

**TEXTILE VARIANCE
REFERENCE GUIDE
2015**



coalesse®

Textile Variance

Thank you for your interest in specifying Coalesse products. We wish to do all we can to assist you in your textile specification. Our comprehensive textile database provides our recommendation for textile applications based on our experience with textiles on our products. Please refer to this Textile Variance Reference guide for detailed information and images illustrating aesthetic variances in textile application.

Please feel free to contact Coalesse, and we will work with you. Contact us at 800.627.6770 for assistance, or go to: <http://www.coalesse.com/fabric/FabricDatabase.html> for our comprehensive textile database.



Coalesse standard cutting methods

Coalesse applies our product knowledge and craftsmanship to utilize specific upholstery methods in our textile application. As with any cutting and upholstery methods the design of the product will impact the pattern view such as those models with curved designs and surfaces.

On the majority of our products the upholstery method we utilize per unit is referred to in the industry as Match Cut, sometimes referred to as Flow Match.

Match Cut involves selecting an element of the pattern aligning that key element in the front center and matching out from the center to the left and right sides.

If the model includes left and right side arm panels each of the arms are produced to complement one another. The outside back is also Match Cut to complement.

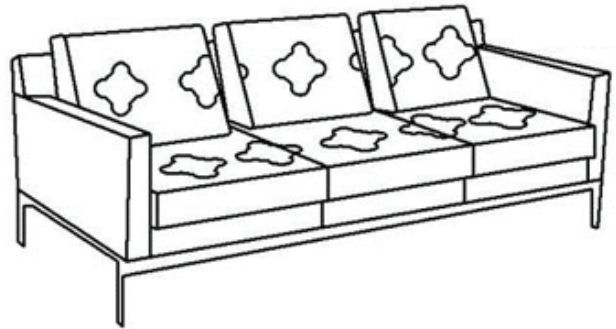
On limited models based on their design the most appropriate pattern matching is achieved through Center Cut. The Coalesse models that currently involve Center Cut as a standard are Millbrae, Circa, Ripple, and Thoughtful models.

Center Cut involves centering an element of the pattern in the center of each seating location from left to right and top to bottom on the inside back and seating areas.

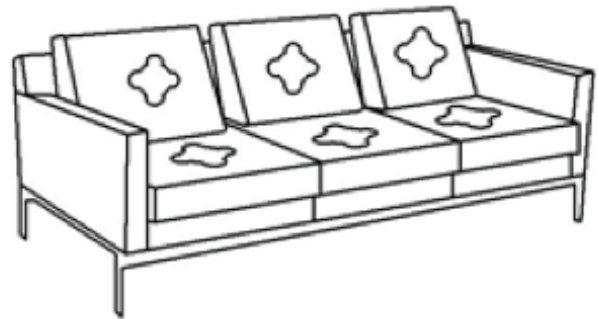
If the model includes left and right side arm panels each of the arms are produced to complement one another.

The outside back is also Center Cut and each area of the back will be cut to match with an element of the pattern as a central focus point. However, the positioning on the back of the focal pattern element is centered from left to right to complement the front of the seating area, but not from top to bottom of the outside back.

Our capabilities and craftsmanship allow us to partner with any designer and customer to design and focus on a specified pattern element in a textile to meet your specifications. We support these request via our Special Engineering Quotes to ensure we produce your product to your specifications.



Match cut the center cushion is cut in the center of the pattern the other cushions are matched into the center cushion.

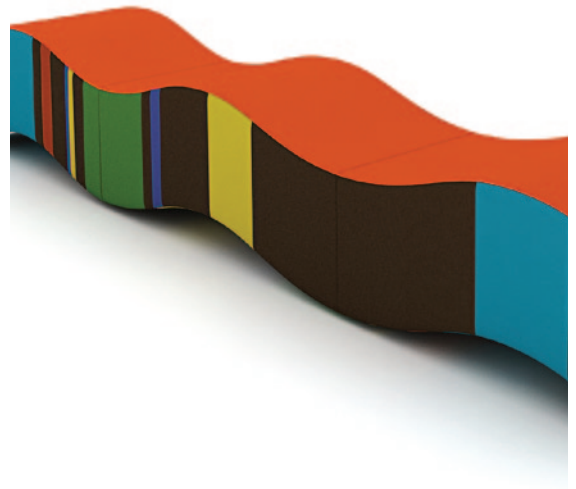


Center cut all cushions are centered on the pattern.

Special engineering quote required

Certain textiles are only sold by the textile vendors as panels of fabric. These textiles often involve intricate patterns or designs. Coalesse wants to be sure that we apply your textile appropriately and we need to quote you the accurate number of panels required for use on the product specified. To be sure we effectively support your order all the way through production in these unique textiles we will require a Special Engineering Quote.

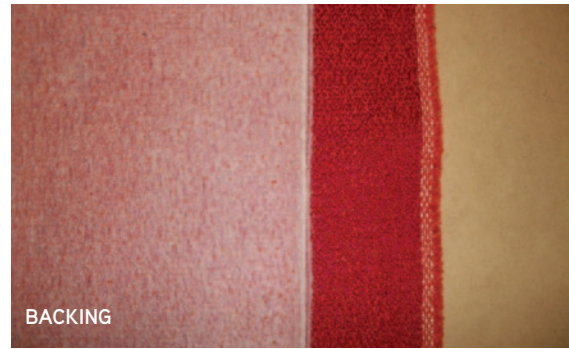
(Message you will see - Special Engineering Quote Required
- This textile requires a Special Engineering Quote to allow detailed application instructions and appropriate textile yardage quotation. This textile pattern sold in panels only – not standard yardage, and it results in a PASS WITH CAUTION in the fabric database.)



What is backing?

Backing is a coating applied to the back of textiles to stabilize and reinforce fabrics for upholstery use. It helps reduce fraying and seam slippage. It is typically not recommended for silks or thin woven textiles since backing may distort color slightly. Backing may be latex or acrylic material.

Additional lead time and upcharges apply. Please contact Concierge Team for more information.



What are stitching details?

Coalesse seating upholstery includes many different stitching techniques in our upholstery process. Each is used in a variety of ways.

1. Single needle is the basic most common stitch that is used on any sewn piece.
2. Top Stitch is created by folding over the selvage of the single needle and sewing to one side on the top of the cover surface. It is used for detail on specific designs such as top edge of the Capa chair.
3. Inverted Stitch or French Seam is created by trimming the selvage bringing the seam together and sewing the top edge together. This detailing technique is used to create a pillow such as the Chord Pillowback or LaCosta Couture chair.
4. Double needle detail is created by special double needle equipment. The single needle seam is opened and stitched on both sides of the seam. This can be decorative to accent the piece or can be critical to the integrity of the chair. This technique is also used to create a zipper on specific models.
5. Saddle Stitch is created in the same fashion as the Top Stitch or Double Needle; however a thicker thread is used to create the finished look. Saddle Stitch is used on designs such as our HolyDay lounge.



Shown above is the Capa chair, notice the top stitch detail on the seat cushion.



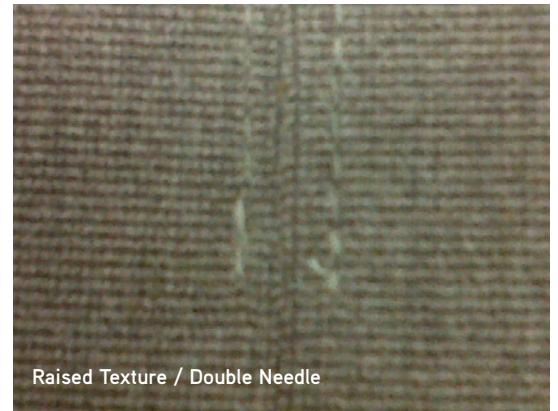
Double needle detail is used to create the zipper on the back of the Wrapp chair.

Top stitch or double needle

With some materials that have a raised pattern or rough texture, these stitching details cannot be properly achieved with the standard expected seam aesthetic. Raised patterns or rough textures may cause the stitching to appear misaligned, crooked, or “snaked” and with these textiles this cannot be eliminated.

These stitching details are used on various Coalesse products and in some cases when used as a design aesthetic, it can be eliminated from the unit allowing you to continue with your textile selection. In such cases Coalesse would proceed, noting that any top stitch or double needle detail would be deleted and manufacturing would proceed with a single needle stitch. (Message you will see – NOT RECOMMENDED FOR TOPSTITCH OR DOUBLE NEEDLE – SINGLE NEEDLE APPLICATION WILL APPLY- and this results in a PASS WITH CAUTION in the fabric database.)

On other products, top stitch or double needle detail is used to create the pillow, zippers or may serve as a stress point. This type of stitch is then considered to be critical to the structural integrity of the unit. Without this detail, the cover would not upholster on the chair so Top stitch or Double Needle cannot be removed from the chair. In these cases you may choose to continue with your selection understanding the seam aesthetic variance that will occur since the stitch cannot be deleted. You may also choose to reselect an alternate textile. (Message you will see: NOT RECOMMENDED FOR TOPSTITCH OR DOUBLE NEEDLE ON THIS PRODUCT. TOPSTITCH OR DOUBLE NEEDLE DETAIL CANNOT BE REMOVED AND IS REQUIRED FOR STRUCTURAL INTEGRITY OF THE UNIT - and this results in a PASS WITH CAUTION in the fabric database.)



Raised Texture / Double Needle



Rough Texture / Top Stitch

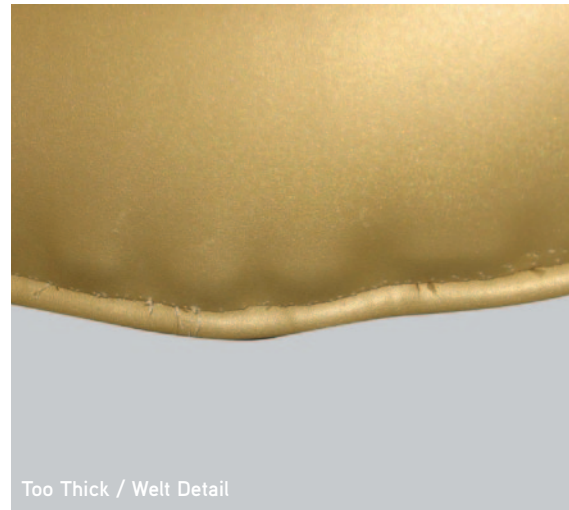


Double needle detail used to create the Zipper Detail (shown in a Rough texture textile)

Thick or stiff

THICK OR STIFF: Some textiles are constructed of thicker or stiffer material. Based on the natural curves, zipper usage, welt, and design of Coalesse products, these thicker or stiffer textiles will not perform well on designs with these features.

When textiles are too thick or stiff to use on selected products you must reselect and choose an alternate textile. : (Message you will see - **TOO THICK OR STIFF** - and this results in a **FAIL WITH EXCEPTION** in the fabric database and this textile may not be utilized.)



Too Thick / Welt Detail

Horizontal stripe

Certain textiles, most commonly synthetic leather or vinyl involving polyurethanes or nylon content, may stretch more in one direction. When this situation occurs we will specify an application direction for that textile to minimize stretch when applied to Coalesse products. The stretch cannot be eliminated; however, can be minimized with the proper application.

At times these textiles may have a striped texture or pattern that will have to run horizontally on the product in order to ensure the correct application direction off the roll to minimize stretch. (Message you will see – **HORIZONTAL STRIPE APPLICATION REQUIRED TO MINIMIZE STRETCH WITH THIS TEXTILE SELECTION** and this results in a **PASS WITH CAUTION** in the fabric database.)

On some models we do not recommend a horizontal stripe, such as on Circa. (Message you will see - **HORIZONTAL STRIPE APPLICATION REQUIRED TO MINIMIZE STRETCH WITH THIS TEXTILE, HOWEVER HORIZONTAL STRIPE IS NOT RECOMMENDED ON THIS MODEL** - and this results in a **PASS WITH CAUTION** in the fabric database.)

Two-way pattern

Certain textiles involve geometrically-designed patterns that run both vertically and horizontally. Some Coalesse models, due to their naturally curved design including some Coalesse modular units, do not lend themselves aesthetically to a two-way pattern application. Modular units such as Circa which have units that curve out and in when connected and upholstered in geometrically-designed patterns may appear to smile or frown from unit to unit as the pattern connects.

Please note proper match out of pattern cannot be achieved. Contrasting upholstery is recommended.

TWO WAY PATTERN – SOLID OR RANDOM REPEAT APPLICATION RECOMMENDED, PROPER MATCH OUT CANNOT BE ACHIEVED WITH A TWO WAY PATTERN.

Or

TWO WAY PATTERN – CONTRASTING UPHOLSTERY RECOMMENDED FOR BIX BACKSCREEN ONLY, PROPER MATCH OUT CANNOT BE ACHIEVED WITH A TWO WAY PATTERN.

Or

TWO WAY PATTERN – CONTRASTING UPHOLSTERY RECOMMENDED FOR RIPPLE. PROPER MATCH OUT CANNOT BE ACHIEVED WITH A TWO WAY PATTERN

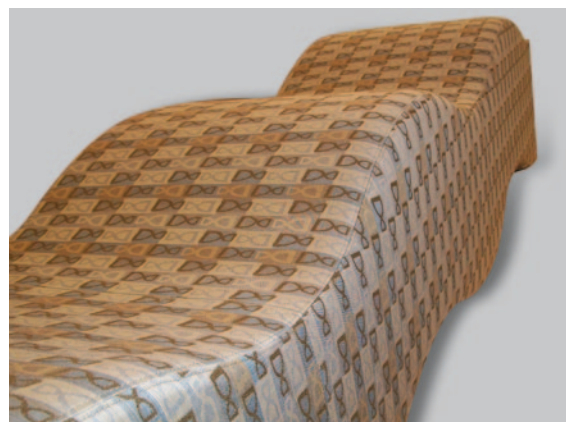
All messages above result in a PASS WITH CAUTION in the fabric database.



Two-way pattern

On some Coalesse products such as Ripple, you may also see a suggestion of using a contrasting upholstery. You may also choose to reselect an alternate textile.

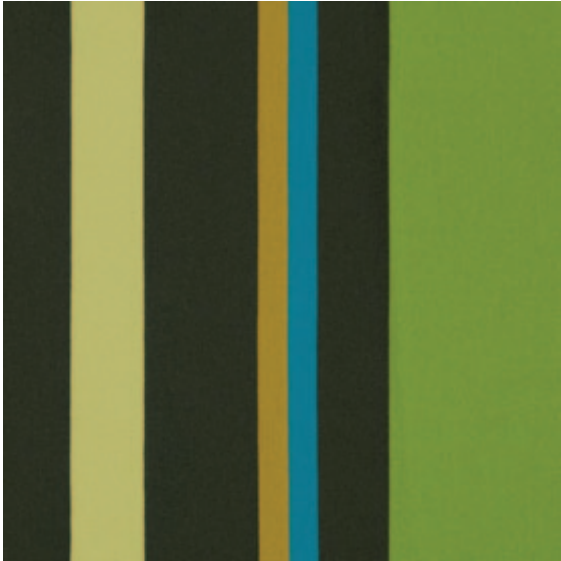
On some models a two way pattern cannot be applied such as the Lagunitas screens and seat decks. (Message you will see – TWO WAY PATTERN – and this results in a FAIL WITH EXCEPTION and this textile may not be utilized.)



Large repeat

Certain textiles involve large repeats and Coalesse uses traditional upholstery processes that consider the textile and repeat. We want to allow the opportunity for specific application instructions to be provided by our designers and customers. These specific instructions can include details on specific elements of the textile and pattern design that you prefer Coalesse to utilize and consider when upholstering and matching your pattern. You may prefer we utilize a completely random application of the textile and disregard any matching considerations. We require these specific application instructions on a textile that involves a larger repeat and you will be asked to request a Special Engineering Quote to support and communicate your specific application instructions to manufacturing. We will quote the yardage requirements based on your application instructions.

(Message you will see - Large Repeat - This textile has a large repeat. Please submit a Special Engineering Quote to provide specific application instructions, and it results in a PASS WITH CAUTION in the fabric database.)



The image above is a pattern from Maharam, Big Stripe. When you review the image below you can see how the large repeat in the pattern prohibits the application of the full pattern view on a seating unit whose dimensions are smaller than those of the textile pattern itself. If a series of units were placed side by side in a ganging application, a continuation of the pattern from one unit to the next may be preferred. Specific instructions would require the Special Engineering Quote.



Striped textile

Certain textiles involve stripes that can be in contrasting colors to the main textile background or they could be more subtle tone-on-tone stripes. Coalesse applies stripes vertically unless otherwise instructed; however, some Coalesse models due to their naturally-curved design may not lend themselves aesthetically to a stripe application, and only vertical stripe application is recommended.

When a textile involving a striped pattern has been selected for use on one of the Coalesse products with a curved design that aesthetically does not lend itself well to stripes, you will receive a notice. In these cases you can continue with your selection, understanding the application of a stripe on this model does create a potential concern on the finished product aesthetically that cannot be eliminated when using this textile. On some Coalesse products, such as Ripple or Bix, you may see a caution suggesting the use of contrasting upholstery. You may also choose to reselect an alternate textile. (Depending on the model you will see one of the following messages: STRIPED TEXTILE – SOLID OR RANDOM REPEAT APPLICATION RECOMMENDED, PROPER MATCH OUT CANNOT BE ACHIEVED.

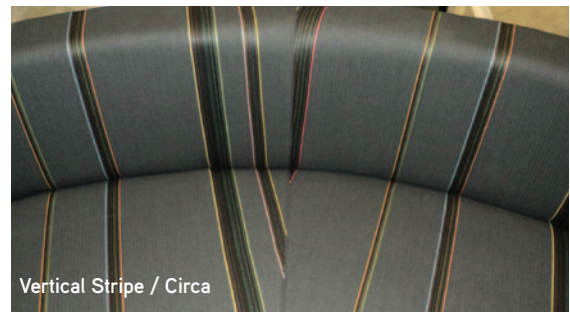
Or
STRIPED TEXTILE – STRIPES MUST BE APPLIED VERTICALLY ON THIS MODEL.

Or
STRIPED TEXTILE – CONTRASTING UPHOLSTERY RECOMMENDED FOR BIX BACKSCREEN. SOLID APPLICATION RECOMMENDED FOR BACKSCREEN ONLY, PROPER MATCHOUT CANNOT BE ACHIEVED.

Or
STRIPED TEXTILE – CONTRASTING UPHOLSTERY RECOMMENDED FOR RIPPLE. PROPER MATCH OUT CANNOT BE ACHIEVED WITH A STRIPE.

All messages above result in a PASS WITH CAUTION in the fabric database.

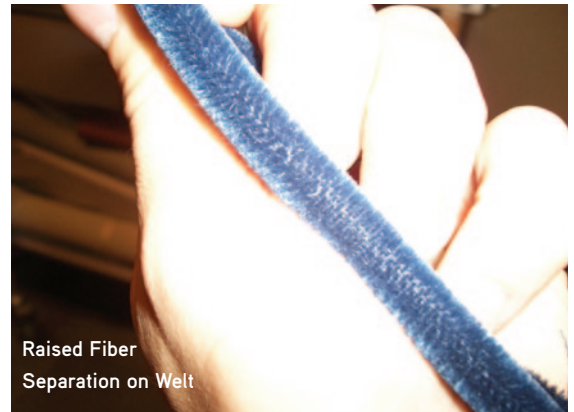
On limited models, stripes may not be approved and this applies to Lagunitas back screens and seat decks. (Message you will see – STRIPED TEXTILE – and it results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)



Welt

Welt is a cord-like material that is wrapped in your textile selection and is sewn together serving as a trim feature for bases, arms, and backs on many Coalesse products.

Some textiles when wrapped around the welt cord may exaggerate a raised texture or separate raised fibers in the textile exposing the base material. In these cases you can continue with your selection but would need to be aware that application of this textile on the welt will create a visual on the finished product aesthetically that cannot be eliminated. In addition, we may suggest that you specify a contrasting upholstery on the welt that will not create the same aesthetic issue. (Message you will see – **CONTRASTING FABRIC ON WELT IS RECOMMENDED** - and this results in a **PASS WITH CAUTION** in the fabric database.)



Memory

Some textiles when stretched have limited memory and will not return to their initial shape or appearance. With normal memory, a textile will quickly return to its normal shape when pulled in different directions. With light memory, the textile may not return to its normal shape or will be slow to return.

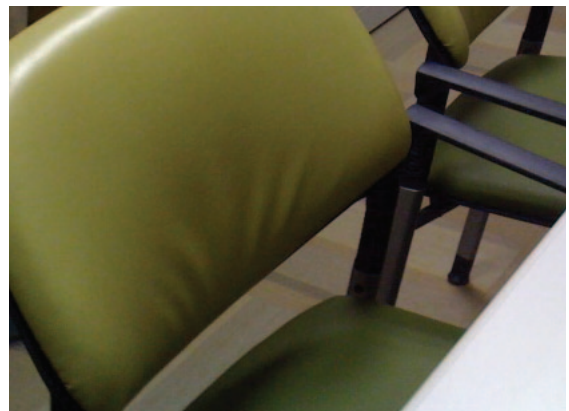
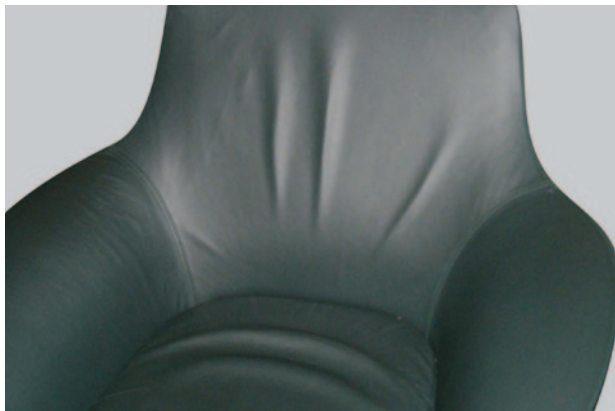
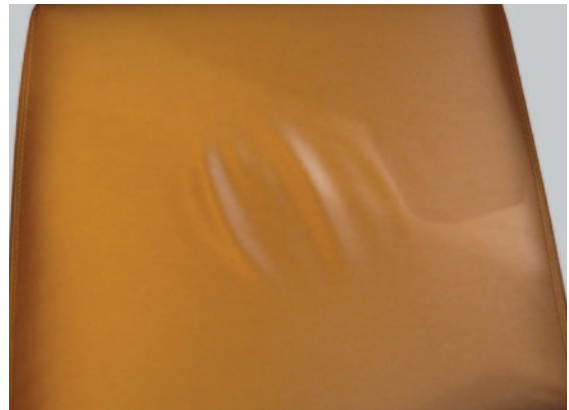
When the application of a textile will result in stretch that will not return to its original form and results in wrinkling, these textiles are not recommended for use on Coalesse products. We recommend you reselect and choose an alternate textile. (Message you will see – **MEMORY** and it results in a **FAIL** in the fabric database.) You do have the option of continuing with your original textile selection; however, noticeable wrinkling or puddling may occur. Coalesse cannot be responsible for textile performance or aesthetic appearance with use.



Wrinkle, puddle, or pucker

Some textiles when combined with the natural curves and design of various Coalesse products will exhibit wrinkles or will puddle or pucker in various areas of the product. Certain Coalesse seating will show comfort wrinkles due to the design of the product.

When the application of a textile will result in excessive puddling or wrinkling, these textiles are not recommended for use on Coalesse products. We recommend you reselect and choose an alternate textile. (Message you will see – WRINKLE, PUDDLE, PUCKER and it results in a FAIL in the fabric database.) You do have the option of continuing with your original textile selection; however, Coalesse cannot be responsible for textile performance or aesthetic appearance with use.



Too thin / panel fabric

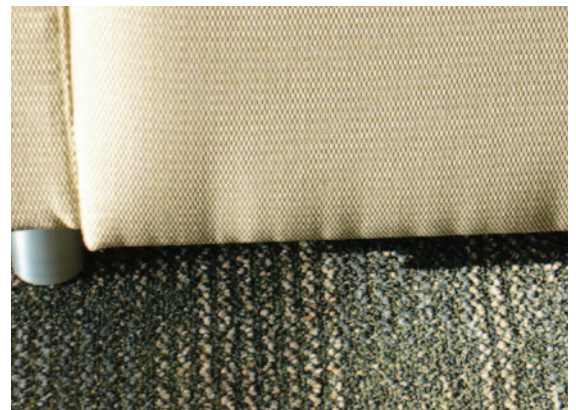
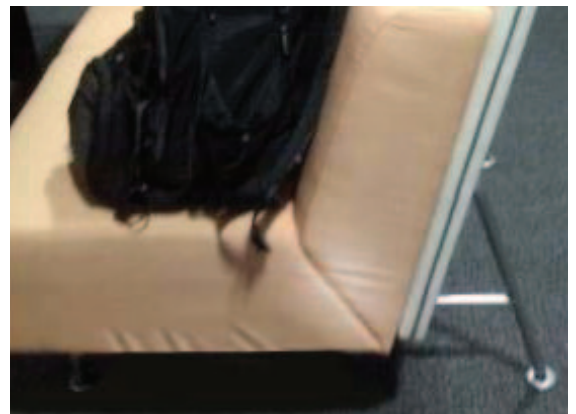
Some textiles have been designed for use as panel fabrics or other applications that do not meet standard upholstery material requirements.

When a textile is classified as panel fabric and you have selected a non-panel item, you must reselect and choose an alternate textile. (Message you will see – PANEL FABRIC – and this results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)

Cat teeth

Some textiles especially thinner textiles or perhaps textiles with a heavier silk content will wrinkle or gather at the seams or when pulled in the upholstery process at the base of a unit.

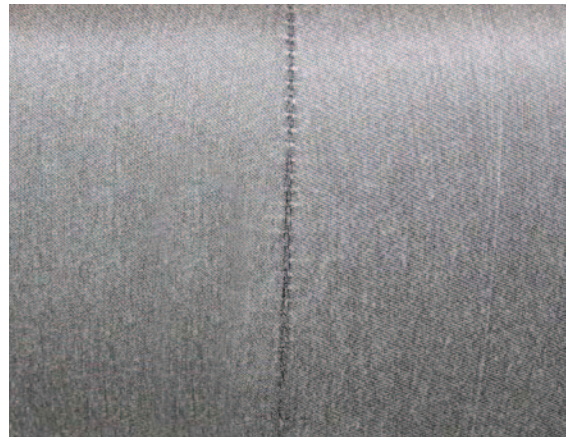
When the application of a textile will result in cat teeth we recommend you reselect and choose an alternate textile. (Message you will see – CAT TEETH and it results in a PASS WITH CAUTION in the fabric database.) You do have the option of continuing with your original textile selection.



Thread separation

At seams, textile threads pull away from the seam when pressure is applied. Usually visible in textiles that have dark face and light back or vice versa. Thread separation usually occurs on fabrics of continuous filament yarns that are very smooth with a slick surface. It is also caused by loosely constructed fabrics.

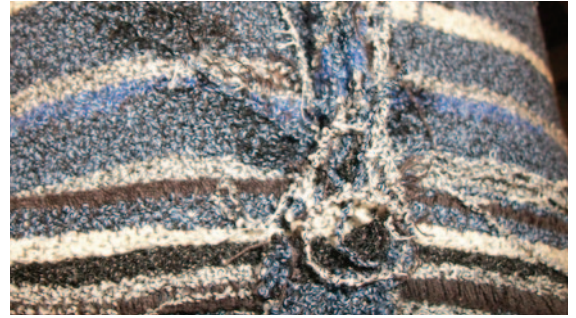
When the application of a textile will result in thread separation, we recommend you reselect and choose an alternate textile. In these cases you can continue with your selection, understanding the application of this textile on the product will create a visual on the finished product aesthetically that cannot be eliminated. You may also choose to reselect an alternate textile. (Message you will see – THREAD SEPARATION - and this results in a PASS WITH CAUTION in the fabric database.)



Loosely woven

Some textiles are loosely woven and will unravel easily resulting in weak seams. With these textiles, adding a backing will generally not eliminate the issue.

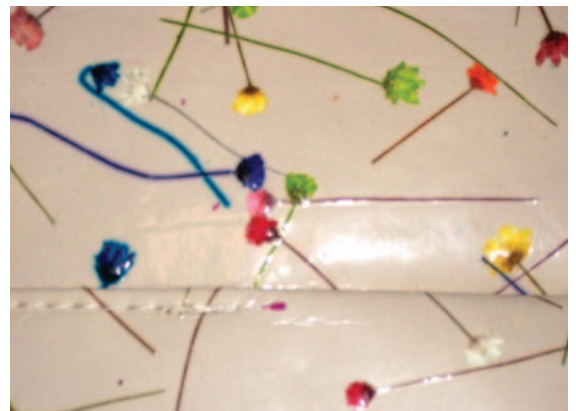
When a textile is classified as loosely woven, we recommend you reselect and choose an alternate textile. (Message you will see – LOOSELY WOVEN – and it results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)



Misc. not recommended

Some textiles have resulted in field performance issues, and those issues do not meet any other classifications. However, we have clear performance issues that required upholstery replacements. Most textiles will fail or have a pass with exception based on our standard evaluation criteria so this is rare; however, it can occur.

When a textile is classified as miscellaneous not recommend you must reselect and choose an alternate textile. (Message you will see – MISC NOT RECOMMENDED – and it results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)



Not recommended for single needle

Some textiles should not be used in a single needle application and require a stronger seam. Some Coalesse products only involve single needle stitching and as a result if a fabric is not recommended for single needle then it would not be recommended for use on this product.

When a textile is classified as not recommended for single needle, and the product you are selecting is only produced with single needle stitching then you must reselect and choose an alternate textile. (Message you will see – NOT RECOMMENDED FOR SINGLE NEEDLE – and it results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)



Glue test

Some Coalesse products have a glue process in the upholstery applications. Certain textiles will absorb the glue or allow glue bleed through and cannot be applied to these products.

When a product requires gluing in the upholstery process and the textile will not work with glue then you must reselect and choose an alternate textile. We may in some cases require you add a backing to your textile to eliminate the glue bleed through. By adding a backing, you can then use your initial textile selection. (Message you will see – GLUE TEST – and it results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)



Leather

Some Coalesse Products may involve specific rules involving leathers or synthetic leathers.

Shell Back chairs – Shell back chairs have a wrap around upholstery method and as a result are not available in leather or COL. The leather when gathered in the wrap around upholstery technique is too thick to work effectively underneath the shell back. (Message you will see – CANNOT SPECIFY LEATHER ON THIS MODEL – and this results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)

Holy Day Lounge and Tables – Holy Day lounge seating and tables with leather have a unique option available for saddle stitching. Since this detail is only available on the models in leather unique models were set up for leather upholstery versions.

If you select the Holy Day Lounge Leather model and try to specify a non-leather material the message you will see – LEATHER REQUIRED FOR THIS MODEL and it results in a FAIL in the fabric database. You should at this point go back and specify the Holy Day Lounge.

If you select the Holy Day Lounge which includes the standard non-leather models and try to specify leather the message you will see – CANNOT SPECIFY LEATHER ON THIS MODEL and it results in a FAIL in the fabric database. You should at this point go back and specify the Holy Day Lounge Leather model.

If you select the Holy Day tables, only the models available with Leather tops are loaded to the fabric database and if you tried to specify a non-leather material the message you will see – LEATHER REQUIRED FOR THIS MODEL and it results in a FAIL in the fabric database.

Lagunitas screen/seat deck leather or vinyl may not be used on Lagunitas screens and seat decks. (Message you will see – LEATHER or VINYL – and this results in a FAIL WITH EXCEPTION and this textile may not be utilized.)



Outdoor

Some Coalesse products such as Emu have models designed for use outdoors and textiles designed for outdoor use should be specified on these products when ordering. If you plan on utilizing indoors there are specific Emu models set up for indoor use. (Message you will see on an outdoor model if you select a textile not designed for outdoor use – OUTDOOR – and it results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)

Other Coalesse products are designed only for indoor use and Coalesse does not offer indoor/outdoor versions of these products. (Message you will see on an indoor model if you select a textile designed for outdoor use – OUTDOOR – and it results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)



Cannot use repeat

Tack panels are a one piece design, fabric will be railroaded for consistent application. Matched pattern, directional, or striped fabrics may not be specified on tack panels. Self-healing fabrics are recommended. (Message you will see- CANNOT USE REPEAT - and it results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)

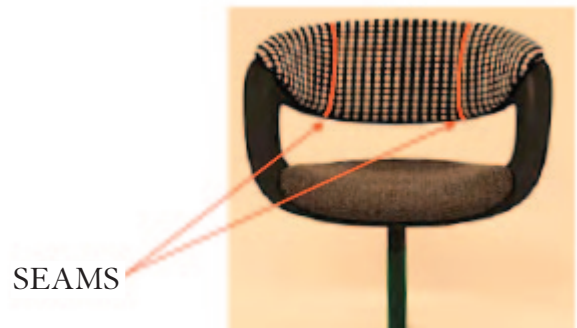
Application issue

There are occasions when Coalesse has had a specific experience with a textile in our manufacturing processes and determined the textile will not work on specific products based on finished results. The issues for that textile may not specifically match current issues previously defined; however, we still do not recommend the textile for use and fail that textile on a specific product. When this occurs since no other issue specifically defines the challenge we will indicate an Application Issue. (Message you will see- APPLICATION ISSUE - and it results in a FAIL WITH EXCEPTION in the fabric database and this textile may not be utilized.)

Back seams required

On certain models that are standard with no seams, textiles such as those with aligned patterns or those that may be thick or stiff will require the addition of back seams to enhance the upholstery aesthetic.

On Lox with the upholstered back option, the inside back will have the addition of single needle stitch seams with certain textiles to allow Coalesse to expand the textile offerings that may be used on the product. When you have selected a textile that requires the addition of seams you may reselect if you prefer a seamless back or you can continue with your selection. (Message you will see – BACK SEAMS REQUIRED - on certain models that are standard with no seams, textiles such as those with aligned patterns or those that may be thick or stiff will require the addition of back seams to enhance the upholstery aesthetic and it results in a PASS WITH CAUTION in the fabric database.)



Additional seam requirement

On limited Coalesse products, there are upholstery areas that involve large cuts of textiles for that specific area of the product. When these large expanses occur and the textile requires vertical application, there may be a need to add seams for appropriate textile application. Leathers also require the addition of seams. The additional seams may occur across the outside back of larger units including loveseats and sofas.

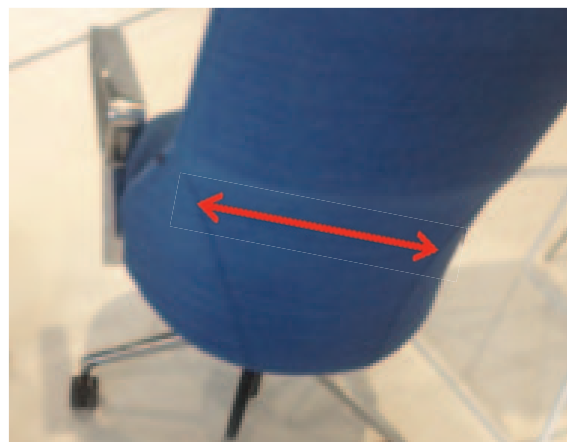
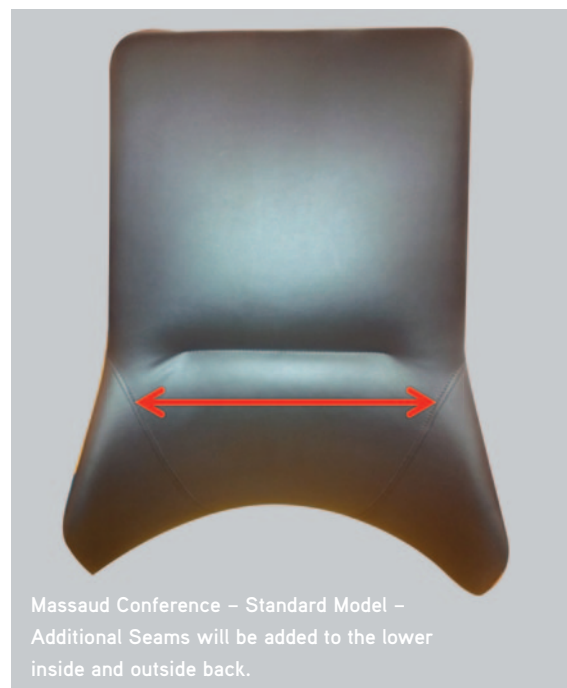
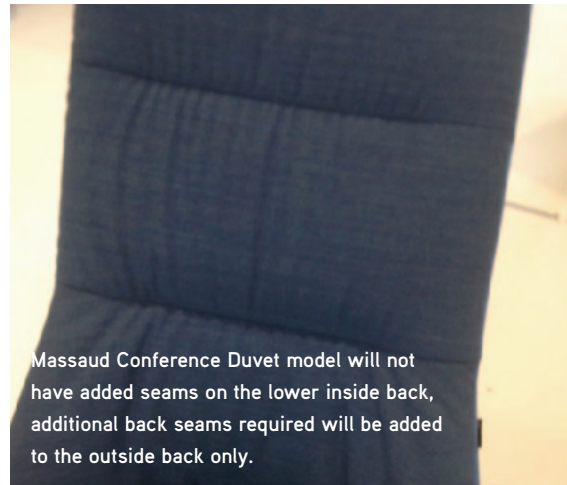
On Joel lounge product, textiles that are applied vertically or leather require the added seam in the center of the front panel. (Message you will see - ADDITIONAL SEAM REQUIRED - On the Joel product, any textile applied with vertical application or leathers will require the addition of a front panel center seam, and it results in a PASS WITH CAUTION in the fabric database.)



Additional back seam requirement

On Massaud Conference models including the standard and duvet models, most textile selections will require the addition of seams on the back of the chair. The Massaud Conference standard model will have additional seams on both the lower inside and outside back of the chair; however, the duvet model will have the additional seams on the outside back of the chair only. The addition of the seams allows Coalesse to create a clean upholstery application with a large variety of upholstery selections.

(Message you will see - ADDL BACK SEAM REQUIRED - On the Massaud Conference product, this textile will require seams on the lower inside and outside back. Duvet model seams on outside back only, and it results in a PASS WITH CAUTION in the fabric database.)



Screen application

Coalesse continues to launch new and innovative products. As we introduce new products and materials we also discover unique characteristics requiring we caution or recommend against the use of specific textiles. Lagunitas lounge and bench seating incorporates screens into the design and these screens involve structure and architectural support elements that may become more evident or visible with the use of specific textiles.

(Message you will see - SCREEN APPLICATION - Certain textiles, when used on some models, allow telegraphing of structural characteristics of the product typically not visible. Textiles on Lagunitas screens must be at least 54" wide, and it results in a FAIL WITH EXCEPTION in the fabric database and these textiles may not be utilized.)



