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## Product Specification

Item No.: Lowry TV Stand

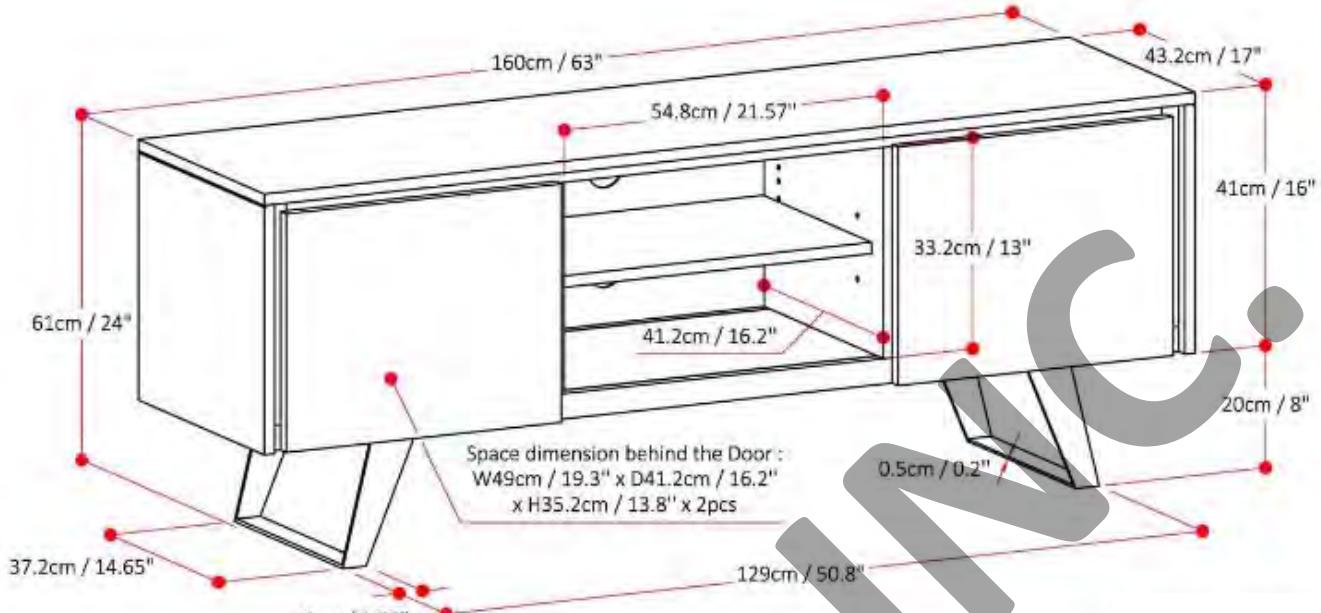
Product size: W-63" x D-17" x H-24"

Date: September 28, 2017

Issued by: Ngoc Do

### Products Overview



**I. General dimension of products:****REMARKS:**

Please refer to technical drawings enclosed at the end of this document for more details of dimension.

All dimensions should follow exactly as Axcess's drawings.

## **II. Materials reference:**

### **1. Solid Wood: All parts, except Leg Frame and Back Panel.**

- Species of wood: Acacia.
- Country of Origin: Vietnam.
- Kind of wood: COL.
- Grade: A, B.
- FSC Certificate: None.

### **2. Metal: Leg Frame.**

- 5mm thickness metal plate.
- Powder coated. Black color (as per sample approved)
- Country of Origin: Vietnam.
- Manufacture: Trien Dat Co. Ltd.
- Metal frame must be resistant to corrosion: Withstand 24 hours in 1% salt spray test.

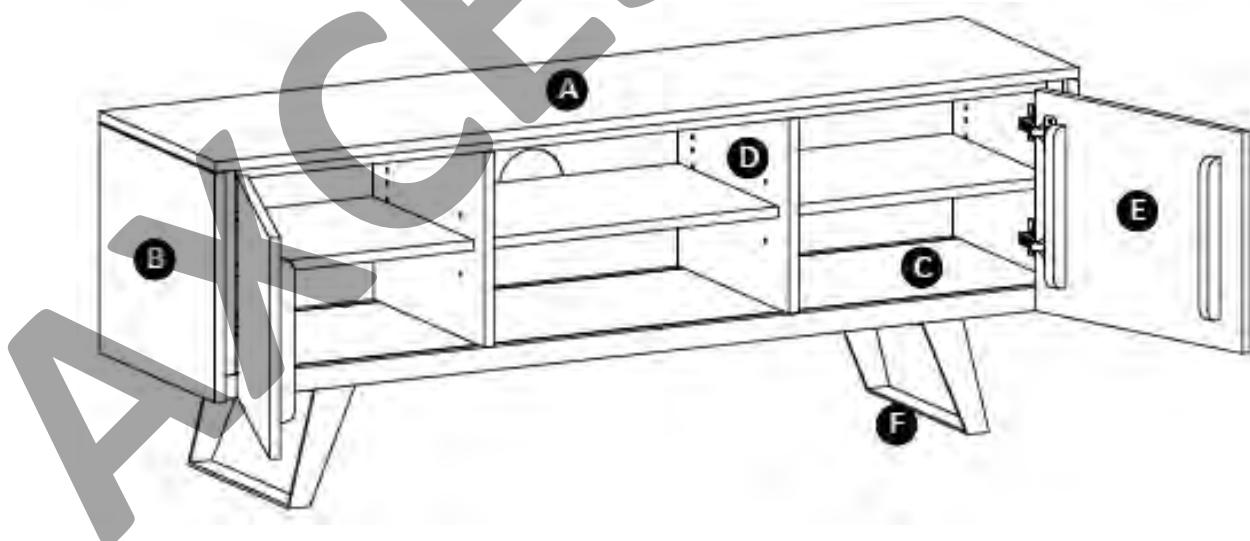
### **3. Plywood: Back Panel.**

- 3mm thickness plywood.
- Standard: CARBP2.
- Country of Origin: Vietnam.
- Manufacture: Homer Wood Product (Vietnam) Co. Ltd.

### **4. Glue (using in production process as lamination, joint, ect.)**

- Water proof glue, D4 standard.
- Country of origin: Vietnam
- Manufactured:
  - o Konishi Lemindo Vietnam Co., Ltd.

## **COMPLETED PARTS:**



### **III. Construction/Specifications:**

- Before mass production, product needs to pass all related tests – conform to US Consumer Product Safety Commission - at Approved Labs.
- All wood must be kiln dry before production and maintained at a humidity level between 8-12% during the manufacturing process.
- The variance of moisture between 2 lamellas cannot be over 2%.
- Width of lamination: should be between 40-80mm. The lamination should have the same width on a board.
- All wood must be free from insect or fungal contamination.
- Wood with sign of previous contamination must not be used (woodworm holes, signs of mould ...).
- All products must be free from physical defects such as poor finish, patchy areas, contamination, pin holes or pitting.
- The surface finish must not discolor, come loose, peel, chip or flake during normal handling or use.
- Finished wood must be smooth and evenly finished, free from cracks, splinters, rough edges and uneven coatings. Hair cracking is considered as critical point.
- Dent, chipped mark, nick... are not allowed.
- Dead knots must not be present on finished wood.
- Filler must not be visible on visual surface (always in view by customer) and must be no bigger than 5mm x 5mm on other surfaces.
- All load bearing pieces must be free of knots.
- There must not be knots at joints.
- Live knots must be less than 2cm and not exceed 1/3 width of lamella. And only 3 live knots are allowed on each surface, spacing between live knots need to be minimum 10 centimeters.
- Sap wood: can not be visible. It's allowed for max length 10cm + width 1cm on hidden surface.
- Discolor / Black grain: must not acceptable in visible surface.

#### **REQUIREMENTS FOR METAL PARTS / FRAME:**

- Metal must be zinc galvanized (in case of powder coating cover completely the surface inside and outside, metal without zinc galvanized can be accepted).
- Do not accept sharp point or sharp edge.
- Surface of metal must be flat and smooth.
- Dimension of parts / frames must follow technical drawings.
- Weld must be clean and smooth, have no cracks or holes.
- Metal parts / frames must be resistant to corrosion: Withstand 24 hours in 1% salt spray test.

## IV. Finish / Color:

### A. Wood parts:

#### 1. Stain:

- Country of origin: Vietnam
- Lead content: not exceed 90ppm (0.009% by weight).
- Manufactured:
  - o VINA PAINT CO.

#### 2. Color: Distressed Charcoal Brown (AX-215-DCB).

- 6 Steps (with glazed): Prestain / Sealer / Glaze / Sealer / Stain / Top coat
- Color swatch should be approved by Axcess before production starts.
- Any treatment use on wood (stain, preservatives, varnishes) must not release color or other staining during use.

### B. Metal parts:

#### 1. Coating:

- Powder coating required.
- Country of origin: Vietnam
- Lead content: not exceed 90ppm (0.009% by weight).
- Manufactured:

#### 2. Color: Black (follow approved swatches)

### REQUIREMENTS FOR FINISHING OF PRODUCTS:

- Lacquer should be tested at Approved Labs for Total Lead Content according to CPSC before mass production.
- All surfaces have to be sanded properly with appropriated sanding papers (No. 120 – 150 – 180 – 220 – 320 – due to each stage of process) before painting applied.
- All parts must be stained properly on all surfaces and all edges including the surfaces that might end up hidden.
- The bottom of the legs and the bottom edge of side panels should be painted or sealed with lacquer.
- All pre-fixed structures have to be pre-stained correctly prior to assembling. This will avoid exposed unfinished lines once these parts shrunk.
- Pre-stains should be applied with darker color than color of products.
- Especially on edges of furniture: all edges should be WELL finished: on the exposed edges of the drawers, edges of top panels, tops of frame, side of frame, inside the cabinet.
- The NC coating should be evenly spread on the surface of the wood, and due to there are different absorption rates on the wood surface, factory has to apply more coating to the edges, in order to make these edges appear to have better finish.
- Finishing steps and lacquer used should follow the steps mentioned on the color swatch signed by Axcess. Any change needs to be approved prior to applying.
- Color must be consistent from product to product, from order to order.

## **V. Hardware:**

- All coatings on metal parts and hardware must comply to CPSIA regulation:
  - US Code of Federal Regulations Title 16 CFR 1303 for total Lead content in surface coating.
  - US Consumer Product Safety Improvement Act 2008 Title I Section 101 for total Lead content in surface coating.
- Country of origin: Vietnam.
- Manufactured by:
  - Lidovit Co. Ltd,
  - Trien Dat Co. Ltd.,
- All hardware must be resistant to corrosion: Withstand 24 hours in 1% salt spray test.
- Hinge: Adjustable hinge.



- Door catcher:



## VI. Packaging:

Packaging must pass ISTA 3A testing by Approved Labs.

### A. Hardware package:

- Each type of hardware should be packed separately in a zip-bag, with a label that shows the hardware number – similar to the assigned number which is printed on the Assembly Instructions.



- Hardware bags must be clear of all wood parts and must be completely covered by microfoam sheet, then wrapped by 2 ply cardboard sheet. Hardware bags must be placed firmly in a room to avoid damage or scratch the wood parts.



### B. Carton box:

- It's required to use "Full Telescope Design Style Tray" carton style only.
- Carton: Double-wall (5 Ply) Corrugated, 6.5mm thickness; Burst strength: Minimum of 275lb/in<sup>2</sup>.
- All EPS foam used at corners and at all sides will be at least with density D.12.
- All EPS foam used for dunnage should be at least with density D.12.

**C. Packaging instruction:**

- Product should be dried completely before packaging.
- Product should be cleaned completely before packaging. Any dust, stains... are not allowed on any surface.
- All parts wrapped by foam sheet. Foam sheets must cover all surfaces to avoid damage of parts during transit.
- All parts should be tightly bundled in order to make sure they can not be moved during transit.
- EPS foam thickness 20mm should be used on all sides to protect products inside.
- All parts wrapped by foam sheet. Foam sheets must cover all surfaces to avoid damage of parts during transit.



Using "L" Pads at all edges of carton



EPS foam at all corners and 6 faces of carton

**Reinforce tape (full length of 2 short edges)****1 line of scotch tape cover full 4 edges.**

Closing carton box

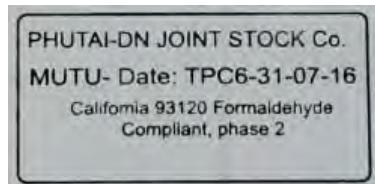
- Reinforcing tape 70mm width must secure the 2 short open edges of box. Apply scotch tape 80mm width along the open edge of carton (cover the reinforce tape). Do not apply the scotch tape across the open edge.
- High quality reinforcing tape and scotch tape must be used.
  - o Brand name: CHOICE PROTECH.
  - o Country of origin: Vietnam
- The tape should not come loose, and not cover the barcode number.



- Packaging must follow packaging process which was approved by Axcess Technical and Quality Assurance Department.
- Notes :
  - Carton layout must be approved by Axcess Inc. before mass printing.
  - Marking should be in correct colors (red or black) as per instruction.
  - The red strings – used to identify the hardware inside the box – must be attached to hardware bag at one end, and the other end must be attached outside carton.
  - Axcess will not accept carton boxes with damages: torn, scratches... or with footprints on boxes.

## VII. Sticker / Labels:

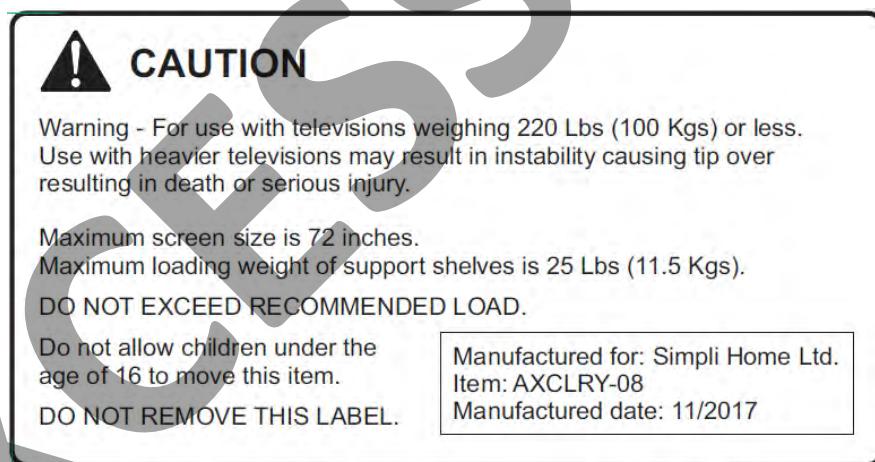
- Shipping marks: must be complied with Axcess's requirement. Must be approved by Axcess before mass printing.
- Sticker/Label:
  - o CARBP2 Label:



- o Chemical Label:



- o TV Warning Label:



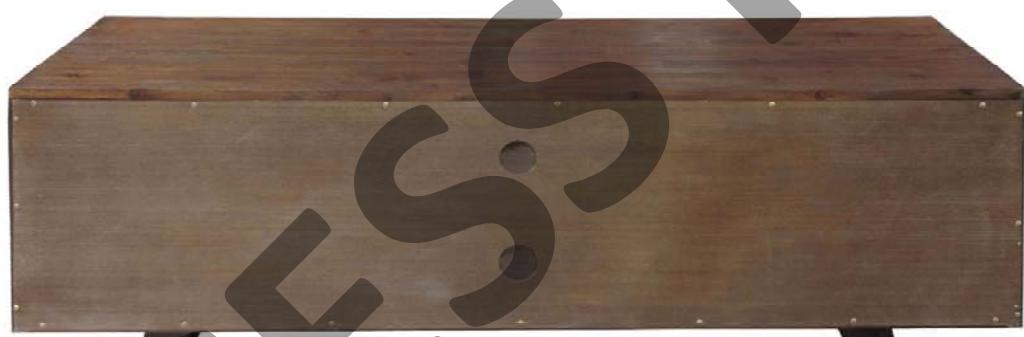
## VIII. Assembly Instruction:

Please see Assembly instruction sheet enclosed at the end of this document.

**IX. Product pictures and detail structure:**



SIDE VIEW



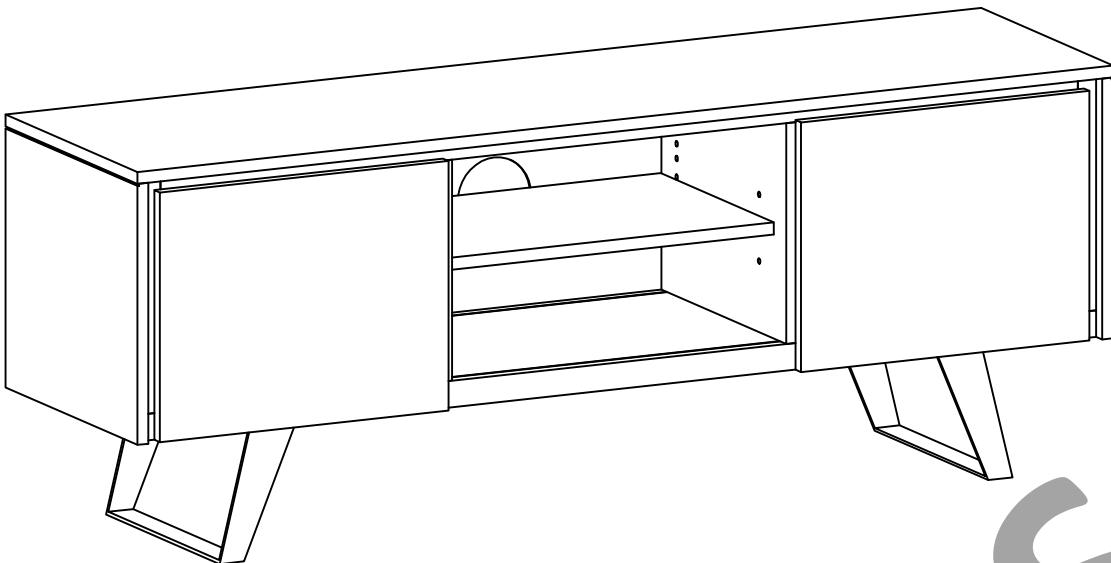
BACK VIEW



BOTTOM VIEW

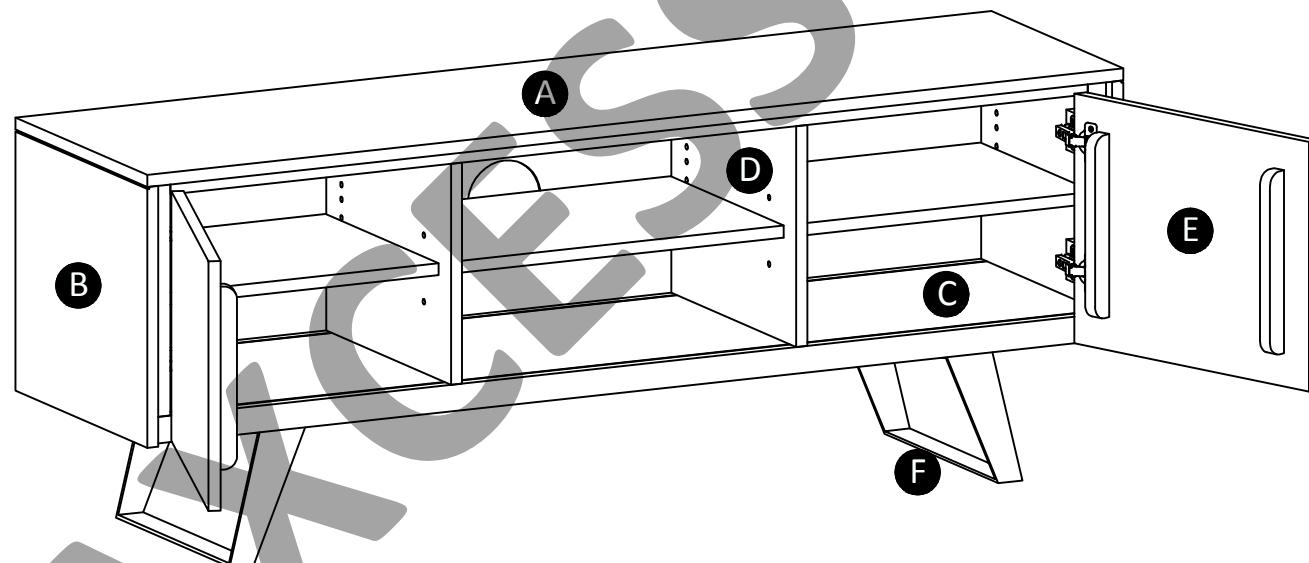


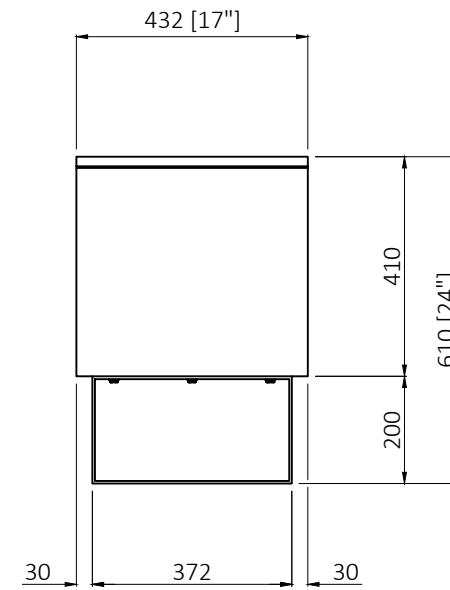
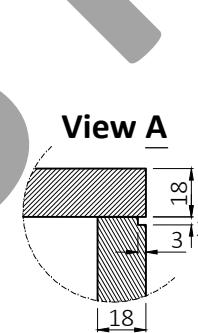
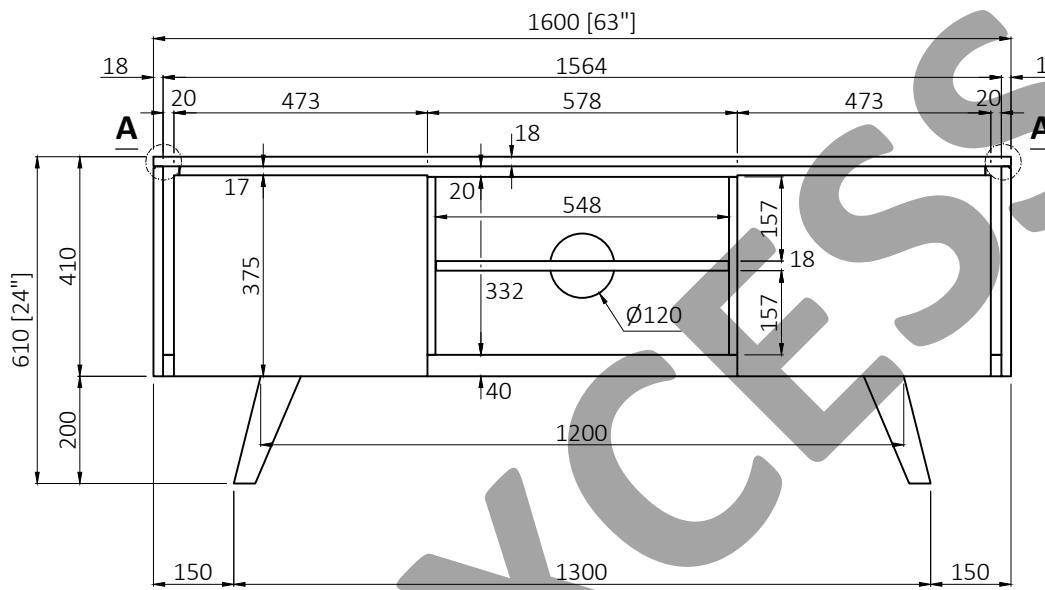
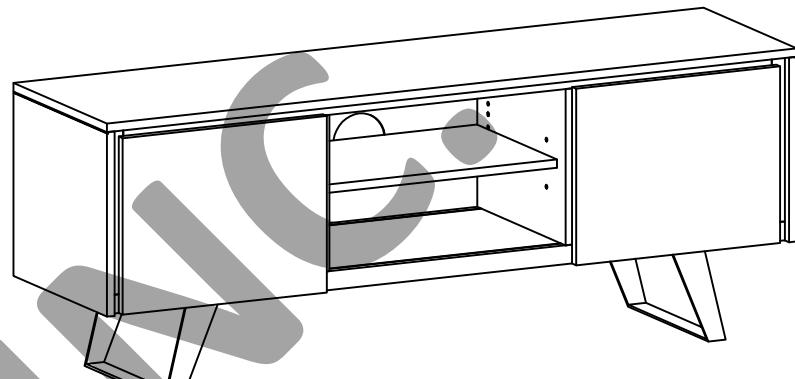
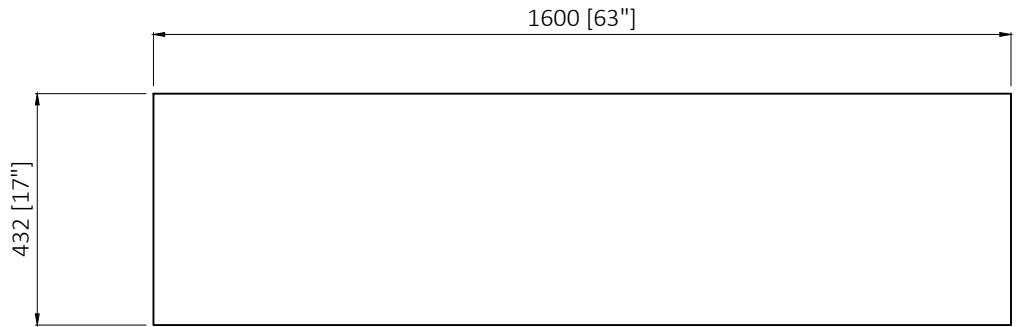
TECHNICAL DETAIL

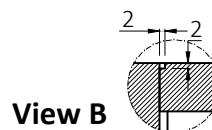
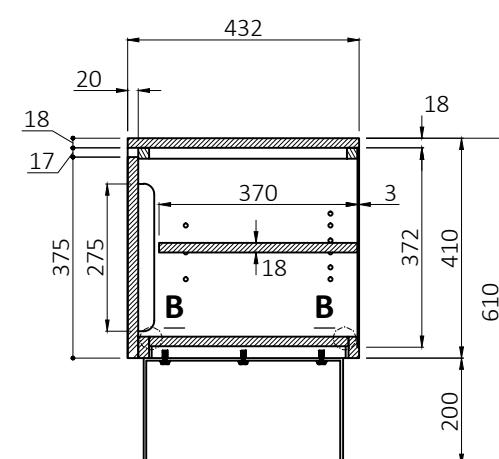
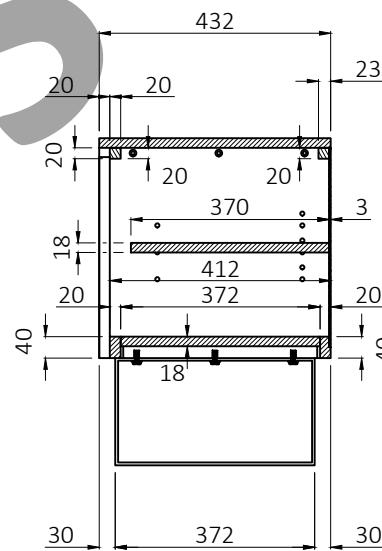
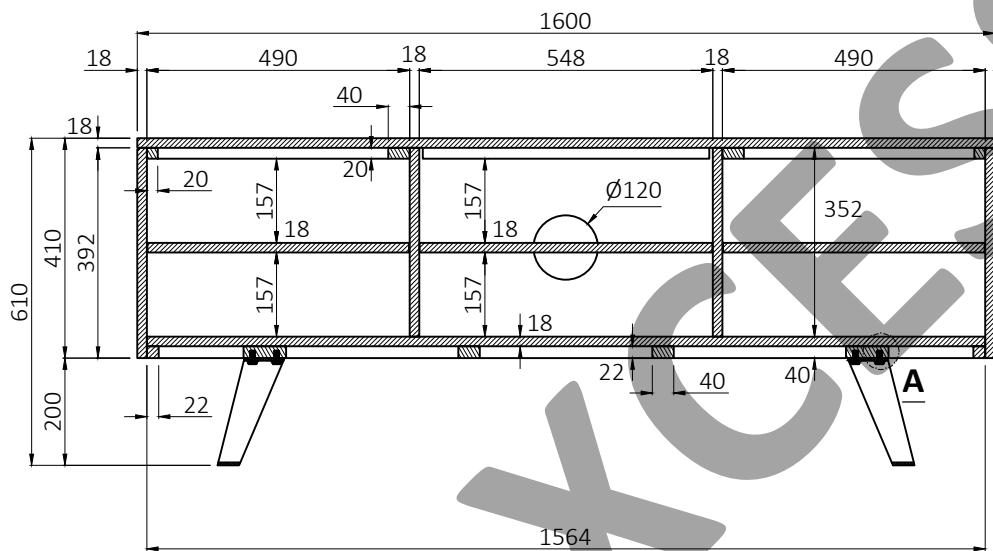
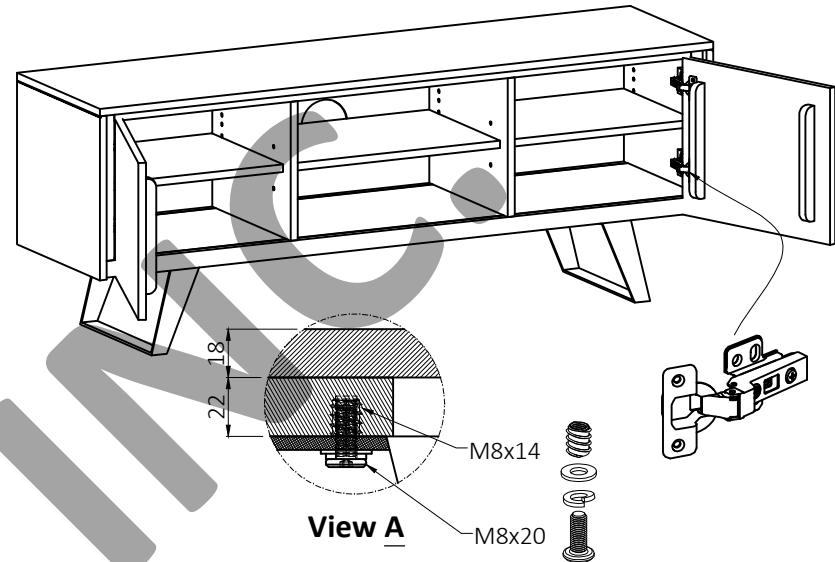
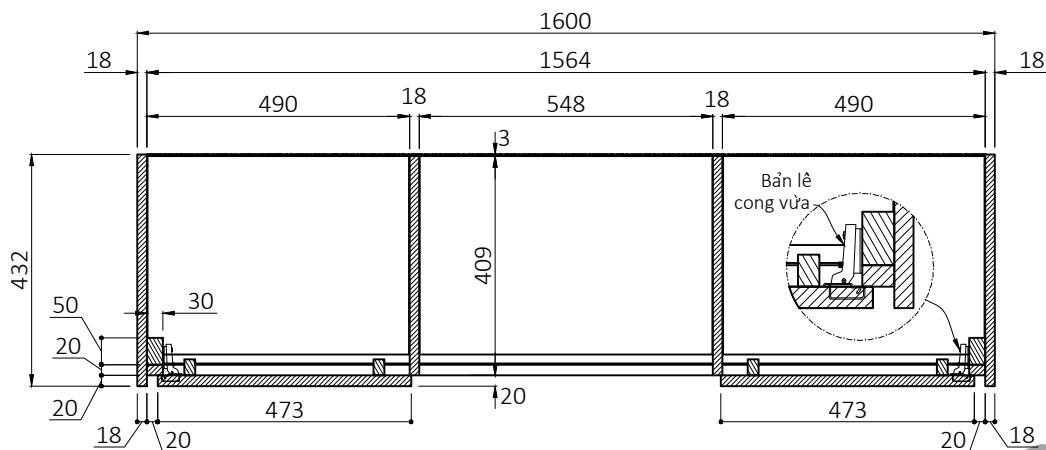


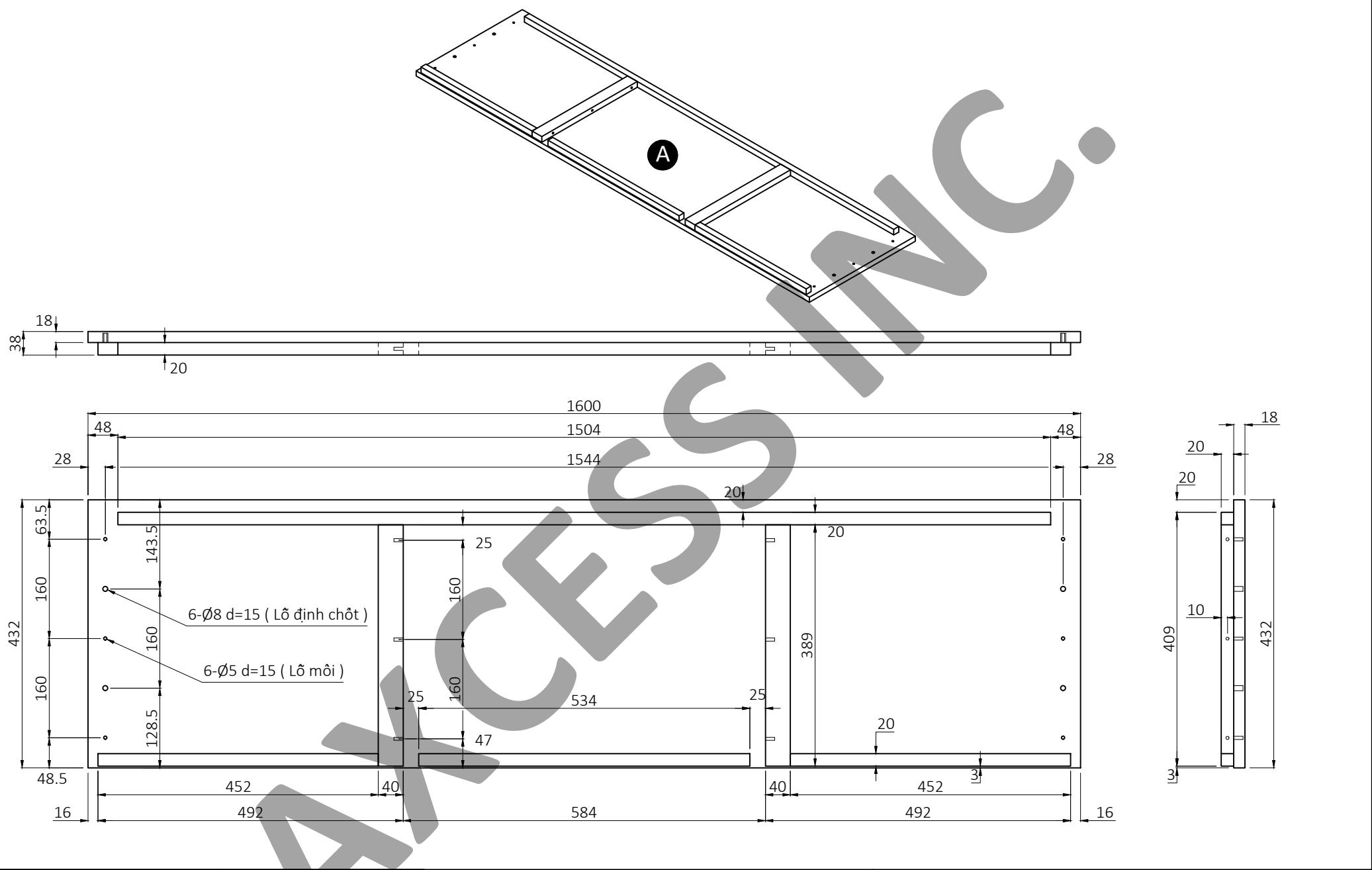
#### SPECIFICATIONS:

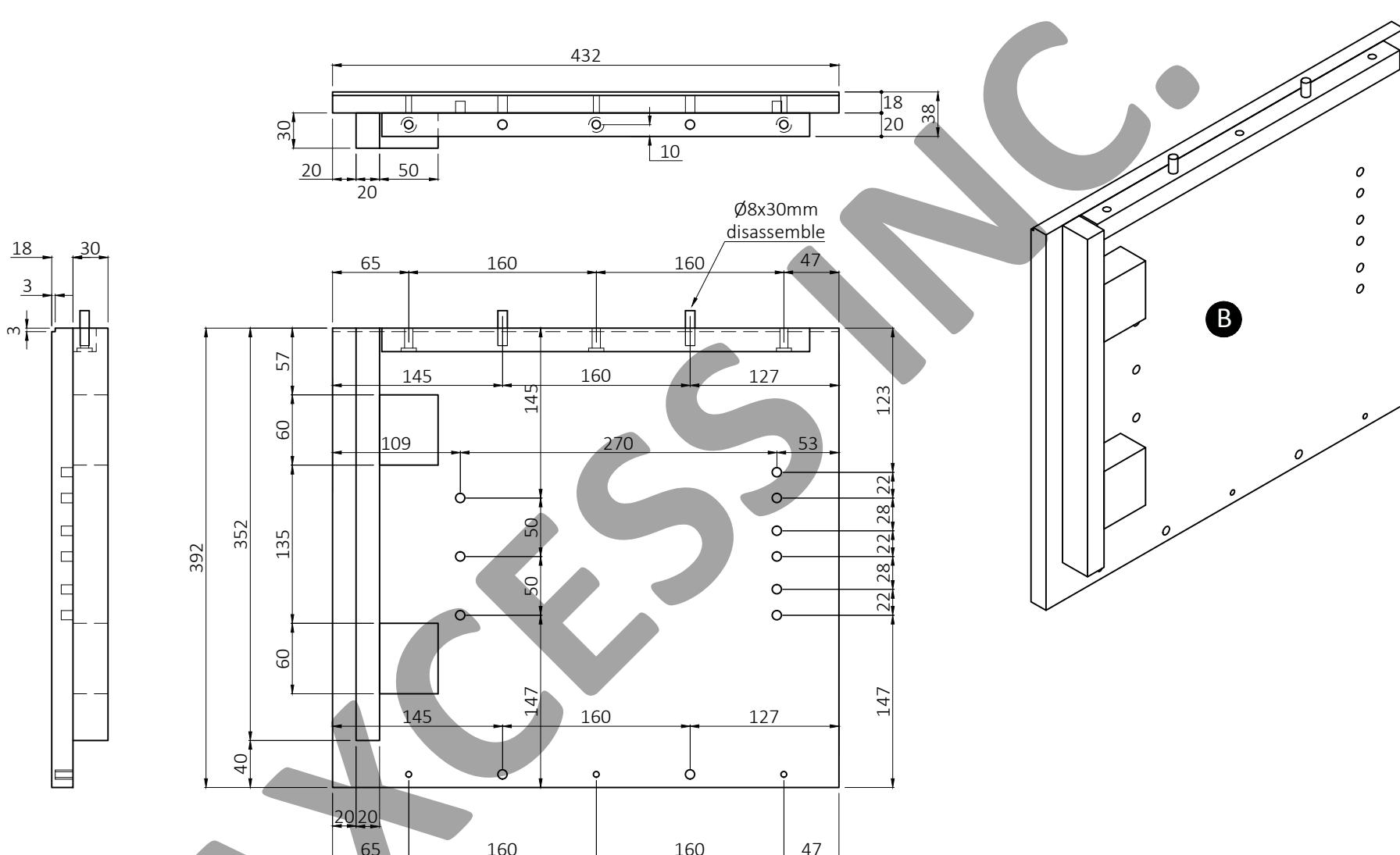
- Color: Distressed Charcoal Brown ( Doors only are wire brushed ).
- Material: Solid Acacia.
- Back panel TV Stand: Plywood 3mm.
- Door with Adjustable hinges and Push style doors.
- Leg : Iron ( Powder coating black color ).
- No visible hardware.











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Drawn by	Check by	Approved by	Item code <b>XXXXXX-XX</b>	Version <b>00</b>	Format: A4 Unit: mm	Scale 1:5
			Product: <b>NEW ACACIA TV STAND</b> <b>63" x 17" x H24"</b>			Sheet 5/8
Vo Ngoc Pho	Tran Dinh Qua	Yoram Weinreich	Detail: <b>SIDES (Left &amp; Right)</b>			Ref. <b>B</b>

