

UL 2818-GREENGUARD INDOOR AIR QUALITY CERTIFIED

When it comes to finishes, our highest priority is to seek a safe solution through a finish that preserves the natural beauty of wood. A wide range of stains are available to bring out the beautiful characteristics of each wood species through a multi-step, flawless finish and application process, detailed on the reverse.

To reduce hazardous formaldehyde emissions, we use our proprietary and specially-designed top coat, DuraTex™ low-emission finish process. Not only does this finish significantly reduce formaldehyde emissions, improving indoor air quality, DuraTex™ was developed to be tough and durable without compromising appearance. Third-party durability reports reflect the beauty behind its everyday strength, year after year.

		URETHANE
		SW Urethane
TEST		IN/RE
ADHESION	Boiling Water, 4 Hrs	5/5
	Bell	Pass/Pass
	Crosshatch	0B/5B (5B/N/A)
	Balance Beam Scribe	Pass/Pass
	Direct Impact	Pass/Pass (Fail/N/A)
PRINT	Ambient	5/5
	120° F	5/5
	Plasticizer Migration	5/5
SOLVENT	Coffee Cup Imprint, 4 hrs	5/5
	VM&P, 20 double rubs	5/5
	Isopropyl Alcohol, 5 min	5/5 (4/5)
	Acetone, 5 min	1/1 (2/3)
	Ethyl Acetate, 5 min	2/5 (4/5)
ABRASION	Lacquer Thinner, 20 double rubs	4/5
	MEK, 20 double rubs	3/4
	Wear Index 500 Cycles	N/A
	DTF (in mils)	2.8-3.2 (2.3)

		URETHANE
		SW Urethane
TEST		IN/RE
CHEMICAL	DI Water 130°F	5 / 5
	DI Water-Ambient	5 / 5
	Hydrogen Peroxide	5 / 5
	Disinfectant Cleaners	5 / 5
	100 Proof Alcohol	5 / 5
	Vinegar	5 / 5
	10% NaOH	5 / 5 (1 / 1)
	PTSA Alcohol Solution	4 / 5 (4 / 4)
	0.5% Palmolive	5 / 5
	1% KCMA Detergent	5 / 5
	Lighter Fluid, 24 hrs	5 / 5
	Lemon Juice	5 / 5
	Orange Juice	5 / 5
	Grape Juice	5 / 5
	Tomato Catsup	5 / 5
	Apple Slice	5 / 5
	Butter	5 / 5
	Olive Oil	5 / 5
	Mustard	5 / 5
	U Dye Black 1/1 w/water, 5 min	5 / 5
Black Sharpie	5 / 5	
ASTM Cold Check	Pass/Pass	

Beam Scribe 5000/10000 Direct Impact 5 in lbs/10 in lbs IN = Initial RE = 72 hrs Recovery
 0 = Very Severe 1 = Severe 2 = Moderate 3 = Slight 4 = Very Slight 5 = No Effect

*All results reflect testing being covered 24 hours, unless noted.
 Test results in parentheses reflect differing outcomes from third party testing.*

love what you do



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A TIME-INVESTED PROCESS FOR TIME-TESTED RESULTS

- STEP01 White Wood Sanding:** The entire unit is sanded with 180-grit paper and minor flaws are repaired.
- STEP02 White Wood Inspection:** Prior to finish, the entire unit is closely inspected. All surfaces are checked for smoothness to the touch and flaws.
- STEP03 Sap Stain:** As is needed to uniform the lighter areas in the wood, sap stain is applied.
- STEP04 Overall Stain:** The entire case is sprayed with an NGR stain giving the overall color. The unit is checked against a standard for color and allowed to air dry before wash coat.
- STEP05 Wash Coat:** Wash coat is a thinner clear coat that flows into the grain and locks down the color. It also provides a foundation for the clear coats that follow. The wash coat air dries before the next step.
- STEP06 Wash Coat Sand:** The wash coat, once dry, is sanded with a very light abrasive to remove the small wood fibers that initially rise from the applications of color and wash coat.
- STEP07 Top Filler:** Depending on the type of unit and the color, top filler may be applied to the work surface. This is a thicker stain used to remove some of the deeper grain from the tops. It is rubbed into the surface and then the excess is wiped off. The top then air dries for a short time before it goes in the oven.
- STEP08 Color Check/Shade:** Before the sealer goes on, the unit is looked over and checked against a color standard. Any lighter areas needing to be evened up are then shaded to give a more uniform look to the overall case.
- STEP09 Sealer Coat:** A coat of sealer is sprayed over the entire unit. The sealer air dries, and then into an oven to bake the finish dry. This will take 15-20 minutes. Once out of the oven the unit cools briefly and is ready for the next step.
- STEP10 Sealer Sand:** The unit is now sanded overall by hand over the details of the case, and using a flat sanding machine on the tops. This removes the remaining imperfections from the surfaces and preps the case for final topcoat. The unit is wiped down and blown off to remove the cuttings from the sanding process. It is now ready for topcoat. The unit is looked over and touched up if needed.
- STEP11 Final Topcoat:** At this time the unit will be wiped down and blown off once more. Next the unit is given a semi-filled coat of catalyzed DuraTex™ over the entire case. This is done in an automotive style booth that uses filtered air to remove air borne dirt. The unit then air dries before going to the oven.
- STEP12 Final Dry:** The unit spends approximately twenty minutes in the oven baking the finished cases. It then cools before the installation of hardware, detailing and final inspection. This will take approximately sixty to ninety minutes. Once this process is complete, it gives us a beautiful, durable, semi-filled finish.
- STEP13 Final Inspection:** The unit comes to the inspector where the tag is referenced and the unit is compared to the details of the order, color, size, rim detail, etc. Using standards and gauges the inspector reviews the unit before passing it on to be packed if all checks out.