

**Model Numbers:**

**5623 & 5623WA Chair**  
**5633 & 5633WA Loveseat**  
**5643 & 5643WA Sofa**  
**5613T-WA & 5613T-WA Tablet Arm Chair**

**Frame Construction**

Constructed of 5/4" lumber kiln dried to a moisture content of 6-8% and laminated hardwood plywood 3/4" in thickness. All main frame joints are double doweled and glued. Stress points are further reinforced with the use of glued and screwed corner blocks.

**Upholstery/Foam Construction**

**Seat:** The seat platform is constructed with Universal 7 1/2" ga. x 19 1/2" sinuous wire springs, firmly attached to front and back rails. Springs are installed on 5" c/c. A unitized spring surface is attained by attaching two (2) 16 ga. insulated steel tie wires (#F16SW) to each spring with Hartco clips running the entire length of the seat. A Flex-O-Lator unit is then laid over the springs. The surface is covered with a layer of Propex (woven polypropylene matting) then covered with five (5) inches of ultracell premium polyurethane foam.

**Back:** The back is similarly sprung with Universal 7 1/2" ga. x 15 1/2" sinuous wire springs, firmly attached to the top and bottom rails. The unitized spring surface is repeated. A 2 1/2" layer of ultracell premium polyurethane foam with compression of 20 pounds that is covered with a layer of polyester fiber.

**Arms:** Sides are covered with furniture grade paperboard. Tops of the arms receive a contoured H. D. bonded foam insert for softness. A final layer of 1/2" foam is covered over top and sides of arms.

**Final Assembly**

The bottom surface of the seat is covered with a sheet of Cambric for dust protection. The bottom of the arm is fitted with nail-in plastic glides to help protect any flooring surface. The product is then carefully packed with padding and shrink wrapped to minimize movement in shipping.

**Wood Finish**

Exposed wood is machine sanded with 180 grit paper, followed by 220 grit paper for a smooth surface. A spray stain is then applied for an overall even color. Once the stain is applied, the wood parts are run through a burn-off oven and the wood finish is baked on for one hour at a temperature of 140 to 150 degrees Fahrenheit. The wood is then sealed to prevent moisture imbalance. The entire frame is then sanded by hand with 400 grit paper for fine detailing. The final step is the application of a conversion varnish topcoat which is also run through the burn-off oven process.

