



WILLISAU
SWITZERLAND

Materials

made by

hand & heart
with cleverness

Wood /

OUR WOOD – Every tree grows in its own unique way

Wood is probably the oldest material of mankind and is still becomes more and more popular. Wood and the colour shades of the wood surfaces express the unsophistication and have a correspondingly harmonic effect on people.

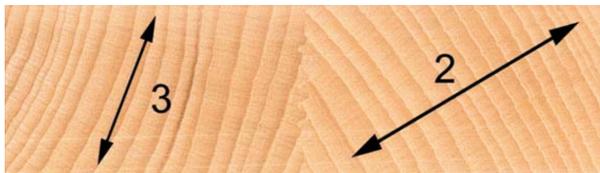
Willisau Switzerland is exercising utmost care regarding the choice of wood, veneer and wood materials. Different colour shades and structures, small shakes, light distortions, intergrowths and knobs are natural features of the material and can therefore not always be avoided. They rather bring out the unsophistication of such imperfections and form exactly your piece of furniture - they make it unique!

SOLID WOOD

The individual design, distinct grain and uniqueness of each finish are what create the charm of the object. We are mainly using local and European wood for our furniture.

As is generally known, wood is described as a lively material over and over again. This does not only refer to the warmth and cosiness it radiates, though. Wood is a hygroscopic material. That means that it adapts its humidity balance to the environment. If the humidity level of the heated living environment drops in winter, for instance, wood releases humidity to the living space. In summer it is exactly the other way round.

This interdependency makes the material swell (expand) and dwindle (tighten). Nature challenges us here for, while the wood remains almost inflexible in longitudinal direction, it moves parallel to the medullary rays (2) and even stronger parallel to the annual growth rings (3). As the figure shows, in case of a table plate this means that it almost does not change in length when it is glued in length, however, might vary considerably in width.

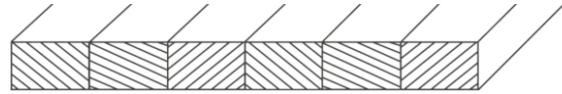


We therefore recommend maintaining a constant humidity and room temperature. The individual design, distinct grain and uniqueness of each finish are what create the charm of the object. Our design provides the best possible conditions for expansion and contraction of the wood. However, it is not always possible to completely prevent smaller hairline cracks in the case of solid wood panel, particularly during periods of transition to very high temperature as well as fluctuations in humidity. We therefore recommend keeping the relative humidity above 40% (ideal humidity in the range of 50%-60%) during the cold and dry winter months.

To meet the multitude of requests, we offer our new PREMIUMline tables in a lengthwise solid design as well. Because these are natural, one-of-a-kind objects characterised by an extraordinary liveliness that is hard to tame with this type of construction in particular, we would like to bring explicit attention to the fact that wooden tabletops are especially sensitive to temperatures and humidity fluctuations. The lengthwise solid (wood) tabletops respond to these changes by "working", which means that over time smaller offsets and irregularities as well as warping of the tabletop can occur.

Constant indoor temperature

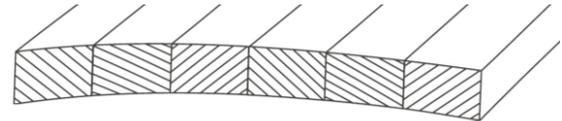
Humidity: between 50 and 60 %
indoor temperature: 18 to 23° Celsius



Dry wood absorbs humidity in moist air, cell walls extend. The shape of wood changes and it becomes bigger.

Swell

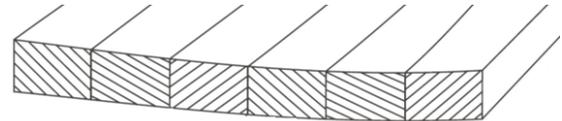
Humidity: more than 60 % humidity



Dry wood absorbs humidity in moist air, cell walls extend. The shape of wood changes and it becomes bigger.

Dwindle

Humidity: below 40 % humidity



Moist wood cells emit humidity in dry air, cell walls become thinner. This reduction phenomenon is referred to as shrinking.

Various effects from light can change the colour of the wood. We therefore ask that you also expose the tabletop extension panel (table fully extended) to various lighting situations as often as possible, particularly at the beginning.

Shrinkage, distortion (swelling, expanding), cupping (warping), minor cracks and/or gap formations and discolouration are natural (caused by nature), comply with the current state-of-the-art and do not constitute grounds for reclamation.

Dimensional tolerances:

Thickness:	+/- 2%
Width:	+/- 3%
Length:	1 mm per meter
"warping/cupping":	1 mm per 10 cm width of panel (considered normal and acceptable)
Wood humidity:	A change of 1% results in approx. 0.6% change in mass.



The wood humidity is approx. 7-10% at the time production is complete. During the subsequent natural drying process of solid wood, small hairline cracks (particularly around branches) are unavoidable. These are practically invisible with non-stain treatments, treatment with wood tones or un treated products. However, these cracks may become visible under opaque surface treatments. Unfortunately this is unavoidable.

The structure of the wood (grain) in solid wood tables from the panel to the leaf (extension) is not continuous, due to the immense length of the logs that would be required!

Solid wood: oil or varnish ?

“Back to nature” – A trend which has long since found a place in the furniture industry as well. The number of natural finish products is increasing all the time, but what options do customers have to choose from?

Varnished finish

Varnished surfaces are treated with a rugged polyurethane lacquer, giving life to the structure of the wood and offering a partially close-pored finish. The varnish hardens the surface and protects it, for the most part, against spots of all types. In addition, the surface is resistant to acids and highly resistant to alcohol.

Advantages:

Easy to take care of, no special care necessary. The surface can be cleaned and maintained with warm water and a bit of washing-up liquid if necessary. In general, “less is more”! Make sure not to use any abrasive agents (such as Vif etc.). Ideally you should use a clean, damp cotton or microfibre cloth. Then dry off the surface using a soft, dry cloth.

Varnishes have a UV protective property that delays discolouration caused by sunlight. In addition to that, the surface is more resistant to water, alcohol and solvents.

Disadvantages:

Repairs can only be performed by a professional.

Oiled finish

Our oiled finishes are a treatment with a solvent-free, purely organic special natural oil, free of any additives. It gives life to the natural beauty and structure of the wood, giving the finish an open-pored and slightly silky shine. The oil penetrates the wood and protects it from the inside. This results in an oiled surface that is antibacterial and antistatic.

Advantages:

Natural finish. The oil creates a moisture-repellent finish. Depending on the condition of the surface, the protection against acids and alcohol can be guaranteed for a period ranging from several minutes to several hours. Because the oil penetrates the wood, the wood surface actually feels like wood, promoting a colour of the solid wood that is rich in contrast.

The finish can also be cleaned using lukewarm water. No additives are necessary. Ideally you should use a clean, dry or lightly dampened cotton cloth. Spilled liquids must be wiped up immediately using a clean, dry cloth or paper towel.

WARNING: Never use scouring agents, detergents or furniture polishes for cleaning purposes.

You can repair minor damages to the panel yourself. It is possible to repair scratches, small marks and spots.



Procedure for smaller scratches or permanent stains (e.g. indelible ink foam rubber-tipped pen or similar):

Use the Scotch (1) from the Willisau care set. Apply a small amount of oil and rub the table in the direction of the grain (2). Next, immediately use the cotton towel (3) included with the set to wipe away the oil that has not penetrated the pores. Never use micro-fibre or leather towels for this.

Procedure for repairing heavier signs of use:

Sand down the table using 220-grain sandpaper in the direction of the grain. Wash off the dust using a damp cloth and let the table dry overnight. Next use Scotch to perform an additional fine sanding in the direction of the grain. Then use a cotton towel to apply oil to the raw surface. Finally, wipe away the oil that has not penetrated into the pores.

Disadvantages:

The table has to be oiled at regular intervals (frequency of oiling depends on use of the wood surface, normally approx. 1-2 times per year). Please use the care set (oil) included with the delivery and make sure that you follow the instructions for care of oiled tables from Willisau, Switzerland.

Both methods of treatment have advantages and disadvantages that must be taken into consideration based on the owner's needs. For customers who want a care-free table, we always recommend a varnished product. Oiled products are for customers who appreciate the natural appearance of the finish as well as the possibility to perform small repairs themselves. As already mentioned, the oiled surface requires continuous care but provides the option in turn to carry out small repairs oneself.

**wholesale price / net after trade discount
care product Willisau Switzerland:**

Wood /

SOLID WOOD WITH CHARACTERISTIC FEATURES

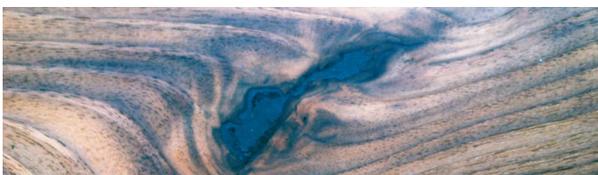
The natural structure of each solid wood panel is unique. This creates dining tables with a highly expressive, lively grain. The individual pattern, the distinctive and natural grain as well as the uniqueness of every surface are given particular consideration in the selection of solid wood with characteristic features. Branches and knots as well as hairline cracks in the wood surface add to the authenticity of the particular solid wood table.

Natural holes in the tabletop are filled with a dark special mixture and then given a clean finish and surface treatment. Here it is possible, i.e. not completely preventable, that small particles of the filler will break away during the working of the wood.

Elm wood in particular exhibits considerable natural colour variations. We minimise this accordingly by steaming the elm wood before it undergoes processing. Otherwise, the colour variations would be much greater. Your new, custom-made table can therefore still vary from what you saw originally (display table, wood sample).

The solid wood collapsing leaves (table extensions) do not necessarily exhibit characteristic features (knots, branches etc.) due to their "small" size.

It takes 80 to 140 year for a tree to grow before it can be used. During this time, each wood develops its very own, unique image. Branches and intergrowths therefore naturally differ in shape, size and number and make every table unique. Please find some individually grown features created by nature below:



WOOD VENEER

Both ecologically and economically, veneer is the best way to utilise wood and is among the most finely fashioned products that can be made out of wood. The process involves cutting thin layers from the log. Each sheet of veneer is unique. Wood veneer is then affixed to a carrier panel or medium-density fibreboard (MDF). In doing so, a layer of solid wood is applied to this wood foundation. In compliance with our own quality guidelines, a typical wood profile with the character of solid wood is created using various different sheets of veneer for nearly all types of wood veneers.

The differences in structure and colour, branches and knots are desirable features and give the wood its solid character. For manufacturing reasons (cutting of veneer), the positioning of the veneer between the tabletop and collapsing table leaf is always slightly offset (max 5 mm). This is unavoidable and therefore does not constitute any grounds for reclamation.

Here it is also possible that various effects from light may change the colour of the wood. We therefore ask that you also expose these tabletop extension panels (table fully extended) to various lighting situations as often as possible, particularly at the beginning.

Veneered surfaces are generally only available with natural coating as the oil cannot get into the veneer sheet and protect it from inside as in case of solid wood. Moreover, veneer cannot be polished and oiled randomly often to renew it as the veneer coating is very thin.

For care, ideally you should use a clean, damp cotton or microfibre cloth. Then dry off the surface using a soft cloth.

TYPE DECLARATION FOR SOLID WOOD

Maple	Switzerland, Germany, France
Beech	Switzerland, Germany, France, Italy
Oak	Switzerland, Germany, France, Hungary, Croatia, Italy
Ash	Switzerland, Germany, Croatia
Cherry tree	Switzerland, Germany, France, Romania
Am. walnut	Eastern North America
Eu. walnut	Switzerland, Germany, France, Austria, Romania
Elm	Switzerland, Germany, France, Romania
Pine	Switzerland
Eu. larch	Switzerland
Fir	Switzerland

Powder coating / Marble /

POWDER-COATING

The new era of wood finishing!

Powder-coating is very common in the metal-working industry as it has a lot of advantages – it is an innovation for the wood industry, though. Wood lives and shows different characteristics depending on quality, age and origin. Our partner has developed this technology in a way that it can be applied for MDF (medium-density fibreboards) in a very high quality and is environmentally friendly on top of that.

Remains good where it gets scratches

Either as dining table or in the office. Surfaces of furniture have to stand great challenges every day but you don't see this on our powder-coated surfaces. They are very rugged and resist sharp edges as hardly any other surface.

Health and environment

Our powder coatings are free of solvents and toxins. Other than conventional coatings, we are regaining 97 percent of the overspray powder and reuse it. As this is a dry system, the product is free of smells and other emissions. The powder coating of wood substrates meets the highest demands and has been awarded with the rating eco-1. This award is synonymous for a very good qualification in Minergy-Eco buildings and for the compliance of high requirements as to environment and health, as our powder coating contains neither solvents nor biocides. Very well compatible furniture for your living room - absolutely reasonable and trend-setting from our point of view.

Powder-coating on MDF – the process

After the incoming goods inspection the woods is stored for at least 24 hours to get the optimum conditions for the coating process. State-of-the-art measuring and application technologies guarantee for a consistent and grooveless composition of layers. Our two-layer-system (foundation and finishing coat) of solvent-free powder paints and a permanent process monitoring guarantee for the excellent Willisau quality and its sustainability.

Powder-based lacquers are solvent-free coating materials. They are made of resins, pigments and additives. The fine powder is electrostatically loaded and applied with air guns. After that, the coated substrates are running through infrared ovens, whereby the powder links and hardens. As soon as all parts have cooled down they can be further processed.

This surface resists everything

Sticky hands of children or gravy on the table. That is just no problem at all for our finely structured surfaces - that robust and resistant are they. But should there be remains of any kind at some stage, just wipe them away with a moist piece of cloth.

Standard colours

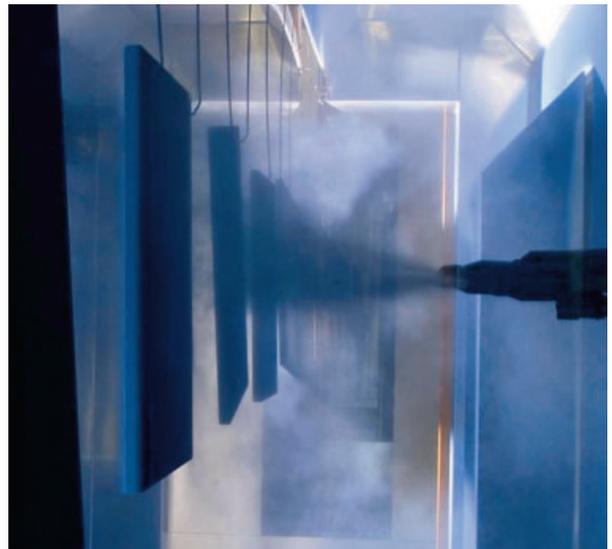
Powder-coating:

- hard white S 0500-N
- pure white RAL 9010
- cream white F6.03.87
- wool S 2005-Y50R
- turf S 7005-Y50R
- light grey RAL 0008000
- mouse grey SN.02.37
- anthracite ON.00.21
- black RAL 9005

Extra colors

Powder-coating:

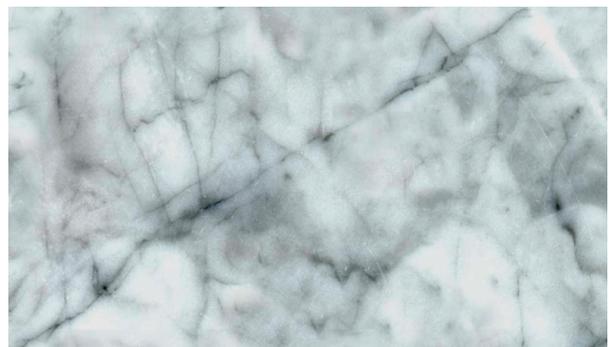
- mud F6.05.70
- pearl white F2.05.65
- fango E4.05.45
- sand S 4005-Y50R
- warm grey FN.02.67
- steel blue S 6020-R90B
- marine S 4020-R90B
- aqua S 2020-R90B
- mud green S 6020-G70Y
- olive S 4020-G70Y
- cherry 3070-Y90R (NCS 1995)
- peperoni 2080-Y90R (NCS 1995)



MARBLE

This precious raw material varies a lot in terms of colour and structure. Slim and broad quartz veins. Pores and deviations in colour result in a never recurring, unique marking. Little brush marks are very distinctive as this kind of rock is quite soft. At Willisau Switzerland, marble plates for the living area are generally protected by a resistant polyurethane-based D/D-lacquer.

Use a lintfree cloth such as a chamois leather or a sponge and warm water without any additions to clean the surface. Remove spots or rims of juice immediately with a moistened cloth. Do never use aggressive chemicals or furniture polishes!



Stucco / XM /

OUR CERAMIC – revolutionary and unique

Ceramic is a revolutionary and one-of-a-kind product - harder than granite, lighter than aluminium, flexible and processable with techniques that are suitable for glass and natural stone. International laboratories and research institutes have certified the extraordinary quality of WILLISAU ceramics with the help of strict tests. Ceramic is an inimitable material that stands out due to its technological and aesthetical features. It has an extremely versatile surface with a great visual effect that is resistant, reliable, practical and long-lasting at the same time.

Ceramic's particular properties are the result of an innovative production process involving the careful selection of raw materials, revolutionary compression technology and a particular firing process in electric, environmentally-friendly kilns. Ceramic is manufactured exclusively from natural materials such as clay, feldspar and natural non-organic pigments. The properties can be outlined as follows:

Chemical-resistant:

WILLISAU ceramic can withstand both organic and non-organic solvents. Disinfectants and detergents will not damage the surface. The surface properties will remain the same if cleaned. The only substance that can damage WILLISAU ceramic in any way is hydrofluoric acid.

Hygienic:

Our ceramic is completely food-safe, as it does not give off any substances. No mould, mildew or bacteria can penetrate the surface.

Fire-resistant:

Our ceramic is made of 100% non-organic substances, and is a non-combustible material. Our ceramic will not smoke or give off toxins in a fire.

Heat-resistant:

Even when exposed to heat, the shape and surface of ceramic remains stable.

Frost-resistant:

Ceramic is frost-resistant and can cope in any atmospheric and climatic conditions; it also absorbs almost no moisture (coefficient of nearly 0).

Scratch-proof:

Ceramic has an abrasion-resistant and completely scratch-proof porcelain surface, with a hardness of 8 on the Mohs scale (industrial diamonds have a hardness of 10). This means that its properties remain the same even after intensive use and frequent cleaning.

UV-resistant:

WILLISAU SWITZERLAND ceramic is completely UV-resistant, as it contains no organic pigments.

Environmentally friendly and recyclable:

Our ceramic is a 100% natural product, and is manufactured from the same raw materials as conventional china. It does not damage the environment and can be very easily ground up and recycled for other production processes.

WARNING:

Due to the unique production process, ceramic may naturally exhibit minor impurities (small colour differences, pigmentation marks, minor protrusions / indentations or stripes depending on the light) and variations in size which still meeting recognised quality standards and are no cause for complaint. Like glass, ceramic is an extremely hard material, and as such is sensitive to impact on the edges. This can cause cracks to appear in the material.

INSTRUCTIONS FOR CARE

TO BE AVOIDED

- Abrasive, Meister Proper - leave residues!
- Glass cleaner (e.g. Ajax - are too inefficient against fat and limestone residues)

RECOMMENDED

Cleaning agent

- Cif or Vim
- Cleaning foam (with blue or green interface)

PROCEED AS FOLLOWS

1. Use a cleaning foam (blue side for normal stains/green side for persistent stains) to rub Cif in circularly with a little water on the table plate.
2. Leave it on for a few minutes.
3. Subsequently, rinse off with a piece of fibre cloth.



Ceramic colours

Colour	Thickness in mm	Price category	Colour category	to width
Nero Assoluto	3 / 7	PC 1	Standard	105 cm
Oxide Darknight	3 / 7	PC 2	Standard	105 cm
Tortora	3 / 7	PC 2	Standard	95 cm
Zement Braun	3	PC 2	Standard	95 cm
Zement Dunkel	3 / 7	PC 2	Standard	105 cm
Eiche Dunkel	3	PC 3	Standard	105 cm
Eiche Hell	3 / 7	PC 3	Standard	95 cm
Weiss	3 / 7	PC 3	Standard	95 cm
Zebrino	3 / 7	PC 3	Standard	95 cm
Beige	3	PC 2	Extra colours	95 cm
Dunkelgrau	3	PC 2	Extra colours	95 cm
Hellgrau	3	PC 2	Extra colours	95 cm
Ivory	3	PC 2	Extra colours	95 cm
Jura Braun	3	PC 2	Extra colours	95 cm
Nero	3	PC 2	Extra colours	95 cm
Oceangrey	3	PC 2	Extra colours	95 cm
Oxide Flame	3 / 7	PC 2	Extra colours	105 cm
Oxide Ice	3	PC 2	Extra colours	95 cm
Pistachie	3	PC 2	Extra colours	95 cm
Zement Beige	3	PC 2	Extra colours	95 cm
Zement Cendra	3	PC 2	Extra colours	95 cm
Zement Hell	3 / 7	PC 2	Extra colours	105 cm
Zement Ivory	3	PC 2	Extra colours	95 cm
Zement Montana	3 / 7	PC 2	Extra colours	95 cm
Zement Sand	3	PC 2	Extra colours	95 cm
Cream White UF0105	3 / 7	PC 2	Extra colours	95 cm
Arenit	3	PC 3	Extra colours	95 cm
Basalt	3 / 7	PC 3	Extra colours	95 cm
Calacatta	3	PC 3	Extra colours	95 cm
Dark Sand	3 / 7	PC 3	Extra colours	95 cm
Hemloch Dunkel	3	PC 3	Extra colours	95 cm
Kansas Antik	3 / 7 / 12	PC 3	Extra colours	95 cm
Light Sand	3 / 7	PC 3	Extra colours	95 cm
Mocha Perla	3	PC 3	Extra colours	95 cm
Moor Eiche	3 / 7	PC 3	Extra colours	95 cm
Oregon Antik	3 / 7 / 12	PC 3	Extra colours	95 cm
Pulbis	3	PC 3	Extra colours	95 cm
Black Ocean	7	PC 3	Extra colours	95 cm
White Marble	12	PC 1	Standard	140 cm
Crystal Grey	12	PC 1	Standard	140 cm
Royal Stone	12	PC 1	Standard	140 cm
Antic Brown	12	PC 1	Standard	140 cm
Black Beauty	12	PC 1	Standard	140 cm
Black Berry	12	PC 1	Standard	140 cm
Limed Oak	12	PC 1	Standard	140 cm
Milan Industrial	12	PG 1	Standard	140 cm
Bromo Natural	12	PG 1	Standard	140 cm
Structure Grey	12	PG 1	Standard	140 cm
Structure Black	12	PG 1	Standard	140 cm
White Sand	12	PG 1	Standard	140 cm
Silver Marble	12	PG 1	Standard	140 cm
Structure Dark	12	PG 1	Standard	140 cm
Kreta Nature	12	PG 1	Standard	140 cm
Viscont Grey matt	12	PC 2	Standard	140 cm
Black Avornello matt	12	PC 2	Standard	140 cm
Black Avornello poliert	12	PC 2	Standard	140 cm
Emperador matt	12	PC 2	Standard	140 cm
Emperador poliert	12	PC 2	Standard	140 cm
Statuario matt	12	PC 2	Standard	140 cm
Zement Hellgrau	12	PC 3	Standard	120 cm

OUR GLASS

– aesthetically pleasing, smooth and homogeneous

Glass is a product of nature. The most important raw materials are quartz sand, chalk and soda. Glass is produced by bonding these different substances at high temperatures and then solidifying the melted mass again during cooling, without the occurrence of crystallisation. The untreated, hard surface exhibits impressive qualities of chemical resistance, imperviousness to spots, simple cleaning and is absolutely hygienic – not to mention its aesthetic aspects.

WARNING:

Due to the sophisticated and complex production process, deviations in mass and minor colour differences are to be expected. The tiniest of bubbles, little stones and streaks in the glass are unavoidable with today's current state of technology. Glass is not scratchproof. We therefore recommend handling it with care during day-to-day use. We also recommend placing a protective pad underneath objects you place on the table.

Evaluation criteria and guidelines for visual inspection of furniture are defined by the "Deutsche Gütegemeinschaft", quality mark RAL-GZ 430, defined and specified as follows:

- *Evaluation basis:*
Emmetropic eyes; diffused daylight (no direct sunlight or artificial light).
- *Evaluation of harmonic overall impression:*
From a distance of 2 - 3 metres.
- *Evaluation of details:*
From a distance of about 0.5 metres.

Product description coloured glass Optiwhite (white glass) TSW

Our glass is made by float glass technology and is in accordance with generally accepted EU standards. There are two surface options: glossy or matted (satinized). Optiwhite glass is decoloured by exactly dosed metal salts and is largely free of green casts occurring in the glass.

Irisation appearances such as light clouds, little spot, rings, flow marks or drawing defects in spectral colours are subject to physical effects in polarized light and cannot be avoided. Small bubbles, spots, glass scatterings, flow marks, centre line flaws or ripples are acceptable material characteristics as long as safety and function are guaranteed.

Such imperfections are evaluated in diffused daylight from a distance of about 0.5 m.

Depending on type and size of glass 100% pure glass is impossible as far as production is concerned. Glass is particularly amenable to scratches (no subjects with sharp edges must be placed on it, for instance). Water and other liquids must be removed from the glass surface immediately as limescale lips might develop. Also, no deep-frozen or hot objects should be placed directly on the glass surface as this may cause damage in the glass. Exposure to light and other lighting causes different colour effects that change depending on the angle we look at the glass. This is a characteristic which is typical for this material and cannot be complained about.

Our glass is suitable for winter gardens with an ambient temperature between +5° and +30° Celsius. Both cold and thermal shocks have to be avoided as such abrupt variations in temperature might cause the glass to break. This may be the case, for instance, then the window is opened at sub-zero temperatures and is closed again after some time. It is also important to keep a minimum distance of 40 - 50 cm from radiators.

Glass / HPL Uni

INSTRUCTIONS FOR CARE

If you have chosen a high quality glass table, in order to maintain your table's perfect surface well into the future, it is necessary to observe the following advice:

- Immediately wipe off all liquids that come into contact with the tabletop in order to prevent the formation of chalk spots.
- Grease spots can be rubbed away using hot, distilled water and a cotton cloth.

Clear glass

The smooth side can be cleaned using glass cleaner or a micro-fibre cloth.

Satined glass (matt)

Satined glass is manufactured from clear glass and processed to create an opaque glass that still allows light to pass through it. This process involves roughing the surface to create a cloudy, matt look. We recommend a microfibre cloth and water for daily cleaning. The following agents are suitable to remove stains on satinised glass surfaces for cleaning at regular intervals (those agents may not be used on coated glass or on glass edges, though):

TO BE AVOIDED

- Cleaning foam with green interface - too abrasive! Otherwise, glass surface might be damaged!
- Dishwashing detergent (e.g. Handy, Palmolive) with dish towel (leaves stains)
- Glass cleaner (e.g. Ajax) - is too inefficient against fat and chalk remains.

RECOMMENDED

Cleaning agent

- Micro-fibre cloth
- Cleaning foam for glass (with blue or white interface)
- Spor eraser (Scotch Brite3M - white foam, Meister Proper "Magischer Schmutzradierer" - white foam)

Cleaning products

- Cream cleaner (e.g. Cif or Vif)
- Lemon stone (e.g. Jemako)
- Ox-gall soap
- Limescale remover (e.g. Durgol)
- Acetic cleaner

REMOVAL OF PERSISTENT DIRT

1. Lightly wet glass surface with a clean cloth.
2. Use a cleaning foam to apply cream cleaner or lemon stone circularly on the glass top.
3. Leave it on for at least 2 minutes.
4. Rinse off thoroughly so that detergent remains are removed.
5. Subsequently, polish glass surface with a dry cloth.

REMOVAL OF PERSISTENT CHALK STAINS

Treat glass surface with chalk remover (Durgol) or acetic cleaner first, leave it on for 2-3 minutes and rinse off. Subsequently, clean as described above.

When wet, the surface of the glass may sometimes exhibit temporary visual effects that are no longer visible after drying. These effects are due to the specific production or material and do not constitute any grounds for reclamations.

Scratch resistance is not unlimited, too. Especially in case of glass plates with a shiny surface, possible scratches are easily visible. To avoid this, a certain caution in daily use is therefore recommended. Daily signs of use do not influence quality.

The glass plate may show minimum faults and marks on the upper side. They were caused during the manufacturing process and unfortunately cannot be avoided. For that reason and due to the natural origin, they do not constitute a reason for complaint.

Standard colours

Clear glass / Satined glass*:

- hard white	S 0500-N
- pure white	RAL 9010
- cream white	F6.03.87
- mud	F6.05.70
- pearl white	F2.05.65
- fango	E4.05.45
- wool	S 2005-Y50R
- sand	S 4005-Y50R
- turf	S 7005-Y50R
- light grey	RAL 0008000
- warm grey	FN.02.67
- mouse grey	SN.02.37
- anthracite	ON.00.21
- black	RAL 9005
- steel blue	S 6020-R90B
- marine	S 4020-R90B
- aqua	S 2020-R90B
- mud green	S 6020-G70Y
- olive	S 4020-G70Y
- cherry	3070-Y90R (NCS 1995)
- peperoni	2080-Y90R (NCS 1995)

*Slight variations in colour cannot be excluded due to the satinised glass surface.



OUR HPL – durable and low-maintenance

Along with ceramic, high quality HPL finishes are the current trend in table manufacturing. This high-pressure laminate (HPL) is able to withstand a great many things. The tabletops are very resistant to all kinds of different wear.

The finishes meet the highest quality standards in accordance with EN 438/ISO 4586 with respect to impact, scratch and abrasion resistance. They are largely resistant to acids, cracks, moisture, temperatures up of 180°C, are non-fading and do not exhibit discolouration. The panels are long-lasting and emissions-free. They are made of approximately 70 % cellulose and 30 % resins modelled on naturally occurring resins. Highpressure presses are used to compress the paper at pressure of about 80 kg/cm² and a temperature of approx 140°C. HPL has been developed to come up to the high demands of everyday life.



INSTRUCTIONS FOR CARE

Thanks to its durable and hygienic sealed surface, HPL does not require any special care. Overall, the panels are easy to clean, which is usually the case for structured finishes as well. To clean, use a clear soap solution and warm water. Dry the table-top with a piece of paper or a soft cloth afterwards. In case of persistent dirt and stains, cleaning can be improved by using a cleaning foam or a nylon brush. Furniture polishes and wax-containing cleansers tend to fill the structures of the HPL surface, which results in the build-up of a sticky, unpleasant layer that adheres to dirt. For this reason, these cleansers must not be used! When cleaning, makes sure to use the mildest possible cleanser. In particular, cleansers must not contain any scouring agents or acidic ingredients, as these types of cleansers may change the sheen and cause scratches.

RECOMMENDED

- Swiss Reiniger



WARNING:

Smaller pigment spots and colour differences, slight impurities as well as minor bumps and dimples in the HPL finish are due to natural processes as well as the production process. These are in compliance with recognised quality standards and do not constitute any grounds for reclamations.

Standard colours HPL Uni

- Black 218
- Slate grey 271
- Mouse grey 272
- Dust grey 273
- Light grey 276
- Snow white 306
- Noble white 377

Extra colours: www.willisauag.ch

HPL STUCCO

HPL Stucco is 100% comparable to HPL Uni with regards to durability. Due to the applied Stucco effect and the light elevations resulting from that, it is more prone to impacts of any kind. Such elevations have an absolutely abrading effect to staining colors, but also to dirty hands / clothing and tend to hold these contaminations on the transitions between the plain colored areas and the elevations. These contaminations are more visible to the naked eye in case of white shades than in case of to darker shades of color. This effect is known from staining blue jeans on lighter cushioning material (white leather / fabric).



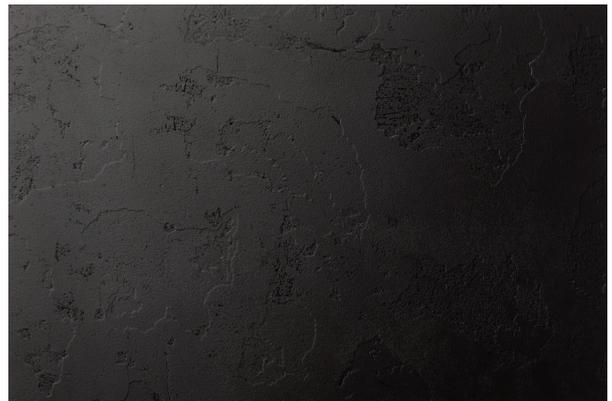
Standard colours HPL Stucco

- Black 218
- Cobra 381
- White 217
- Noble white 377

HPL LAVA

The expressive. Smooth and at the same time porous, matt and rich in contrast like natural lava rock.

HPL Lava are layered composites consisting of thermosetting binder and cellulose layers. The core of the HPL consists of phenolic-impregnated kraft papers (FSC and PEFC certified suppliers) and the top layer of papers (FSC certified suppliers) which have been impregnated with acrylates and cured by electron beam. The LAVA surface is characterized by a special surface structure effect modeled on the natural lava stone.



Standard colours HPL LAVA

- Black 218
- Slate grey 271
- Mouse grey 272
- Sepiabrown 298
- Noble white 377

Extra colours: www.willisauag.ch

HPL Natural Fiber / XM-HPL Strato Soft

HPL NATURAL FIBER

The HPL laminate panel as part of architecture and design. HPL Natural Fiber is an HPL laminated core sheet with a cloudy, irregular surface appearance. The surface image may differ from plate to plate. This untreated HPL reflects the character of the material and can be perfectly combined with other puristic materials such as solid wood, ceramics, glass, etc. The confrontation with raw materials and the unique Swiss HPL production give this puristic material its own character. The requirements of SN EN 438 are fulfilled.



Natural fiber Gold-ORO Inverso (9300 IN)

The unique gold-colored metal and material character of this noble-looking laminate is created thanks to a special production process. It is particularly effective in vertical use with natural sunlight or a daylight-independent special lighting supports the effective staging!

Standard colours HPL Natural Fiber

- Gold-brown / 910 AM
- Gold-ORO Inverso / 9300 IN

Extra colours: www.willisauag.ch

XM-HPL STRATO SOFT

The requirement for the development of this innovative surface: to create a structure in HPL quality, but better than ever before. Thus, XM-HPL STRATO SOFT stands out due to its optic with an enormous colour transparency and depth that is unique so far – and a nice, warm, velvety soft haptic.

Strato are laminar composites of papers and thermosetting synthetic resins, which are applied to carrier materials (MDF). Their surface made of matte, electron-beam-hardened acrylates with clean-touch properties enables a diverse decorative and functional design of table surfaces. Due to the clean-touch technology, fingerprint marks are very poorly visible. However, their life is increased by the use of cutting boards and coasters and when scouring counter stands (including certain pottery) not moved and spilled liquids are removed immediately clean.

Temperatures above 100 ° C should be avoided.

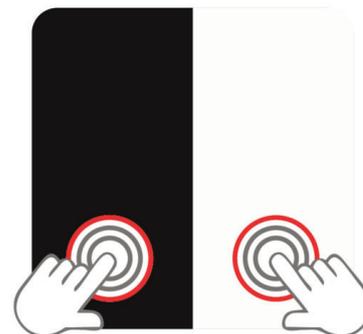
Chemical resistance

The Strato surface has good chemical resistance to most common substances and chemicals. The surface was tested with the reference substances acetone (16 h at 22 ° C), coffee (16 h at 80 ° C), sodium hydroxide (NaOH), hydrogen peroxide (H₂O₂) and shoe polish (10 min at 22 ° C).

The surfaces are not resistant to stronger acids (also descalers) and strong alkalis. Impurities with these substances should be removed within approx. 5 minutes and the surface should be neutralized with water.

Standard colours XM-HPL Strato Soft

- Kalkweiss 1010
- Aurelia 1020
- Glisgrau 1030
- Onyx 1040
- Deep Forest 1050
- Eggnog 1060
- Maulbeere 1070
- Taubenblau 1080





OUR VARNISHES – durable protection

Varnished surfaces are treated with a rugged polyurethane lacquer, resulting in a (partially) closed-pore finish. The varnish hardens the surface and protects it for the most part against spots of all types. The finish is also resistant to acids as well as alcohol and offers durable protection against water and solvents.

WARNING:

Varnished surfaces are delicate, sensitive to impacts and scratches and are therefore to be handled with utmost care.

INSTRUCTIONS FOR CARE

Varnished surfaces are maintenance-free. No special care is necessary. The surface can be cleaned and maintained with warm water and a bit of washing-up liquid if necessary. In general, "less is more"! Make sure not to use any abrasive agents (such as Vif etc.). Ideally you should use a clean, damp cotton or microfibre cloth. Then dry off the surface using a soft, dry cloth.

Standard colours Lack

- hard white	S 0500-N
- pure white	RAL 9010
- cream white	F6.03.87
- mud	F6.05.70
- pearl white	F2.05.65
- fango	E4.05.45
- wool	S 2005-Y50R
- sand	S 4005-Y50R
- turf	S 7005-Y50R
- light grey	RAL 0008000
- warm grey	FN.02.67
- mouse grey	SN.02.37
- anthracite	ON.00.21
- black	RAL 9005
- steel blue	S 6020-R90B
- marine	S 4020-R90B
- aqua	S 2020-R90B
- mud green	S 6020-G70Y
- olive	S 4020-G70Y
- cherry	3070-Y90R (NCS 1995)
- peperoni	2080-Y90R (NCS 1995)

OUR METAL AND ALUMINIUM – good-looking, no nonsense

Aluminium and metals such as iron, steel or chrome are also being used more and more in modern furniture design, and in doing so great importance is placed on aesthetics and austerity.

INSTRUCTIONS FOR CARE

Metals and aluminium are very easy to care for. A soft rag or micro-fibre cloth is adequate to wipe down the surface.

Use curd soap to clean the metals and the aluminium and then wipe them dry. Never use detergents containing grainy substances as these may cause scratching.

Leather /

OUR LEATHER – Individualism originating in nature.

As an upholstery material for our chairs and armchairs we offer high-quality leather in a variety of trendy colours.

Leather is an inimitable natural product which is made of animal hides and skins. Each skin that is tanned to leather has its own, lively grain with grown structures such as pores, grains and imperfections is a unique piece. Natural features are no errors and do therefore not reduce the quality of our leather in any way. Natural signs on the skin such as wrinkles, well healed up and beautifully grown scars, insect bites, warts, hair whorls or impacts of horns are a quality grade that prove that the material is real.

- Genuine leather stretches with use and the creases that are thus formed create the individual character of your furniture and give it an agreeable surface.
- Every leather takes up the dye in its own individual way and various sections absorb it differently, which leads to attractive nuances in the colour.
- The effect of too much heat can cause parts of the leather to dry out, lose their elasticity and become brittle, so keep it at least 40 cm from radiators.
- Comme tout produit naturel, le cuir peut changer de teinte sous l'effet des rayons solaires. Il ne doit donc pas être exposé directement au soleil ou à une source lumineuse.

INSTRUCTIONS FOR CARE

Both stylish and long-lasting, leather is a magnificent product. Leather is natural hide – and hide that is properly cared for stays looking good for far longer. We therefore recommend that you regularly treat your leather. Correct care and cleaning of leather removes traces of use, such as dirt, grease from hair and perspiration. It moisturises the leather and provides it with substances that keep it in good condition.

To give the leather the necessary moisture, rub it down every 1-2 months with a clean, damp cloth. Do not use microfibre cloth as they have a strongly corrosive effect. Protect the leather from direct sunlight. Once or twice a year, treat the leather with an adequate leather care product which is available in specialised

trades. Apply the care product on a covered spot first to see if it is compatible with the material.

It is unobjectionable to carry out basic cleaning with mild soap water (curd soap). Always remove stains with a clean cloth from the outside to the inside. Subsequently, clean the relevant area on a large-scale from seam to seam to avoid water marks. Afterwards, rinse with water on a large-scale as well. Never rub strongly - not even in case of persistent stains. Piece of furniture can only be used again when it is completely dry.

Denims

Denims, which are in common use and are extremely durable, are tough on all leathers. They are abrasive and their colour rubs off onto light materials, substantially shortening the life span of leather coverings. Such colour rubbed off onto light materials in particular cannot be removed.

Coffee, red wine and other liquids

Immediately absorb such liquids with a soft cloth, and wash right away over a large area with ample lukewarm water. It is virtually impossible to remove old stains which have been allowed to dry!

Alcohol stains

If alcohol or cola is spilt on the leather, quick action is necessary: Immediately dab up with a cloth and then dilute the liquid that has already been drawn into the leather with ample water, rubbing the stain with a wet foam.

Ballpoint pen

Immediately put mildly adhesive sticky tape on the ballpoint pen mark (ballpoint pen mark must not have dried and has to be removed immediately). Do not rub the sticky tape on. With a ballpoint pen, trace the mark on the leather over the sticky tape. Repeat this procedure 2-3 times. Remove the sticky tape and erase the remainder on the leather with a colourless eraser.

Special cleaning tips

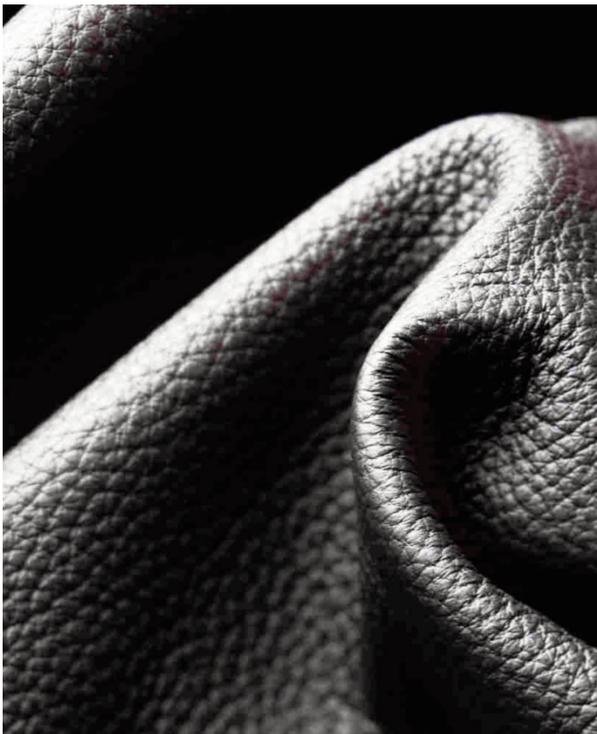
Erase small soiled spots with a colourless, soft eraser. Then wash with lukewarm water.

WARNING:

Never use corrosive cleansers (dishwashing detergent, all-purpose cleaner etc.), as this will permanently damage the leather surface (waterproofing/finish).

All of our leathers have the same properties and meet the same standards of quality listed below:

- Base: Chrome-tanned cowhide, European raw material, imbued with aniline
- Thickness: 1.0 –1,3 mm
- Finish: Lightly polished, protected with pigment.
- Properties: High-quality, durable upper leather with uniform surface structure, delightfully soft and smooth.
- Special attributes: Natural properties such as mast pleats, veins, skin structure remain as evidence of its authenticity. Colour and structural variations are unavoidable and evidence of real leather. These variations do not constitute grounds for reclamations.
- Lightfastness: The lightfast factor of the leather is 4 (scale max. 5).



OUR TEXTILE LEATHER – a pleasant touch

This synthetic leather, with its classic, timeless leather-grain texture, cosy softness and pleasant touch, offer the best qualities for upholstering chairs. Our textile leather is also robust and very easy to clean.

INSTRUCTIONS FOR CARE

Cleaning and care with warm water or with a bit of curd soap if necessary. In general, "less is more"! Do not use any abrasive agents. Ideally you should use a clean, damp cotton or microfibre cloth. Then dry off the surface using a soft, dry cloth.

Colours according to product line Decovin Nappa of the Winter Creation.

OUR MICROFIBRE AND ALCANTARA® products – soft and smooth

ALCANTARA® is the registered trademark of a new generation of ultra microfibre materials exclusively manufactured by ALCANTARA S.p.A. Elegant and practical at the same time: ALCANTARA® combines quality, smoothness, subtlety and a diversity of colours with a particular level of durability and ease of care.

Soft and smooth, fine and elegant: MICROFIBRE chair coverings. Made of the finest polyester microfibres and bonded to rough cotton carriers. Equipped with stain protection that is impervious to liquids for additional convenience. Microfibre coverings are breathable, robust and exhibit good colour retention and light resistance.

INSTRUCTIONS FOR CARE

ALCANTARA® and microfibre (micro fabric) are easy to care for. Just treated with a mild soap and a bit of water (damp cloth wrung out), the microfabrics will retain their beauty. Never rub too strongly even with heavy spots. Never use any chemical cleaning agents!

Dry-cleaning:

Only use perchlorethylene.

- Treat stains immediately
- To prevent lines from developing, clean from the outside working toward the centre of the stain
- Never apply solvents directly to the fabric, and use a clean cloth
- Do not prop up or set down before the material is completely dry
- Went completely dry, loosen the nap back up with a soft brush

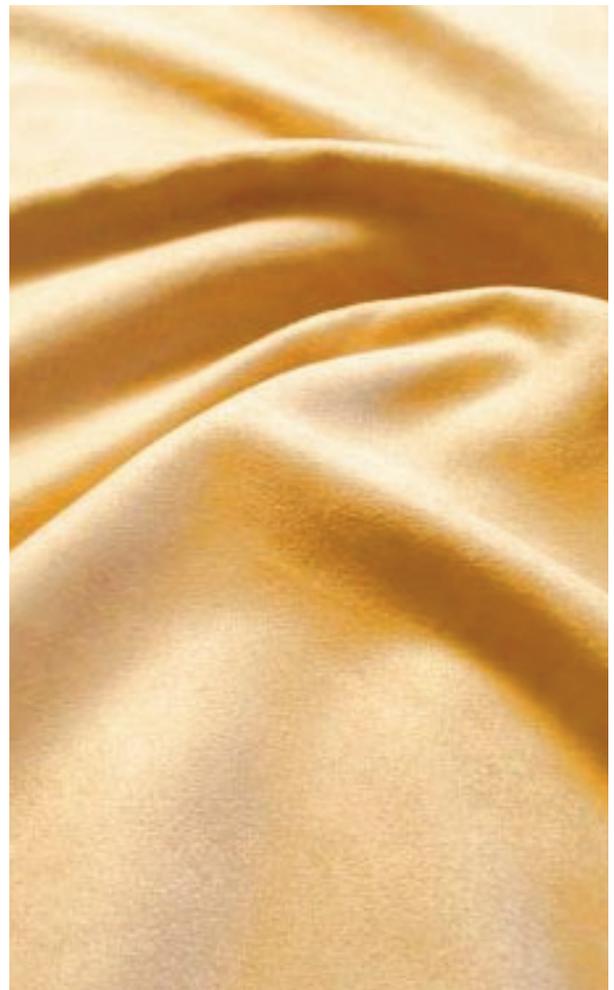
Colours according to product line Microfibre and ALCANTARA® of the Winter Creation.

OUR KNITTED FABRICS

– excellent elasticity and crease resistance

Knitted fabrics (also known as knitwear) are fibre systems created industrially through the formation of meshes on the knitting machine. Knitwear belongs to a type of knitted fabrics whereby a loop of thread is wound through another (thread runs perpendicular and forms a mesh rod together with the neighbouring thread). Knitwear can only be manufactured by machine.

The advantage of the knitted materials is in their great elasticity, which also results in a low dimensional stability and strength. Basically, knitted fabrics are thus better suited for certain applications than woven fabrics. The advantage of knitwear is that it is for the most part runproof.



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made by *hand & heart* with cleverness