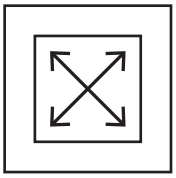


FURNITURE COMPONENT MANUFACTURING

(from wood-based panel materials such as chipboard, MDF, HDF, etc.)

Permissible tolerances



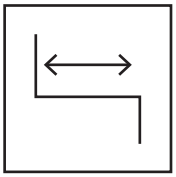
Dimensions / Diagonal

Cutting: ±0.5 mm
Cutting and edge banding: ±1 mm
Applies to non-serial production (individual parts within an order).



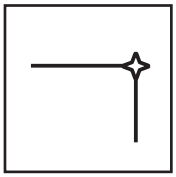
Edge banding 2 mm

Minor imperfections in the edge radius are acceptable due to the operating characteristics of the edge banding machine.



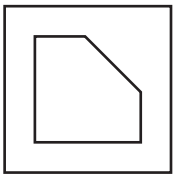
Step

Up to 0.25 mm per side caused by the scoring saw.



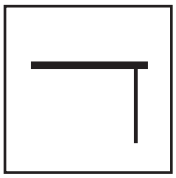
Edge banding ≥0.8 mm

Minor edge chipping at the corners is acceptable due to the operating characteristics of the edge banding machine.



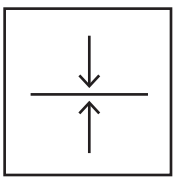
Corners

Offset: ±0.5 mm.



Edge banding of different thicknesses

Edge overhang of up to 0.25 mm at the corners of the component.



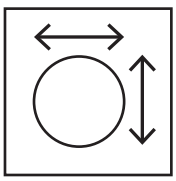
Thickness

According to the technical specifications of panel material suppliers:

https://viyar.ua/downloads/

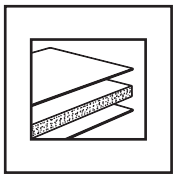
Average tolerances:

Chipboard: ±0.3 mm
MDF: ±0.5 mm



Holes

Position tolerance: ±0.25 mm
Depth tolerance: ±0.5 mm



Lamination

Standards according to the technical specifications of panel material suppliers (see below)

Type of component	Surface	Permissible deviations / Evaluation criteria
Cabinet components	Entire surface	Point defects – up to 2 pcs., max. 2 mm in size per 1 m². Longitudinal streaks – up to 1 pc., max. 20 mm in length per 1 m².
Front components*	Back side	Point defects – up to 2 pcs., max. 2 mm in size per 1 m². Longitudinal streaks – up to 1 pc., max. 20 mm in length per 1 m².
	Front side	Defects that are not visible under the specified inspection conditions are not considered grounds for a claim.**

* Front components include the visible elements of the finished product (doors, drawer fronts), structural elements intended for the installation of glass, lift mechanisms or other opening systems, as well as fastening elements used as decorative finishing components.

**** Inspection conditions for the surface of a front component:**



Viewing distance: 700 mm



Lighting intensity: 1000–2000 lux



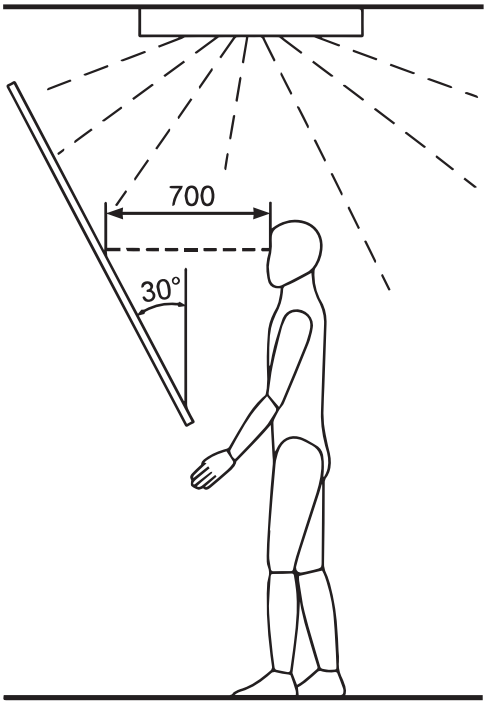
Viewing angle: 30°



Lighting type: Daylight (6500 K)

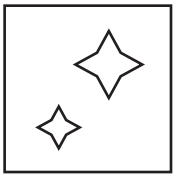


Inspection time: Up to 10 seconds



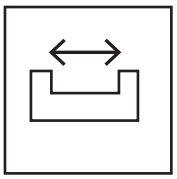


Scan or click the QR code to access the technical specifications of panel material suppliers.



Chips

One chip measuring 2×2 mm per linear meter is permissible.
The presence of chips is directly related to the quality of the panel material.
Not permitted on front components.



Groove / Rebate

Offset: ±0.25 mm
Width: ±0.25 mm
Depth: ±0.5 mm



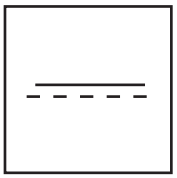
Warping

According to the technical specifications of panel material suppliers:

https://viyar.ua/downloads/

Average values:

Chipboard: ≤ 2 mm per linear meter
Niemann/AGT MDF: ≤ 1.5 mm per linear meter



Glue line

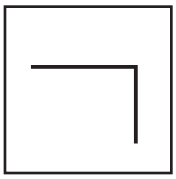
EVA edge banding: up to 0.2 mm
PUR edge banding: up to 0.15 mm
Curvature of the edge banding: 0.2–0.4 mm, depending on the edge banding thickness and the milling radius.



Glue

Minor glue residue is permissible.

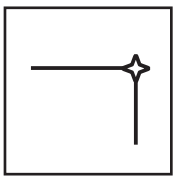
Recommended edge banding thickness



Edge banding 0.4–0.6 mm

Recommended for edges that:

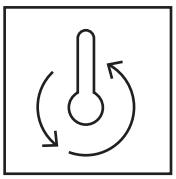
- are not directly visible during normal use;
- are adjacent to other structural elements (e.g. the back edges of components or edges adjoining a wall).



Edge thickness of 0.8 mm or more

Recommended for visible surfaces and front components, where aesthetic appearance and enhanced wear resistance are important.

Operating, transportation, and storage guidelines



Temperature:

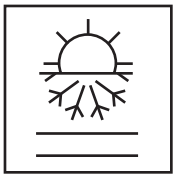
- Operating temperature: from +5°C to +60°C
- Transportation and temporary storage temperature: from -30°C to +60°C



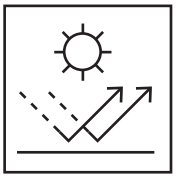
Relative air humidity 20–60%



Do not use the products in heavily contaminated or corrosive environments, or where they are in constant contact with water, ash, slag, cement, chemicals, organic substances, or similar materials.



Do not install furniture components near heating appliances or in locations where temperature and weather conditions are not controlled, such as outdoors without adequate protection from rain, snow, or other environmental exposure.



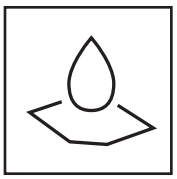
Avoid direct exposure to sunlight.



Do not use abrasive cleaning agents or solvents to clean the surfaces.



For furniture intended for high-humidity environments, it is recommended to use MDF or moisture-resistant laminated chipboard with PUR edge bonding or laser edge banding.



Protect the components from prolonged contact with water or other liquids. The moisture-resistant properties of panel materials and PUR adhesive do not prevent the components from swelling if exposed to moisture for an extended period.



Furniture components must be stored and transported in a horizontal position.

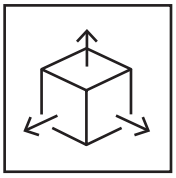


After removing the protective film from components made of Niemann or AGT panels, do not clean the surface for at least 72 hours.

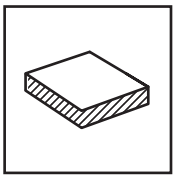
Warranty for manufactured furniture components

VIYAR, as the manufacturer of furniture components, hereby provides the purchaser with a warranty for products manufactured from wood-based panel materials (including chipboard, HDF, MDF, and similar materials) with respect to their technical specifications and supplied quantities.

✓ The warranty covers:



The dimensional accuracy of the components, the quality of cutting, edge banding, and any additional manufacturing services.



Edge banding, provided that it does not detach under proper transportation, storage, and operating conditions.

Warranty period for edge banding:

EVA edge banding – 3 years, PUR edge banding – 10 years, laser edge banding – 15 years.



The quantity of components and offcuts supplied in the order, in accordance with the «Specification» document. Claim submission period: within 14 days of receipt of the order.

✗ The warranty does not apply to products that:



Have been damaged during loading, unloading, transportation, handling, assembly, or installation.



Have been improperly stored or used in violation of the recommended operating and storage conditions.

Warranty claim procedure



Warranty claims are accepted only for furniture components that:

- Are within the applicable warranty period;
- Have not been subjected to improper transportation, storage, or operating conditions;
- Exhibit non-conformities exceeding the permissible manufacturing tolerances;
- Are accompanied by proof of purchase confirming payment for the order placed with our company.



To submit a warranty claim, please contact our Customer Support Center and provide the following information:

- Reason for the claim;
- Order (invoice) number;
- Component number(s);
- Quantity of affected components.



Rework is carried out under the following conditions:

- The customer provides the defective component(s);
- Only the defective component(s) will be reworked, not the entire order;
- Rework will be performed either by correcting the defect on the existing component or by manufacturing a replacement component;
- A replacement component can only be manufactured with the same dimensions as the original.



Rework lead time:

- 1–3 business days, depending on the complexity of the work;
- An additional 1–2 days may be required if the reworked components need to be transferred to another branch;
- The lead time may be extended if the required material is temporarily unavailable.

Goods that have been cut or processed to the dimensions specified by the buyer (customer) are not subject to exchange or return in accordance with Resolution №172 of the Cabinet of Ministers of Ukraine dated March 19, 1994.

An order is considered confirmed upon payment.