



MINIMUM CONSTRUCTION STANDARDS PRIVATE & EXCLUSIVE BRANDS FURNITURE

All Private and Exclusive brands must follow Minimum requirements unless otherwise specified in the Tech Pack



MINIMUM CONSTRUCTION STANDARDS

PRIVATE & EXCLUSIVE BRANDS FURNITURE

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** IN ADDITION TO ALL REQUIREMENTS IN THIS DOCUMENT, ALL PRODUCT SPECIFIC TESTING PROTOCOLS MUST BE FOLLOWED. TESTING PROTOCOLS CAN BE FOUND ON K-LINK AT : <https://link.kohls.com/resources/subcategory/hardlines> **

Revised Date: 11/20/2024



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SECTION 1: BASIC MATERIAL REQUIREMENTS

All individual components must meet the following requirements and perform together in assembled form.

WOOD AND MANUFACTURED WOOD PRODUCTS:

Moisture Content - Correctly kiln dry raw material to a moisture content of 6-10% to prevent cellular collapse.

Wood Species – Use specified wood throughout entire production/life of program. No unauthorized substitutions. This will be documented in the BOM.

Wood Quality – Use standard grade wood with sufficient strength for appropriate end use; use heart wood vs. sap wood.

Lumber Selection – Only first quality material may be used. Refer to Section 6 for additional information on lumber quality and defects.

Wood Products (MDF,Plywood,Particle Board,Veneer) - Use Industry standard thicknesses, grades and practices

Edge Banding – Apply on MDF, Plywood and Particle Board, unless fully wrapped with veneer.

Grain - Cut in correct grain direction and keep grain alignment consistent within one unit and within a set

Joinery – Use appropriate joining methods - mortise and tenon, dowels with glue, glued and screwed, tongue and groove, butt joint, finger joint, etc. – to achieve the strongest possible connection.

Framing – Frame construction for sufficient strength, especially floors/bottoms of benches, rectangular ottomans, shelves, etc.

Sanding – Sand all surfaces smoothly, even surfaces that don't show.

Stain/Finish – Use water resistant/repellent to prevent spots/stains/damage from liquids. (ie. oil,PU,wax,etc)



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SECTION 1: BASIC MATERIAL REQUIREMENTS CONT.

METALS:

Metal Selection – Use high quality material – content, gauge, etc. – appropriate for the end use by product type

Welds – Must be complete, smooth and even. Spot welds must be placed at back/inside.

Hardware – Use high quality material with sufficient hardness to prevent stripping of heads or threads.

Hardware Selection – Use corrosion proof hardware (stainless steel, galvanized brass, zinc etc.) for furniture used in wet/humid areas (outdoors, bathroom, kitchen, etc.). Cap all nuts and bolts to keep moisture out and prevent rusting (Excluding children's products).

CERAMICS:

Shape - Check shape before drying/heating to ensure product matches specified shape and dimensions.

GLASS:

Glass – Must be tempered for strength and safety.

Glass – All exposed edges must be polished unless otherwise specified.

SYNTHETIC MATERIALS:

Textiline Fiber – Must be high quality with excellent UV resistance.



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SECTION 2: LABELS AND PACKAGING

Labels and Stickers	Labels other than as specified or required by Customs, Federal Trade Commission, USDA, EPA and country specific legal requirements (COC).	Not Acceptable
	Does not comply with all advertised and labeled claims.	Not Acceptable
	Label demarking product's surface finish. (To prevent this defect – place component part identification stickers at an inconspicuous location on the unit – back, bottom, inside, etc.)	Not Acceptable
	Label Placement <ul style="list-style-type: none"> Follow instructions as specified in tech pack For a complete list of label placements, reference the below guides available on K-link: <ul style="list-style-type: none"> Resources > Private and Exclusive Brands > Global Technical Design > Home > Label Placement Guides subheading 	
	** For full details regarding labeling, please refer to the Kohl's Labeling Guidelines for Home Textiles , on K-link: <i>Resources > Private and Exclusive Brands > Performance Testing > Soft Home - Home Textiles > "Labeling Guidelines" under Regulatory Compliance & Safety subheading</i>	
Assembly Materials	Missing, incorrect or misspelled mounting, assembly or use instructions.	Not Acceptable
Cartons	Product Packaging: Retail packaging of insufficient size, strength or type to support or protect product.	Not Acceptable
	Master Shipping Cartons: Shipping carton and shipping material insufficient size or strength to protect packaged product in transit.	Not Acceptable
	Re-shippers: SUGGEST Meeting Transit Testing protocols specific for product type/size: ASTM D4169, ISTA 1A, 1B, 1C	Not Acceptable



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SECTION 3: FURNITURE TOLERANCES BY PRODUCT AND MEASUREMENT TYPE

LISTED ITEMS ARE MINIMUM CONSTRUCTION STANDARDS
UNLESS OTHERWISE SPECIFIED IN THE PRODUCT SPECIFICATION CONSTRUCTION DETAILS BY TD

Category of Dimension	Seating & Ottoman	Tables	Bookcase	Umbrella Base	Umbrella
Customer Facing Dimensions +1" / -0"	Width x Depth x Height (Each measurement taken at the widest,deepest,highest point)				
	Total Width	Total Width	Total Width	Width	Umbrella Radius
	Total Depth	Total Depth	Total Depth	Depth	Umbrella Total Height
	Total Height	Total Height	Total Height	Height	
Critical Dimensions +1/2" / -1/2"		Total Diameter		Diameter	
	Seating Seat Height	Table Top Thickness	Bookcase Top Thickness	Umbrella Base (Base) Height	Crank Handle Clearance
	Seating Seat Width	Leg Span Width	Leg Span Width	Support Tube Height	Bottom Pole Length
	Seating Seat Depth	Leg Span Depth	Leg Span Depth		Umbrella Canopy Length
	Seating Front/Back Leg Span	Table Clearance	Leg Height		Umbrella Vent Length
	Seating Side Leg Span	Side Table Clearance	Shelf Opening Width		
	Seating Back Height	Leg Height	Shelf Opening Depth		
	Seating Back Width at Top	Shelf Opening Width	Shelf Opening Height		
	Seating Back Width at Bottom	Shelf Opening Depth	Shelf Width		
	Seating Total Arm Height	Shelf Opening Height	Shelf Depth		
		Shelf Width	Shelf Thickness		
		Shelf Depth	Floor Clearance Front/Back		
		Shelf Thickness	Floor Clearance Sde		
		Floor Clearance Front/Back			
	Floor Clearance Sde				



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SECTION 3: FURNITURE TOLERANCES BY PRODUCT AND MEASUREMENT TYPE CONT.

LISTED ITEMS ARE MINIMUM CONSTRUCTION STANDARDS
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Category of Dimension	Seating & Ottoman	Tables	Bookcase	Umbrella Base	Umbrella
+1/4" / -1/4"	Seating Front/Back Support Bar				
	Seating Side Support Bar Height				
	Runner Length (Straight)				
	Runner Length (Curved)				
+1/8" / -1/8"	(-0") Bolts / Screws	(-0") Bolts / Screws	(-0") Bolts / Screws	(-0") Bolts / Screws	(-0") Bolts / Screws
	Lock Mechanism Placement	Lock Mechanism Placement	Leg Width	Knob Positioning	Umbrella Holes
	Floor Glide Diameter	Leg Width	Leg Depth	Edge Wrap	Umbrella Hole Placement
	Front/Back Runner Placement	Leg Depth			
	Seating Arm Width				
+1/8" / -1/16"		Apron Width Front/Back	Apron Width Front/Back		
		Apron Width Side/End	Apron Width Side/End		
		Apron Thickness Front/Back	Apron Thickness Front/Back		
		Apron Thickness Side/End	Apron Thickness Side/End		
		Overhang @ Apron Front/Back/Side	Overhang @ Apron Front/Back/Side		
		Overhang @ Leg Front/Back/Side	Overhang @ Leg Front/Back/Side		

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SECTION 4: FURNITURE WEIGHT CLAIM

Seating	
Folding Seating	250+ lbs
Single Seating / Garden Stool	250+ lbs
Double Seating (Width > 32")	500+ lbs
Tables	
Accent/Fashion Tables	30+ lbs
End Tables	50+ lbs
Shelf Load Capacity	20+ lbs depending on construction
Drawer Capacity	10+ lbs depending on construction
Coffee Tables	200+ lbs
Shelf Load Capacity	50+ lbs depending on construction
Drawer Capacity	10+ lbs depending on construction
Console Tables	200+ lbs
Shelf Load Capacity	50 lbs - 60+ lbs depending on construction
Drawer Capacity	10 lbs - 25+ lbs depending on construction
Dining Tables	250+ lbs
Trays	25+ lbs
Ottomans/Benches	
Single Seat Ottomans/Benches	250+ lbs
Double Seat Ottomans/Benches (Width > 32")	400+ lbs
Triple Seat Ottomans/Benches	700+ lbs
Umbrella Bases - Total Product Weight Requirement	
Used with a Table	90 lbs or less
Freestanding	90+ lbs

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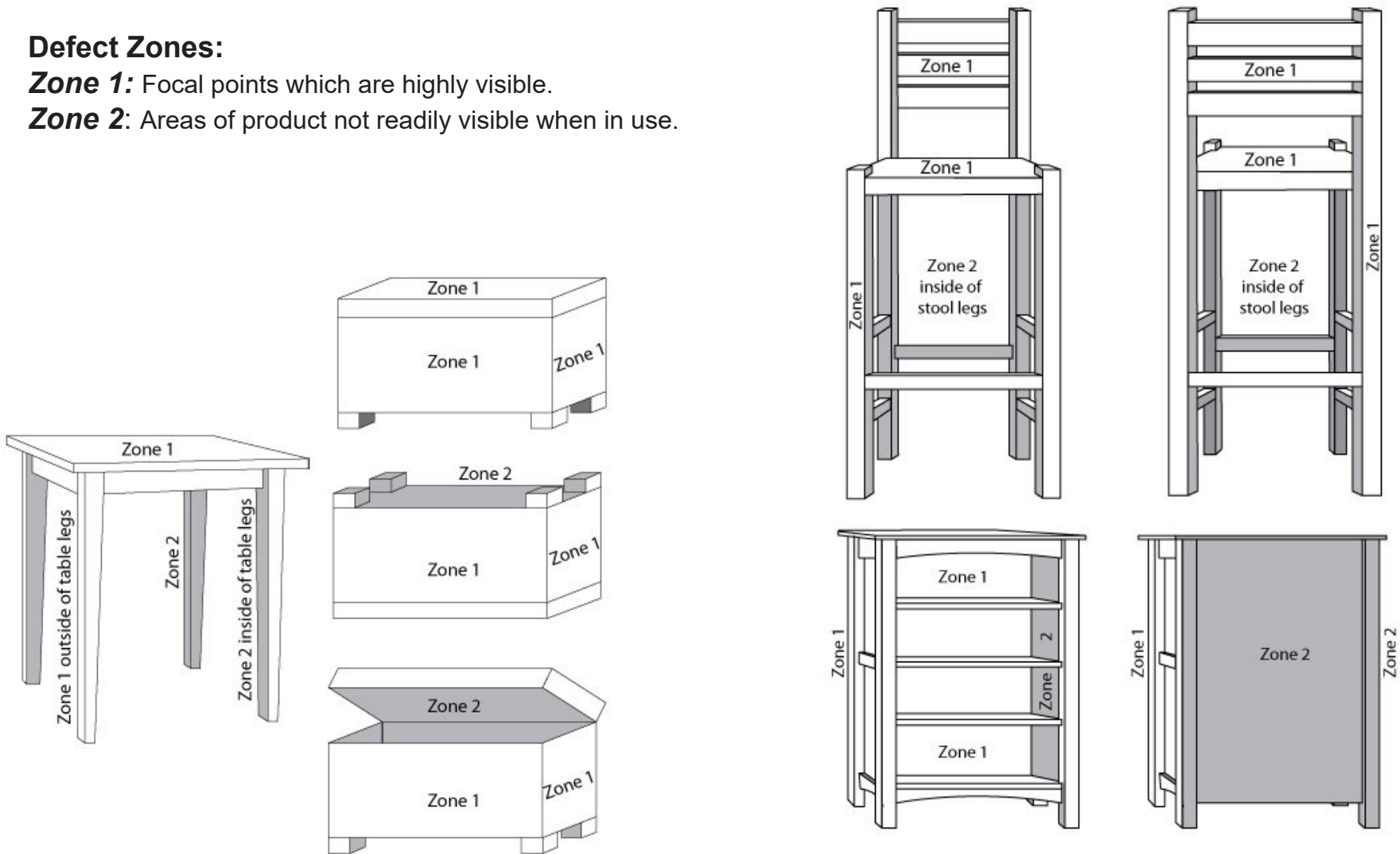
SECTION 5: FURNITURE DEFECT ZONES

Defect Zones: Product mapping identifying areas of product where questionable dirt/soils and material imperfections may or may not exist.

Defect Zones:

Zone 1: Focal points which are highly visible.

Zone 2: Areas of product not readily visible when in use.



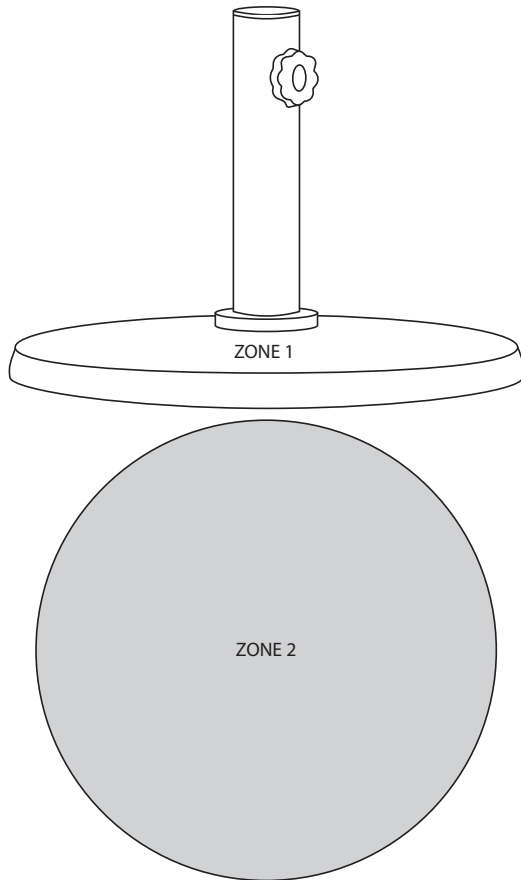
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MINIMUM CONSTRUCTION STANDARDS

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SECTION 6: REFERENCE OF DEFECTS

**** IN ADDITION TO ALL DEFECTS LISTED IN THIS SECTION, SEE THE FOR THE FULL LIST OF HARDLINES DEFECTS ON K-LINK: https://link.kohls.com/media/digital/k-link/downloads/pdf/KOHL'S_DEFECT%20CLASSIFICATION%20LIST_HARDLINES_rev20180308.pdf ****

Defects: Visual and/or performance imperfections that may cause safety concerns, product failure, affect the usability of the product for its intended purpose or be unacceptable to the customer. (Cosmetic variations viewed at arms length in normal room lighting.)		Zone 1	Zone 2		
Color	Wood Color/Stain (Some natural shading will occur in stains on most woods and is acceptable. however, only limited shading is allowed.)	Off - Standard color/stain outside of predetermined acceptable range	Not Acceptable		
		Shading between product components in one unit (not due to grain direction and light reflection)	Not Acceptable		
		Differential sanding causing shading or color variation within a product	Not Acceptable		
		Streaking, drips, ripples or missed areas	Not Acceptable		
		Overspray / air-in-spray causing rough surface or spotting	Not Acceptable	Acceptable	
		Smudges, smears and/or fingerprints in the finish	Not Acceptable		
	Metal Finish/Polish	Missing Finish	Not Acceptable	Acceptable	
		Finish variations between product components within one unit outside of predetermined acceptable range	Not Acceptable		
		Excessive polish remains (cleaning compound)	Not Acceptable	Acceptable	
		Tarnish, corrosion or rust	Not Acceptable		
	Metal Plating	Incorrect/inconsistent thickness	Not Acceptable		
		Peeling or flaking	Not Acceptable		
		Missing plating areas	Not Acceptable		
	Dirt/Soils	All Materials	Any conspicuous dirt, soil or glue spot	Not Acceptable	
			Sticky or tacky surface	Not Acceptable	
Permeating smell or odor			Not Acceptable		
Foreign material, contamination			Not Acceptable		
Mold or fungus			Not Acceptable		
Insects, dead or alive			Not Acceptable		

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SECTION 6: REFERENCE OF DEFECTS CONT.

Defects: cont.		Zone 1	Zone 2	
Materials Wood	General	Incorrect material – not as specified or contracted	Not Acceptable	
		Incorrect moisture content or drying method	Not Acceptable	
		Dimension – not as specified or contracted	Not Acceptable	
	Mineral	Large brown streaks greater than 1 ½" L and/or 1/16" W	Not Acceptable	
		Black marks greater than 3" L and/or 1" W	Not Acceptable	
	Knots (only solid small knots acceptable unless specifically discussed with Technical Designer)	Large knots – maximum size limit established by wood species (ideally ½" diameter)	Not Acceptable	
		Excessive number of knots – maximum number limit on face surfaces established by wood species	Not Acceptable	
		Knots on edges which are not a design feature, outside of predetermined acceptable tolerance	Not Acceptable	Acceptable
		Loose knots	Not Acceptable	
		Holes or cracks left by loose knots	Not Acceptable	
		Knots glued back into board	Not Acceptable	
		Raised or deeply recessed knots	Not Acceptable	
		Knots leaking sap or pitch	Not Acceptable	
		Split or cracking knots	Not Acceptable	
	Splits, Checks, Shake	Lengthwise separations	Not Acceptable	
	Grain	Chipped, torn, raised or loosened grain	Not Acceptable	Acceptable
	Decay, Rot	Soft, pulpy, crumbling wood	Not Acceptable	
	Insect Holes	Holes, voids or small channels in wood created from insects	Not Acceptable	Acceptable
	Wane	Presence of bark or lack of wood along an edge or corner	Not Acceptable	
	Warp, Bow, Crook	Excessive deviation from a flat plane	Not Acceptable	
Pitch Pocket	Internal cavities that contain resinous material, sometimes bark	Not Acceptable		
White Speck	White speck (small white pits or spots)	Not Acceptable	Acceptable	
Honeycombing	Honeycombing (larger, deeper pits)	Not Acceptable		

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SECTION 6: REFERENCE OF DEFECTS CONT.

Defects: cont.		Zone 1	Zone 2	
Materials Natural		Endangered species of plant materials		
		Plant materials restricted by the USDA		
		Plant materials restricted by individual U.S. states		
		Incorrect plant material – immature plant material		
		Excessive fading or color range outside of predetermined acceptable range		
		Excessively dry plant material (causing breakage)		
Materials Metal	Pitting (hole, dimple or air bubble)	Small pits, less than or equal to 1 mm, not clustered		
		Small pits, less than or equal to 1 mm, clustered	Not Acceptable	Acceptable
		Large pits, greater than 1 mm, not clustered	Not Acceptable	Acceptable
		Large pits, greater than 1 mm, clustered	Not Acceptable	
	Heat Stress	Splits in metal rod		Not Acceptable
		Excessive heat stress, randomly	Not Acceptable	Acceptable
		Excessive heat stress, pervasive	Not Acceptable	
Materials Synthetic	Excess Shrinkage	Chips, cracks, splits or stress marks (light colored lines)		
		Highly visible injection point or mold line; distorts surface		
		Rough edges at injection point or mold line; sharp		
Materials Ceramics	(For complete list of ceramics information please see Ceramics Minimum Construction Standards on K-Link)	Inaccurate size, placement, and/or quantity of design elements		
		Does not match specified shape, length, width or height		
		Rim/wall thickness not as specified; not within assigned tolerance		
		Item does not rest flat		
		Color stain/pigments used under glaze, not fully covered by glaze		
		Cracks, chips or broken surfaces		
		Glazed-over cracks, very small (hairline) cracks around handles/ bottom of products.		

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SECTION 6: REFERENCE OF DEFECTS CONT.

Defects: cont.		Zone 1	Zone 2
Construction &/Or Assembly	General	Finished product does not meet Minimum Performance Testing Standards; parts not fully functioning	Not Acceptable
		Finished product dimensions are not as specified or contracted	Not Acceptable
		Missing or incorrect assembly or mounting hardware	Not Acceptable
		Missing, extra or misaligned mounting/assembly holes, hardware or components	Not Acceptable
		QA Checkpoints must be established in production to verify bolt hole / threaded insert placement and ensure proper hole alignment for connecting parts.	Not Acceptable
	Shape Irregularities	Does not match specified shape	Not Acceptable
		Shape irregularities on punched/die stamped metal (not part of design)	Not Acceptable
		Kinks or straight spots greater than 3/8" on scrolled metal	Not Acceptable
		Loose joints, gaps	Not Acceptable
		Bent/crooked legs	Not Acceptable
		Product does not sit level on the floor	Not Acceptable
		Crossbars not parallel	Not Acceptable
		Lid, handle, drawer, door, etc., does not align, fit or function as expected	Not Acceptable
	Weaving (Natural products - rush, wicker, rattan, seagrass, etc. Synthetic products - poly-vinyl chloride wicker, textiline, olefin, etc.)	Gaps or irregularities in weave	Not Acceptable
		Loose ends, raveling	Not Acceptable
		Broken/split ends	Not Acceptable
		Large tied knots or splices	Not Acceptable
		Frame not completely covered by material	Not Acceptable
		Sharp points on metal frame	Not Acceptable
		Puckering, wavy or over stretched areas	Not Acceptable

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SECTION 6: REFERENCE OF DEFECTS CONT.

Defects: cont.		Zone 1	Zone 2	
Construction &/Or Assembly	Welding/Soldering	Misalignment of joint, major deviation	Not Acceptable	
		Misalignment of joint, minor irregularity	Not Acceptable	Acceptable
		Inconsistent welding resulting in too heavy (messy and massive) or too light (not strong enough or open) welds	Not Acceptable	
		Slag or splatter – not sharp	Not Acceptable	Acceptable
		Dimples - spot weld marks, small less than or equal to 1mm	Acceptable	
		Dimples - spot weld marks, large greater than 1mm	Not Acceptable	Acceptable
		Over-buffing large weld area to reduce it causing surface distortion	Not Acceptable	
		Spot weld buffed out to correct slight burns/yellowing from weld	Acceptable	
		Small burn-out of angle iron from welding, not sharp	Acceptable	
		Excessive burnt metal and large burn-out of angle iron from welding (slight amounts are expected)	Not Acceptable	
	Surface Marks	Excessive fading or color range outside of acceptable range	Not Acceptable	
		Excessively dry plant material (causing breakage)	Not Acceptable	
		Small pits, less than or equal to 1 mm, not clustered	Not Acceptable	
		Small pits, less than or equal to 1 mm, clustered	Not Acceptable	
		Large pits, greater than 1 mm, not clustered	Acceptable	
		Large pits, greater than 1 mm, clustered	Not Acceptable	
		Splits in metal rod	Not Acceptable	
		Excessive heat stress, randomly	Not Acceptable	
		Excessive heat stress, pervasive	Not Acceptable	
		Chips, cracks, splits or stress marks (light colored lines)	Not Acceptable	
		Highly visible injection point or mold line; distorts surface	Not Acceptable	
		Rough edges at injection point or mold line; sharp	Not Acceptable	
Finished product does not meet Minimum Performance Testing Standards; parts not fully functioning	Not Acceptable			

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MINIMUM CONSTRUCTION STANDARDS

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SECTION 7: CONSTRUCTION REQUIREMENTS BY PRODUCT TYPE

Furniture Construction Requirements : Organized by product category, these construction requirements are required unless otherwise specified in technical spec.		For photos of components:	
Seating	General	Finished product dimensions are as specified or contracted (see POM of style in Oneplm for specific dimensions and POM tolerances.)	
		All rocking seating (rocking chairs, or seating with rocking runners) must include runner stops to prevent the tipping of rocking chairs when in use	See Page 26
		Gaps in punched metal or slatting do not measure between 7-12mm	See Page 19
		Leg BottomGlides / Floor Glides – as specified by product type and as approved by Technical Design. - Preference: No glides for products with wood legs. Smoothly sanded bottom of wood leg, clean of soils, break the edge slightly to prevent grain tear-out - For other leg types the glides must be high quality material, specific to the end use by product type. No plastic glides with bulging nail/screw heads	See Pages 22-23
	Stacking Specific Requirements	Photos showing stacking ability must be sent to Kohl's TD, if multiple stacking samples are not being sent.	
	Folding Specific Requirements	Gaps between moving limbs must measure <7 mm or >12mm due to finger entrapment hazard.	See Page 19
Must have functional locking mechanism to prevent unintentional collapse/closure.		See Page 20-21	



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SECTION 7: CONSTRUCTION REQUIREMENTS BY PRODUCT TYPE CONT.

Furniture Construction Requirements : Organized by product category, these construction requirements are required unless otherwise specified in technical spec.		For photos of components:	
Tables	General	Dining Tables - Legs must connect directly to table top to ensure proper support.	
		Levelers are required on all outdoor tables unless otherwise specified by Kohl's TD. (This includes garden stools)	See Page 25
		Gaps in punched metal or slatting do not measure between 7-12mm	See Page 19
		Edges - cut metal edges must be smoothed or covered with finish material.	
		Anti-tip kits are required on all console tables 27" H or taller.	See Page 31
	Folding Specific Requirements	Gaps between moving limbs must measure <7 mm or >12mm due to finger entrapment hazard.	See Page 19
Must have functional locking mechanism to prevent unintentional collapse/closure.		See Page 20-21	
Bookshelves and Storage Towers	General	Leg Bottom Glides / Floor Glides – as specified by product type and as approved by Technical Design. - Preference: No glides for products with wood legs. Smoothly sanded bottom of wood leg, clean of soils, break the edge slightly to prevent grain tear-out - For other leg types the glides must be high quality material, specific to the end use by product type. No plastic glides with bulging nail/screw heads	See Page 22-23
		Anti-tip kits are required on all storage units, bookshelves or dressers 27" H or taller.	See Page 31
	With Drawers	- Full wood construction of drawers, drawer face must be separate and attached to full drawer box. - MDF material drawers, cam bolts and camlocks can be used to secure the drawer face and drawer panels.	See Page 30
		Nonwoven drawers must hold a minimum weight of 10 lbs.	
	Wheeled Storage	Items with casters must include at least 2 locking casters per item.	
KD specific requirements	<i>QA Checkpoints must be established in production to verify bolt hole / threaded insert placement and ensure proper hole alignment for connecting parts.</i>		



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SECTION 7: CONSTRUCTION REQUIREMENTS BY PRODUCT TYPE CONT.

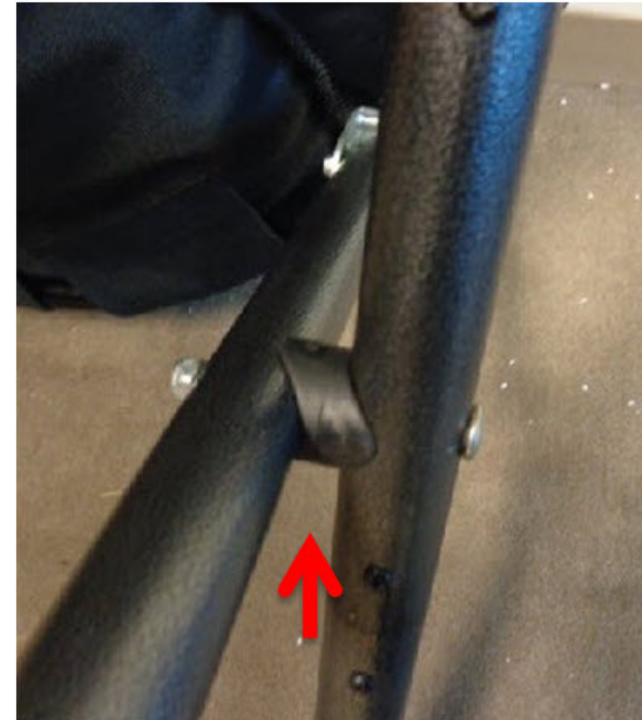
Furniture Construction Requirements : Organized by product category, these construction requirements are required unless otherwise specified in technical spec.			For photos of components:
Ottomans	General	Leg Bottom Glides / Floor Glides – as specified by product type and as approved by Technical Design. - Preference: No glides for products with wood legs. Smoothly sanded bottom of wood leg, clean of soils, break the edge slightly to prevent grain tear-out - For other leg types the glides must be high quality material, specific to the end use by product type. No plastic glides with bulging nail/screw heads	See Page 22-23
	Ottomans w/ Lidded Storage	Air holes – cut/drill/router 1” diameter air holes in the floor of all storage items with lids unless otherwise specified.	See Page 29
		Attached lids must use specified lid lifts.	See Page 27
		Single seater lids must use 2 hinges, and double seater lids must use 3 to ensure lid is not being torqued and construction is quality.	See Page 27
		Items with set on lids must include either lid stoppers or lid shaping must be used to ensure lids will not shift when in use.	See Page 28
Umbrellas	General	Umbrellas with crank handles must be packaged using proper protection to ensure cranks aren't damaged in shipping. Send Kohl's TD photos of final crank packaging for inspection.	
		Cranks on umbrellas must be able to fully rotate when placed in different umbrella tables. (Regular and high dining styles).	
Umbrella Bases	General	Bases must meet required weight minimums.	See Page 8

SECTION 8: CONSTRUCTION REQUIREMENTS

FINGER ENTRAPMENT REQUIREMENTS

- Finger entrapment is a concern for all cut outs, spaces between moving parts, spacing in slats, connection of parts etc.
- Items that do not adhere to this requirement will fail product testing.
- **Spaces must be less than 7mm or greater than 12mm wide.**

Cut out measured 7.66 mm in diameter.
Cut out must be resized for approval.



Gap must measure <7mm or >12mm.

SECTION 8: CONSTRUCTION REQUIREMENTS CONT.

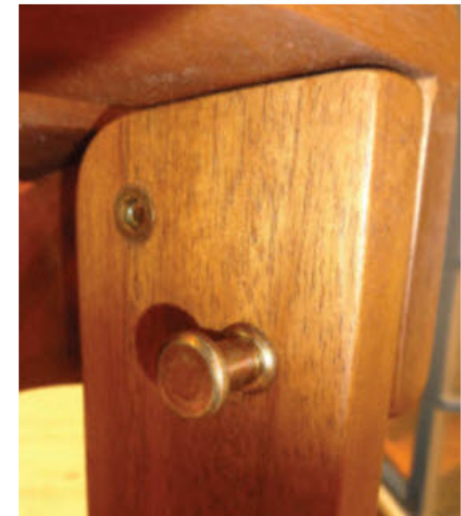
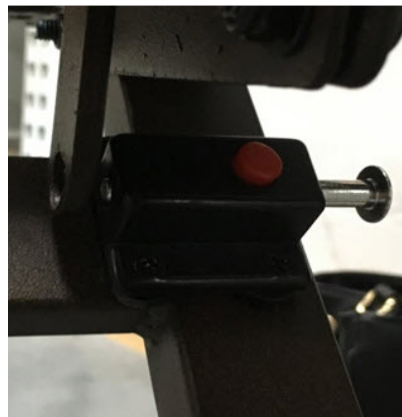
LOCKING MECHANISMS

- Locking mechanisms must be applied to all items that fold, in order to avoid user injury.
- Several different styles of locking mechanisms are acceptable.
- Please provide photos of proposed locking mechanism to Kohl's TD for evaluation BEFORE sending 1st development samples.

Please see below four examples of accepted spring pin locking mechanisms. **All pins must be solid metal and secure the unit in an open position.**



All Pins must be solid metal

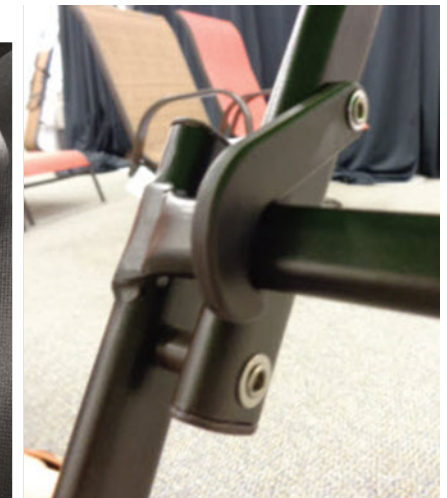
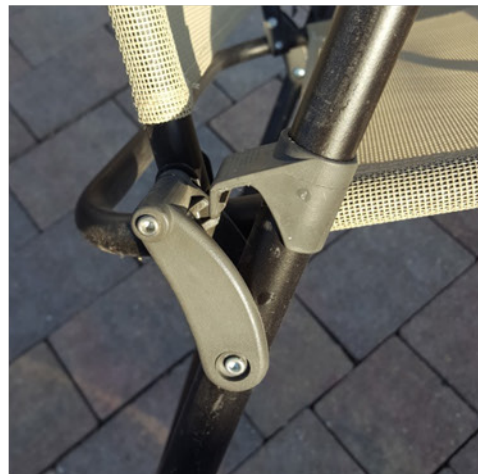


SECTION 8: CONSTRUCTION REQUIREMENTS CONT.

LOCKING MECHANISMS CONT.

- Locking mechanisms must be applied to all items that fold, in order to avoid user injury.
- Several different styles of locking mechanisms are acceptable.
- Please provide photos of proposed locking mechanism to Kohl's TD for evaluation BEFORE sending 1st development samples.

Please see these examples of accepted locking mechanisms. Proposed locking mechanisms do not need to be exactly the same- however all locking mechanisms must secure the unit in an open position.



SECTION 8: CONSTRUCTION REQUIREMENTS CONT.

FLOOR GLIDES

- For wooden legs where floor glides are specified, use either of the standardized Kohl's floor glides below, and contact Li & Fung for sourcing assistance.
- If another style floor glide is preferred by the vendor, please send a sample floor glide to Kohl's TD for evaluation.
- **Please note - vendor options for floor glides must be high quality material, specific to the end use by product type. No plastic glides with bulging nail/screw heads will be accepted.**



SECTION 8: CONSTRUCTION REQUIREMENTS CONT.

FLOOR GLIDES (CONT.)

- For non wooden legs, or for items where the Standard Kohl's floor glides will not work, please provide Kohl's TD photos of the vendor proposed floor glides before sending 1st development sample.
- **Please see some examples below for floor glides used on non traditional items.**

For items with a wire construction where no levelers are specified, consider clip on floor glides.

For items with a wire construction where levelers are needed, consider this construction for leveler attachment.



If units bottom is not flat, floor glides must be raised to ensure the unit is not making contact with the floor.



SECTION 8: CONSTRUCTION REQUIREMENTS CONT.**WOOD LEG PROFILING**

- For styles using solid wood legs, floor glides are not necessary (unless dictated by Kohl's TD).
- Leg bottoms must be sanded smooth and profiled around all edges as shown, with no finish on the bottoms of the leg.
- This is to prevent damage to customers floors (staining/scratching) as well as prevent tear out on the outer edge of the leg.

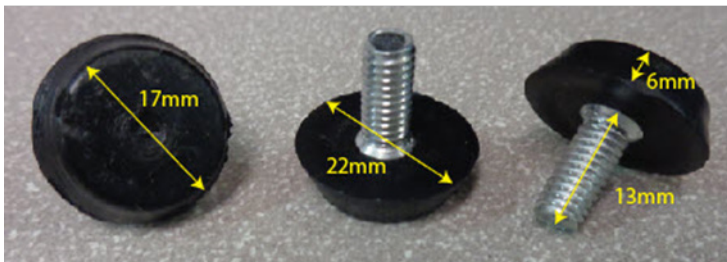


SECTION 8: CONSTRUCTION REQUIREMENTS CONT.

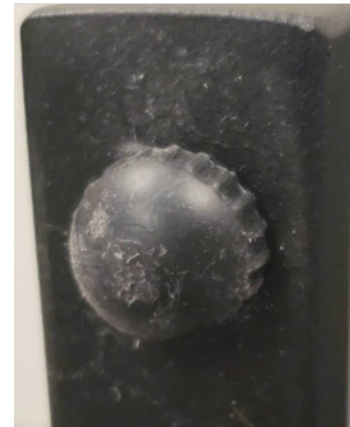
LEVELERS

- All tables MUST have levelers unless otherwise specified in the technical specifications or as instructed by Kohl's TD.
- If vendor would like to propose a different style of Levelers, please send photo to Kohl's TD before sending sample for preliminary feedback.
- Please see photos below for examples of acceptable levelers.

Standard Size of Kohl's Levelers



Other Accepted Leveler Styles



For tables with a wire/woven construction, a leveler attached as shown is acceptable.



SECTION 8: CONSTRUCTION REQUIREMENTS CONT.**ROCKING CHAIR RUNNER STOPPERS**

- Stoppers are required on front and back ends of all rocking chair runners. This is to prevent users from tipping too far forwards or backwards.
- Stopper positioning may vary based upon the shape and length of runners.
- If no length is specified by Kohl's TD, place where feels appropriate and Kohl's TD will evaluate placement on development sample.
- **Please see photos below for examples of accepted rocking chair runner stoppers.**



SECTION 8: CONSTRUCTION
REQUIREMENTS CONT.**LIDDED STORAGE - LID LIFTS & HINGES**

- For storage items with attached lids, self balancing spring loaded lid lifts are required.
- For single seater lids (depending on weight and construction of lid), 1-2 lid lifts are required.
- For double seater lids, at least 2 lid lifts are required. Lid lifts must be able to keep lid open without assistance. If 2 lid lifts are not enough a 3rd will be required, or construction of lid must change to lighter materials.
- Single seater lids must use 2 hinges, and double seater lids must use 3 to ensure the lid is not being torqued and the construction is quality.



SECTION 8: CONSTRUCTION REQUIREMENTS CONT.

LIDDED STORAGE - LID STOPPERS

- For storage items with set on lids, some method of lid stoppers or lid shaping must be used to ensure lids will not shift when in use.
- Vendors may share any proposed methods of lid security with Kohl's TD before sending samples.

Please see below photos of accepted lid stoppers and lid construction used to secure set on lids.



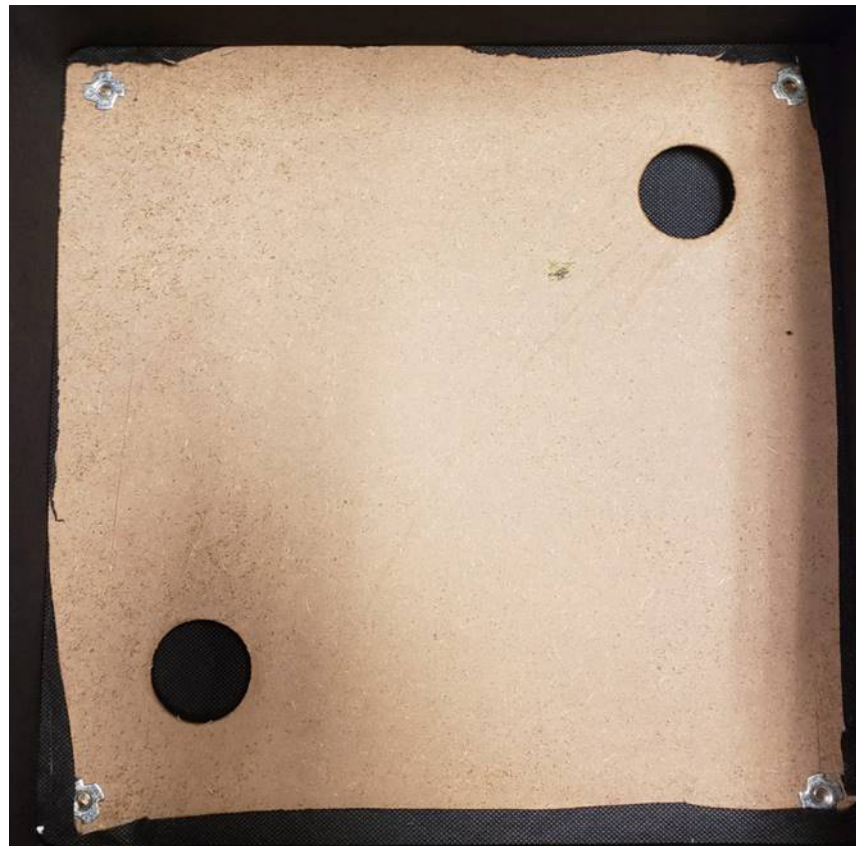
Approved Lid Stopper (4 total)



Construction of lid secured lid during use as a regular storage ottoman and as a tray top ottoman.

SECTION 8: CONSTRUCTION REQUIREMENTS CONT.**LIDDED STORAGE - AIR HOLES**

- Air holes must be included on all solid, lidded storage units/ottomans.
- Cut/drill/router 1" diameter air holes in the floor of all storage items with lids unless otherwise specified.
- **This is a mandatory safety standard. If you are unsure if a style should include air holes, please contact Kohl's TD before constructing sample.**



SECTION 8: CONSTRUCTION REQUIREMENTS CONT.

DRAWER CONSTRUCTION

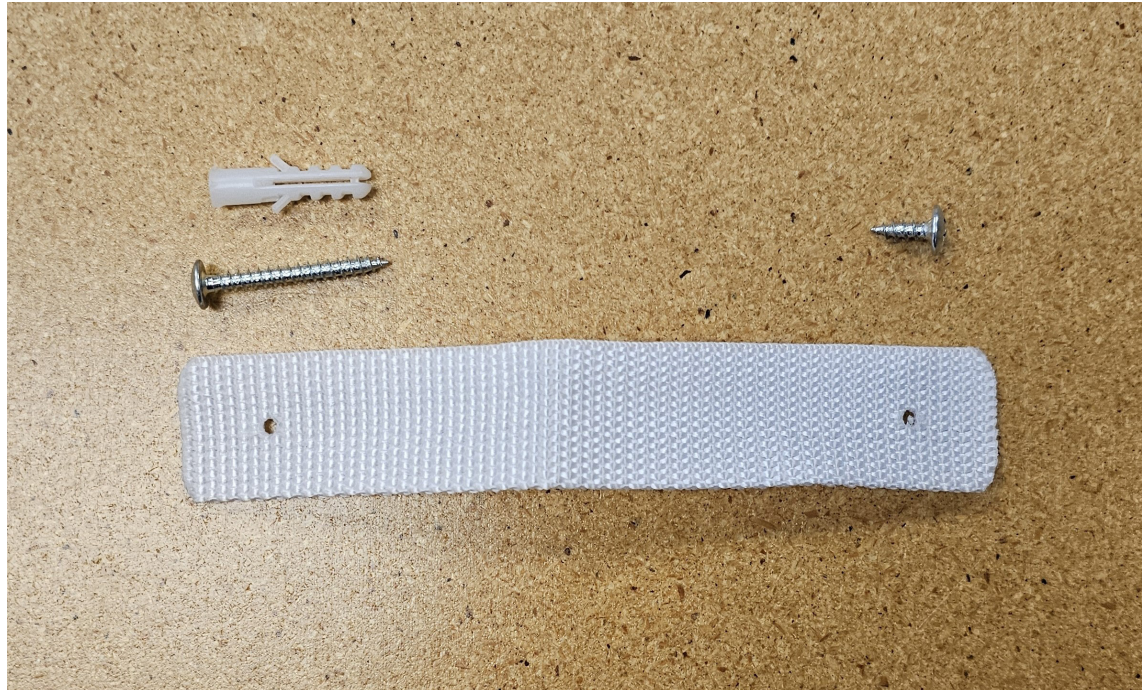
- For full wood construction of drawers, drawer face must be separate and attached to full drawer box.
- For MDF material drawers, cam bolts and camlocks can be used to secure the drawer face and drawer panels.
- Drawer handle may come pre-attached to drawer face if handle design packs flat and is fully protected in shipping OR if the drawer is preconstructed, the drawer handle may be sent with handle attached to inside or drawer.
- It is preferred that drawer slides come pre attached to drawer and table side panels for easier construction for customers.



SECTION 8: CONSTRUCTION REQUIREMENTS CONT.

ANTI-TIP KITS

- Anti-Tip Kits are required for all storage units, console tables, bookshelves, dressers, etc. 27”H or taller.
- If vendor would like to propose a different style of Anti-Tip Kit, please send a photo to Kohl’s TD before sending sample for preliminary feedback.
- No zip tie material is allowed to be used in Anti-Tip Kits.
- **Please see photo below of TD approved Anti-Tip Kits.**



SECTION 9: GLOSSARY OF FURNITURE TERMS AND MATERIALS

Adhesive – Substance that is capable of bonding material together by surface attachment.

Apron – Frame around the base of a table to which the top and legs are fastened.

Bead – During welding, the filler metal/material deposited on and in the work surface when the wire or electrode is melted and fused into the steel to join two or more pieces.

Bevel – Edge of a component which is not perpendicular to the faces of the piece.

Box Joint – Square shaped finger joints used to join wood pieces at right angles.

Bow – Deviation from a flat plane of the wide face of a piece of lumber from end to end.

Burnishing – Smoothing of a metal surface through friction between the metal and a material such as hardened metal media.

Burr – Roughness left by a metal cutting operation such as slitting, shearing, stamping, etc...

Burnt – Metal which has been permanently damaged by overheating.

Butt Joint – A wood joint where straight edges of 2 boards are against each other.

Checks – Longitudinal separation of fibers in wood that do not go through the whole cross section, resulting from tension during drying.

Corrosion – Degradation of metal material due to reaction with its environment.

Crack (metal) – Point where the weld breaks apart from the base structure.

Crater – Depression in the base metal at the end of the bead, caused when steel is burned without depositing filler material.

Crook – Deviation from a flat plane of the narrow face of a piece of lumber from end to end.

Cross Cut – A cut which runs across the board perpendicular to the grain.

Cross sand – Sanding across the grain.

Delamination – Separation of layers in laminated wood or plywood because of adhesive failure.

Edging – Dressing of metal strip and wood edges by rolling, filing, drawing or edge banding (wood).

Finger Joint – Woodworking joint created by cutting a set of complimentary rectangles in two pieces of wood, which are then glued (also known as a comb joint).

SECTION 9: GLOSSARY OF FURNITURE TERMS AND MATERIALS

Raised Grain – A roughened condition on the surface of dressed lumber in which the hard latewood is raised above the softer early wood but not torn loose from it.

Slag/Spatter – Remnants of wire electrode that do not fuse with weld puddle and splatter on surfaces surrounding the welds.

Splits – Separation of wood fibers extending completely through a piece of wood, usually at the ends. Similar to checks.

Spot Weld – Welding process in which fusion is limited to a small area, usually multiple welds at intervals.

Stainless Steel – Corrosion resistant steel of a wide variety.

Tack Welds – Small scattered welds made to hold parts of a weld in proper alignment while the final welds are being made.

Tarnish – Dulling, staining, or discoloration of metals due to superficial corrosion.

Tear out – The tendency to splinter the trailing edge of wood material when cutting across the grain.

Tenon – A projecting member left by cutting away the wood around it for insertion into a mortise to make a joint.

Twist – Deviation from the flat planes on all four faces by a spiraling or torsional action, usually the result of seasoning in wood.

Veneer – A thin layer or sheet of wood or material (i.e. paper, pvc, wood veneer etc...) that is adhered to the exterior of a substrate.

Wane – Presence of bark or lack of wood on the edge or corner of a piece of lumber.

Weld – Union of metal materials made by the process of welding. Welding process uses the application of high heat to join metals.

White Speck – Small white pits/spots in wood. Caused by a fungus in the living tree. No further decay unless used in wet conditions.