

## Quality Assurance Evaluation

**Customer:** GO

**Item #:** WEXLOC

**Description:** Executive Leather Office Chair

**O.A Product Size:** 31" x 26 ½" x 43 ¼"H (lowest position)

31" x 26 ¼" x 46 ½" H (highest position)

**Vendor:** Bo Tai

**Date:** 09/03/09



# Requirements:

<b>Materials:</b>	<b>Foam for back cushion</b>	<b>24kgs</b>
	<b>Foam for seat cushion</b>	<b>28kgs</b>
	<b>Foam for armrest</b>	<b>35kgs</b>

## Constructions:

1. Need to pass (MTL) all relative tests (back, arm, leg & drop test), Bifma standard;  
需要通过所有相关测试(靠背, 扶手, 椅腿及椅座冲击测试), Bifma标准;
2. All foam must be fire retardant and comply CA 117; 所有泡棉须防火;
3. Need to have law label & "Front" label underneath the seat, and should be sewn; Must use factory registration number and must be registered in USA 16 states;  
需要防火标, 警告标及向前标并缝在座垫下面; 必须用工厂的注册号, 并在16个州注册
4. Need to minimize the wrinkle on cushions; 要尽量减少垫子上的皱折;
5. 275lbs box, K=K paper, brown box with shipping mark, use 3" wide packing tape to seal box;  
275磅纸箱, K=K纸质, 用3"宽包装胶带封箱
6. All hardware must be anti-rust and blister pack, must be environmental and comply CPSIA;  
所用五金须防锈且吸塑包装; 必须环保, 符合CPSIA
7. All bolts need Teflon; 所用螺杆须耐落;
8. This chair must not be wobbling at any time of use . 椅子不能有晃动.
9. Need to use a better grade plywood in Productions. 大货需用质量好点的夹板;
10. Caster must be a sports wheel; 用sports轮子;

### Parts 配件

Sports Caster 脚轮(型号: YT-C-G)

Star Base 五爪底座(DF919)

Gas Lift (Lant-80-10)气压棒

Arm 扶手(DF-03)

Butterfly Mechanism 机械装置(T878)

### Supplier 供应商

Yong Tai (YT) 永泰

Da Feng 大丰

Lant 莱特

Da Feng 大丰

Zhong Tai 中泰

12. All coating on wood parts, metal parts and hardware, ink on A/I and stickers, plastic parts must comply with CPSIA regulation (lead content & heavy metal), and plastic parts must pass fire retardant test & Cadmium content of plastic parts must be less than 100ppm.

所有铁配件及五金上的涂层, 说明书和标签上的油墨, 塑料配件须符合CPSIA的要求, 塑料配件需通过防火测试, 含隔量必须少于100ppm.

13. Need birch veneer w/ cathedral grain on the plywood for arm & star base; 扶手和底座夹板需桦木薄片山纹

14. VS, CB, HM, CO, Cappuccino color for wood parts. 木扶手有五个颜色VS, CB, HM, CO, Cappuccino

15. Need to confirm PVC & pig top before mass production. 大货前要确认PVC和猪头.

## Hardware:

All hardware must be anti rust & Vacuum pack  
and must have a piece extra (see Assembly Instruction)

## Packaging:

Box constructions	Regular box
Board	275lbs K=K paper
Packaging	Regular GO Packaging
Shipping Marks	Must follow GO requirements
Color label	NO
Hang Tag	NO
Name Plate	NO
Hardware Tag	Must be 26" long and 2 ½" wide, must have three language (English, French and Spanish)
A/I tag	Must be 26" long and 2 ½" wide, must have three language (English, French and Spanish)

Note: The tag for hardware & A/I must be clear plastic w/ black printing and must comply w/ CONEG.

**For more details please the Confirmed drop test, See reports from QE team**

## Stickers/ Warning:

Made in China In three languages( English, French, Spanish)

Stickers ABC's

**All stickers must have a clear background**

## Assembly Instructions

Need to be confirmed by QE team before printing Mass production

Need to be printed in A3 paper

Need to have envelop per Whalen requirements with three languages (English, French and Spanish)



The base must follow the original sample. Since the base of new sample cannot pass BIFMA test.

底盘要按原样,因为新样通不过BIFMA测试

The caster must follow the original sample.

轮子要按原样

The base must pass 2500 lbs static test (BIFMA test)

底盘必须要通过2500lbs测试



Tried to do BIFMA test on the new base, but it failed at 595.54 KG. 新底盘测试没有通过BIFMA

New base which cannot pass BIFMA test, must follow original sample.

新底盘没有通过BIFMA, 要按原样





The sheen of PVC must match pig top.

PVC亮度要和猪头一样



Original arm

原样扶手

New arm

新扶手



The arm is 60 x 30 mm plywood w/ birch veneer on surface.

扶手是60 x 30 mm夹板，表面贴桦木薄片

The hole for arm pad is top side and Dia. 15 mm bottom side.

扶手垫的孔上面是Dia. 8 mm 下面是Dia. 15mm

8 mm sleeve.



The hole is Dia. 15 mm counter sink.

Dia.15mm沙拉孔

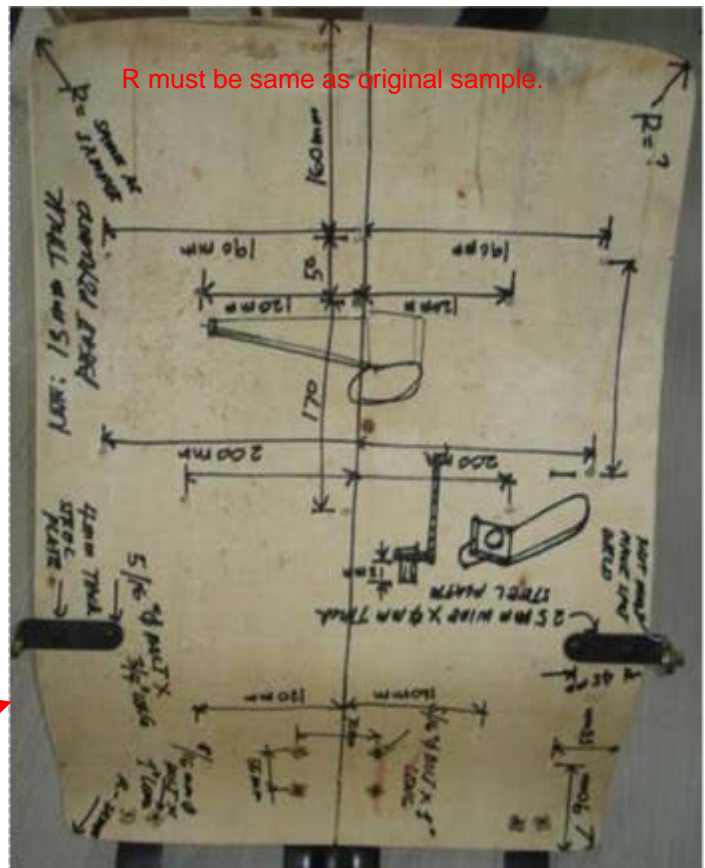


Not acceptable 不接受



Ply wood for arm pad is 8 mm thick, 55 mm wide bent plywood.

扶手垫的夹板是8mm厚，55mm宽曲木夹板



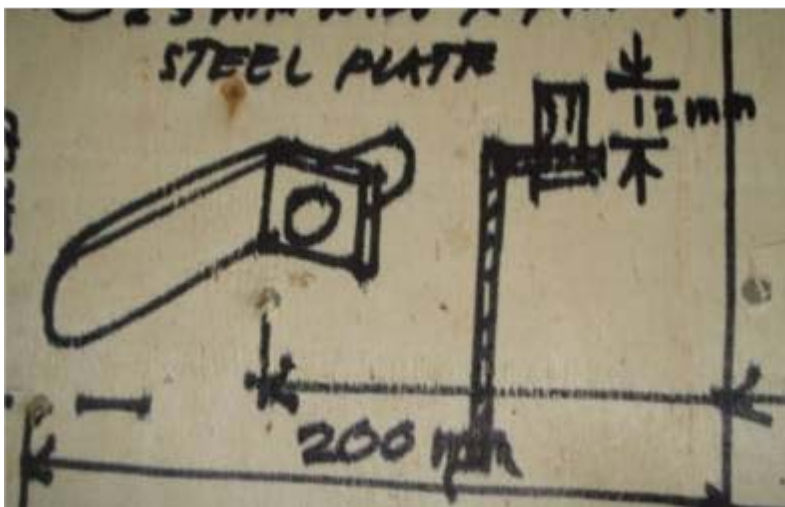
Back rest is 13 mm thick bent plywood.

靠背板是13mm



25 mm wide, 4 mm thick steel plate. The bolt is Dia. 5/16", 3/4" long.

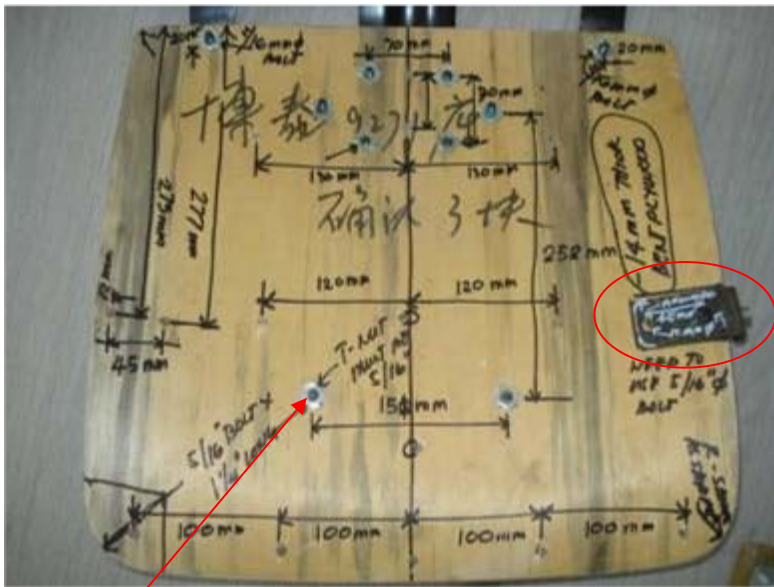
25mm宽，4mm厚铁片.螺杆尺寸是Dia. 5/16", 3/4" .





5 mm thick metal plate w/ Dia. 10 x 19 mm oval hole.  
5mm厚铁片带Dia. 10 x 19 mm椭圆型孔

8 mm thick steel plate. Bolt must be Dia. 5/16", 2" long.  
8mm厚铁片.螺杆必须是Dia. 5/16", 2" .



The metal plate must be rounded.铁片角落要倒圆  
Hole is Dia. 10 mm. 孔Dia. 10 mm.

Seat panel is 14 mm thick plywood.座板是14mm夹板  
T-nut must be Dia. 5/16", bolt must be Dia. 5/16", 1 1/4" long.  
铁板牙必须是Dia. 5/16", 螺杆必须是5/16", 1 1/4"









Need to add more foam.需加泡棉

Pig top w/ coating, must be same as sample signed by Gus. 猪头必须和Gus签字确认的一样

Need to minimize the wrinkle in production.大货中要减少褶皱

Stitching is 6-7 pcs per inch.缝线6针7孔/寸.



Need piping all around the arm. Same as the original sample.

要和原样相同，扶手周围加滚条

Need wood plug.需木塞



Gas lift must be Lant.气压棒

# Update on Sep. 10更新



Need to use the new castor, Supplier is Yong Tai, Model number is YT-C-G. Material is Nylon.

要用新找的轮子，供应商永泰，型号YT-C-G，尼龙材质



Need to use the better plastic cap.

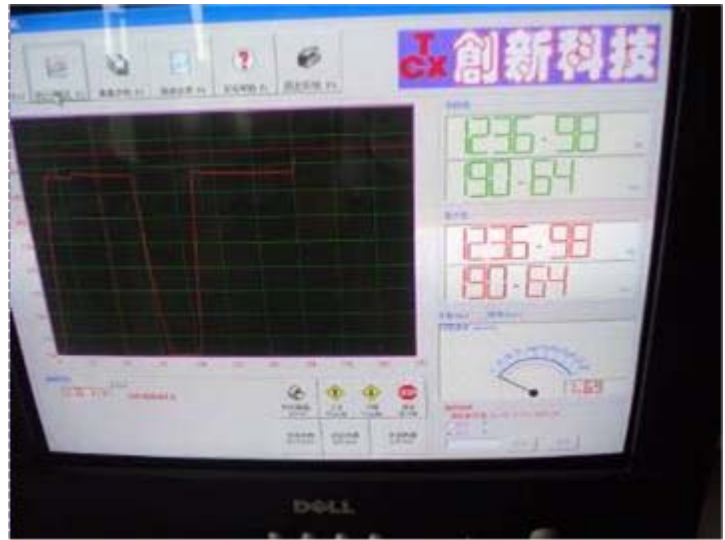
大货要用新找的好的塑胶盖



The metal tube is 20 x 20 x 2.5mm  
The metal plate is 50x20x2.0mm.



Need to have 30\*15\*8mm welding at the joint.  
焊点30\*15\*8mm



1. A force of 2500BLS shall be applied 1 minute and remove the force
2. A force of 3500BLS shall be applied 1 minute and remove the force, again.
3. It was passed.

BIFMA测试通过



Birch veneer w/ cathedral grain. 桦木薄片带山纹

Note: Ply wood lamination must no crack. 夹板不能有开裂