

# End of Product Life

Lounge Chairs

# KEILHAUER



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**Document Disclaimer:**

This document will be reviewed, updated periodically, and is subject to change without notice. Keilhauer is not responsible for slight deviations in the data and information contained in this document. Product recyclability and material content data is calculated using base models only. Textiles and associated weights are not accounted for in the analysis. Criteria for recyclability has been assessed against available recycling facilities in at least 6 of the 10 U.S. EPA regions. Average recyclability is based on individual component weights. Some Keilhauer parts are adhered together which can present challenges when disassembling.



## End of Product Life Introduction

Keilhauer lounge pieces create beautiful, relaxed spaces that foster easy conversation and quiet contemplation. Once your Keilhauer chair or component reaches the end of its life, the whole product doesn't have to end up in a landfill. Many of the parts and materials still have value, and can be repaired, replaced, or recycled to avoid an afterlife as waste.

This document provides instructions for component disassembly that can be applied to our Lounge chair collection. A detailed breakdown of components and the materials they are made of for each product follows the instructions, as well as an outline of how to recycle these components after disassembly. Disassembly should take between 30 - 60 minutes depending on the product and model. Safety glasses and safety gloves are recommended throughout the disassembly process.

# Repairability and Recyclability

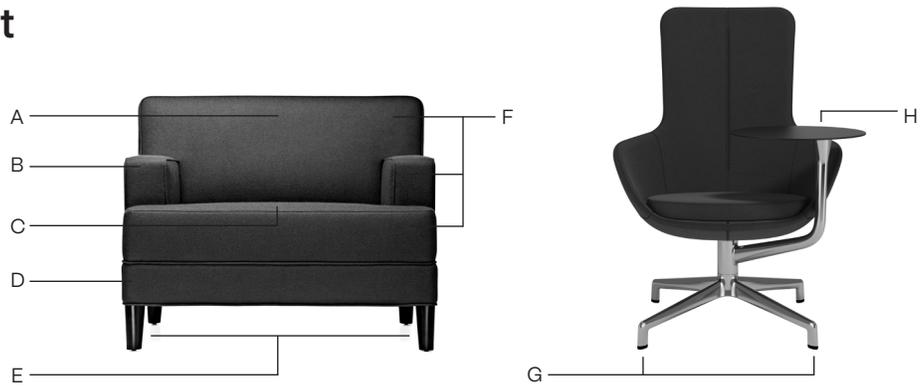
Keilhauer products are made to last a long and useful life, therefore products are component based and are designed with modularity in mind. We take pride in the extra steps we take to ensure that parts are indeed replaceable over time. We also ensure that we mean what we say with our 10 year Warranty Policy (see our Warranty Policy for more details).

Depending on the specific model and year, product parts can generally be easily repaired or simply replaced at home using standard tools. Some components are more complex and require the assistance of a trained Keilhauer Service Technician for replacement. For more details about your specific product, please contact our Warranty department.

The following are our standard components and general information on replaceability. For product specific details, please refer to the Materials & Components Table on pages 10 through 21.

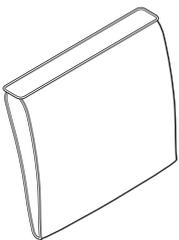
## Anatomy of a Product

- A. Back
- B. Arms / Arm Caps
- C. Seat
- D. Frame
- E. Legs
- F. Upholstery
- G. Glides
- H. Tablet



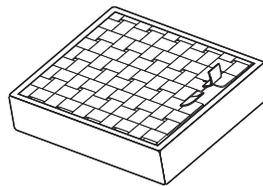
## Standard Components

### Back



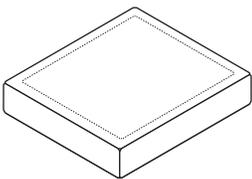
Depending on the model, entire upholstered seat units including the seat pan, foam and covering may be replaceable. Most loose cushion units are also replaceable. Note: depending on the specific product model assistance from a trained Keilhauer Representative may be required.

### Seat Decking



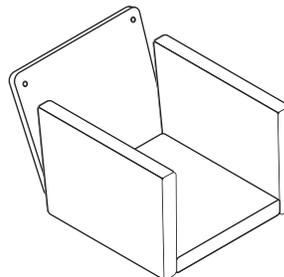
As this component is fixed within a larger unit, this specific component is not replaceable on its own.

### Seat



Depending on the model, entire upholstered seat units including the seat pan, foam and covering may be replaceable. Most loose cushion units are also replaceable. Note: depending on the specific product model assistance from a trained Keilhauer Representative may be required.

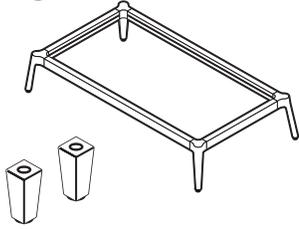
### Frame



As this component is fixed within a larger unit, this specific component is not replaceable on its own.

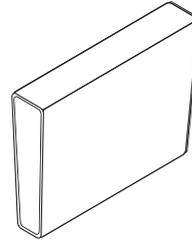
# Standard Components

## Legs



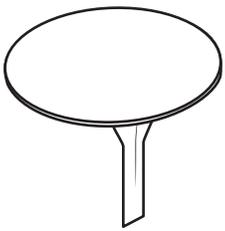
Depending on the specific model and year, Leg units are generally replaceable.

## Arms



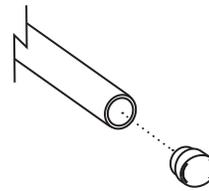
Arm units are usually within a larger unit and therefore are not generally replaceable on their own. Depending on the specific model and year, Arm caps may be replaceable.

## Tablet / Table



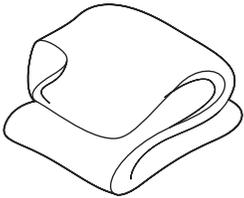
Depending on the specific model and year, tablets and tables units are generally replaceable.

## Glides



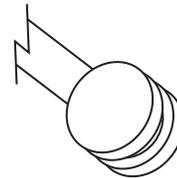
Depending on specific model and unit, glides are generally replaceable.

## Upholstery



Depending on the specific model, year and material availability, upholstery may be replaceable at Keilhauer facilities.

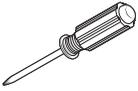
## Casters



Depending on specific model and unit, casters are generally replaceable.

# Tools Required

Screwdriver\*



Box Cutter



Needle Nose Pliers



Painter's Spatula



Adjustable Wrench or Socket Set\*



Safety Glasses



Safety Gloves

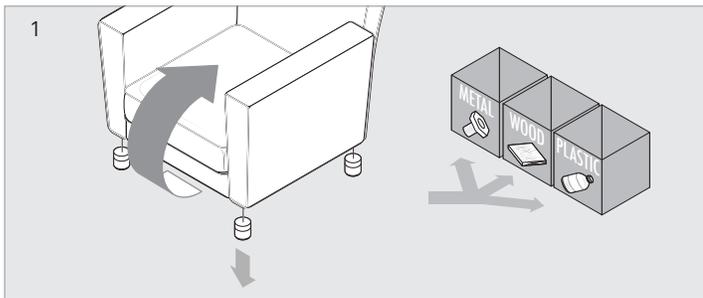


\*To determine the screwdriver type and bits required for each product refer to the Materials and Components Table on pages 10 through 21.

## Disassembly Instructions

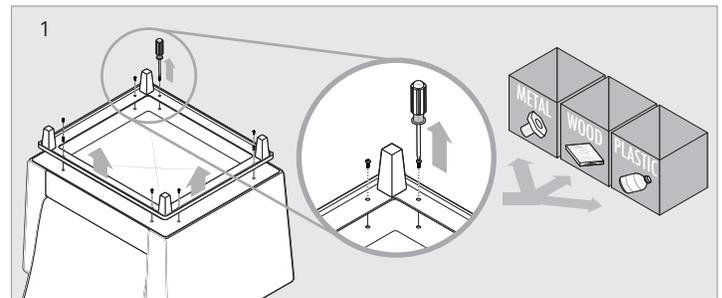
### Removing the legs

#### OPTION 1: Puck legs



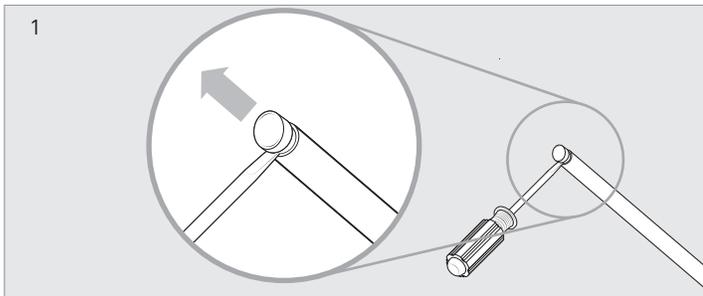
Place the seat upside down so that the legs are facing up. Pull off the puck leg component, put aside and refer to page 9 for recycling details.

#### OPTION 2: Frame legs

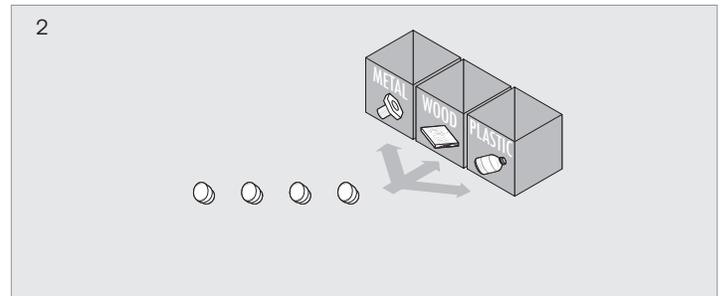


Place the product upside down so that all four legs are facing up. Locate all screws and remove using the corresponding screwdriver. Pull the base from the piece, set aside and refer to page 9 for recycling details.

### Removing the glides from the legs

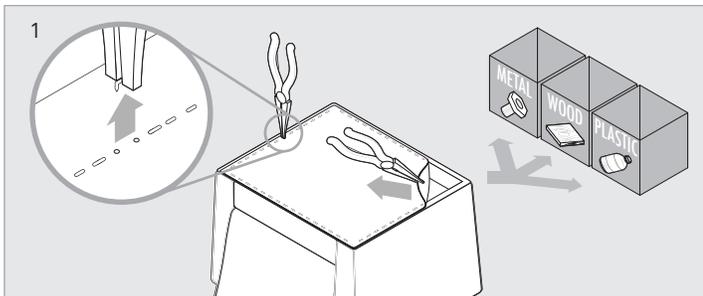


Using either pliers and/or a flat head screwdriver, wedge between the plastic glide and the leg and pop off the glide.



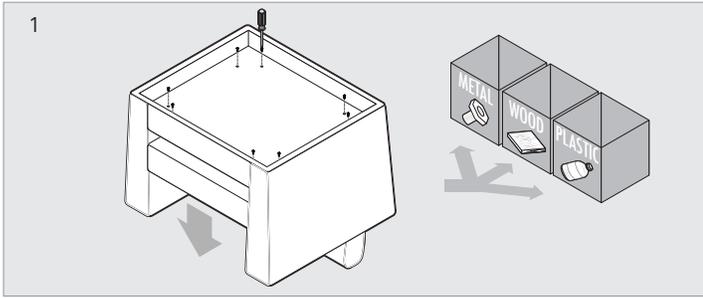
Set the glides aside and refer to page 9 for recycling details.

### Removing the dust cover from the base frame



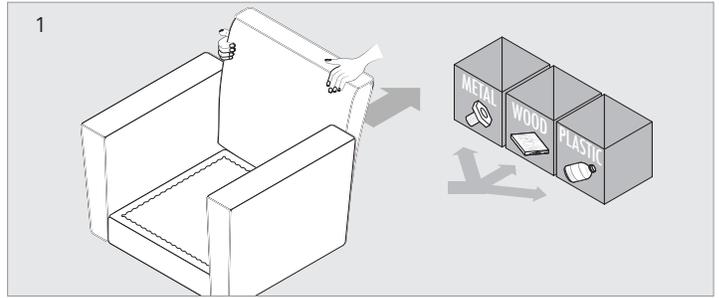
Using needle nose pliers, remove the staples from the base. Pull the black textile away from the base, set aside and refer to page 9 for recycling details.

## Removing the seat from the main frame



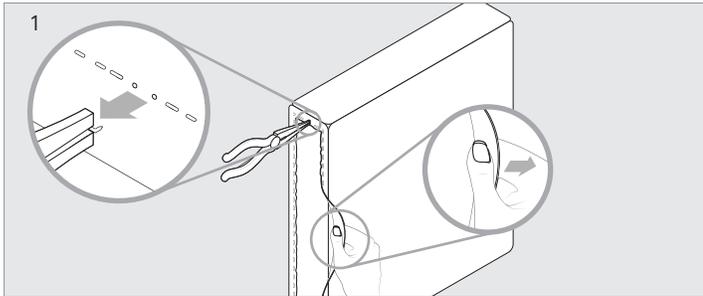
Once the dust cover is removed, the main frame of the product will be exposed. Locate and remove all visible screws to release the seat. Turn the product right side up, pull the seat off, set aside. For next steps, follow *Disassembly Instructions: Upholstered Seat/Back Cushion* instructions.

## Removing the back from the main frame

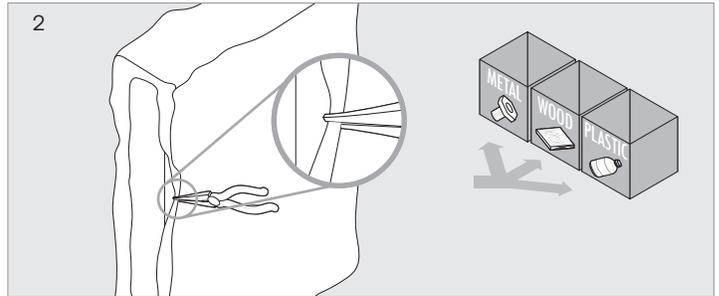


If the back is a separate component and is not sewn in, use some force to pull the back off the frame. Set aside for recycling. For next steps, follow *Disassembly Instructions: Upholstered Seat/Back Cushion* instructions.

## Removing upholstery and foam from the main frame

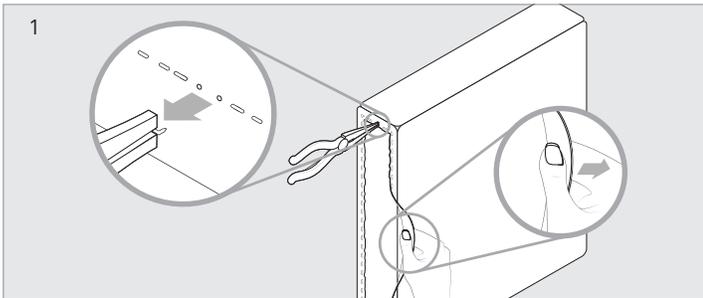


Turn the seat on its side. Using needle nose pliers, remove any staples from the frame. Using the pliers and/or box cutter, cut and pull the textile/leather/vinyl away from the frame. This will expose the foam on the frame. Set the textile/leather/vinyl aside and refer to page 9 for recycling details.

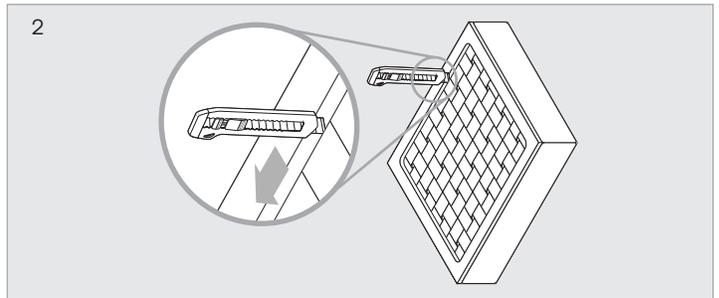


Using pliers, pull the foam away from the frame. Use a painter's spatula to remove excess foam from the wood. Set the foam, wood and textile aside and refer to page 9 for recycling details.

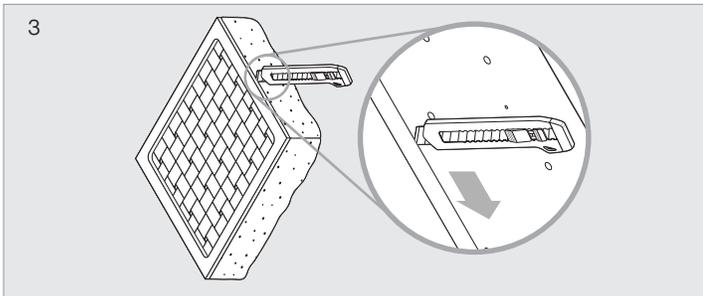
## Upholstered seat/back cushion disassembly instructions



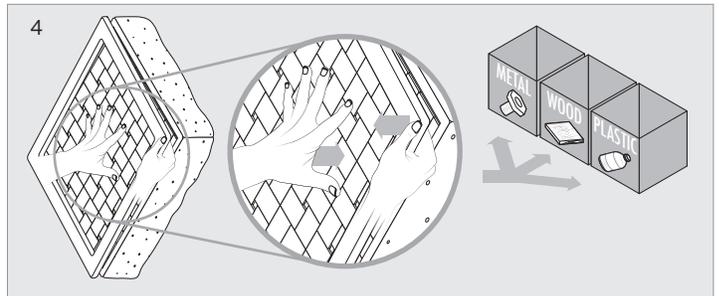
Using needle nose pliers, remove any staples from the frame. Using the pliers and/or box cutter, cut and pull the textile/leather/vinyl away from the frame. This will expose the foam on the frame. Set the textile/leather/vinyl aside and refer to page 9 for recycling details.



If there is webbing, use box cutters to cut the webbing on the inside of the frame.

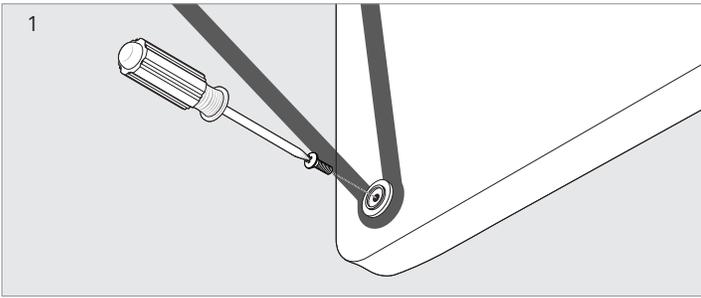


Once the inside webbing is cut from the wood frame, use box cutters to carefully cut the foam away from the wood frame.

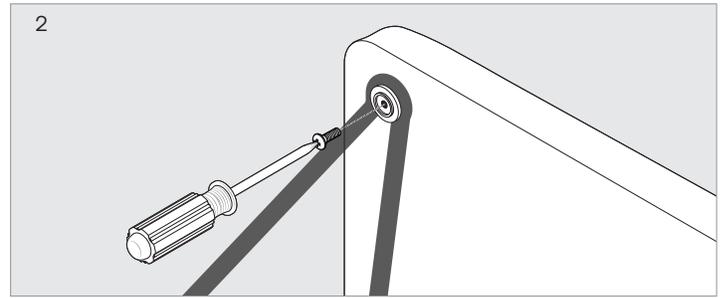


Holding the wood frame, use some force and push the webbing and foam through the center to release it from the frame. Use pliers to pull off any remaining webbing from the wood frame. Set the webbing, wood and foam aside and refer to page 9 for recycling details.

## \*Wheels, Chemistry and Talk only - Removing the frame legs from the main frame

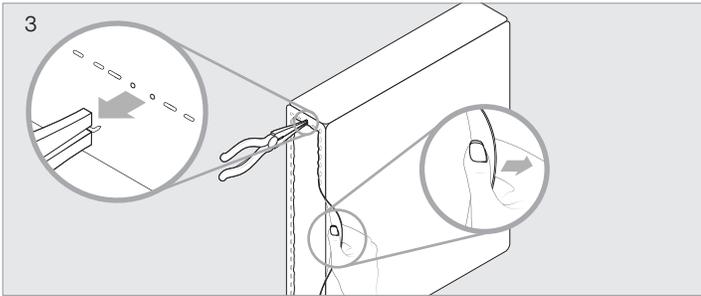


Place the product so that the base legs are facing up. Locate all screws and use a corresponding screwdriver to remove screws. Pull the base from the main frame, set aside and refer to page 9 for recycling details.

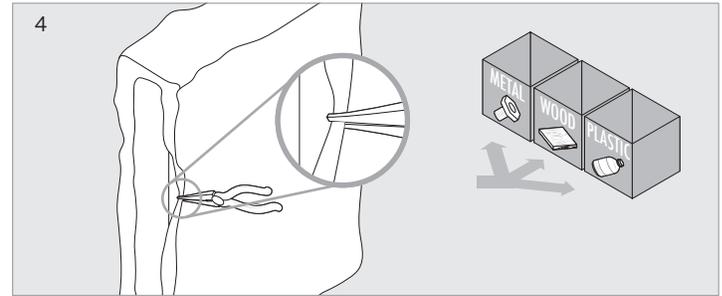


Locate all screws on the lower back area and use a screwdriver to remove screws. Pull the back from the seat frame, set aside and refer to page 9 for recycling details.

## Removing the textile and upholstery



Using needle nose pliers, remove any staples from the frame. Using the pliers and/or box cutter, cut and pull the textile/leather/vinyl away from the frame. This will expose the foam on the frame. Set the textile/leather/vinyl aside and refer to page 9 for recycling details.



Using pliers, pull the foam away from the frame. Use a painters spatula to remove excess foam from the wood. Refer to page 9 for recycling details.

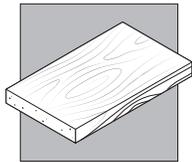
# Recycling the Disassembled Product

Our goal is Closed-Loop Manufacturing, and this extends to our product's end of useful life. Through our Design for Environment (DFE) program, we ensure that we design our products with high quality, long-lasting materials. We also aim to design them to be easily disassembled, and that the materials are recyclable across all municipalities.

Our efforts, along with the efforts of many municipalities across the globe have taken great strides towards environmentally responsible materials management. Still, some materials may or may not be fully recyclable in certain areas. The recyclability of a material depends on the volume available, whether there is an end market for the material, purity of the material (avoid coatings, mixed materials, etc.), and availability of recycling infrastructure (is there a collection method, a processing facility, etc.).

The following outline provides some basic information regarding the most common Keilhauer materials. For more information regarding recyclable materials in your area, please contact your local municipality or recycling company.

## WOOD



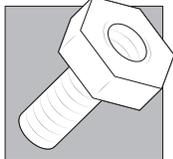
<b>Type:</b>	Hardwood, Plywood, MDF
<b>Recyclability:</b>	Recyclable
<b>Value:</b>	\$0 – \$1/board foot USD
<b>How to recycle:</b>	Contact local recycling companies or your local municipality.

## TEXTILE



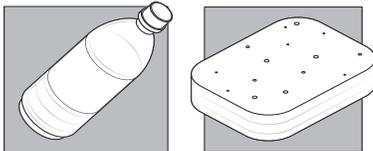
<b>Type:</b>	Leather, Nylon, Polyester
<b>Recyclability:</b>	Recyclable
<b>Value:</b>	Leather \$0.20/lb. – \$0.32/lb. USD Nylon \$0.06 – \$0.25/lb. USD Polyester \$0.06 – \$0.25/lb. USD
<b>How to recycle:</b>	Contact local recycling companies or your local municipality.

## METAL



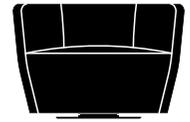
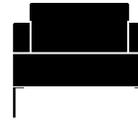
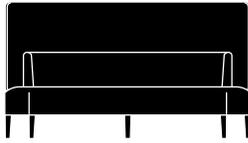
<b>Type:</b>	Steel, Aluminum, Zinc
<b>Recyclability:</b>	Recyclable
<b>Value:</b>	Steel \$0.50/lb. – \$0.60/lb. USD Aluminum \$0.65 – \$0.95/lb. USD Zinc \$0.42 – \$0.71/lb. USD
<b>How to recycle:</b>	Contact local scrap metal dealers, recycling companies or your local municipality.

## PLASTIC & FOAM



<b>Type:</b>	Acetal (POM), Acrylonitrile Butadiene Styrene (ABS), Glass-filled Polypropylene (PP-GF15), Glass-filled Nylon (PA-GF15, PA-GF27, and PA-GF30), Medium Impact Modified Nylon (PA6-MI), Medium Impact Modified Polypropylene (PP-MI), Nylon (PA), Polycarbonate (PC), Polyester (PEST), Polyethylene (PE and PE-HD), Polyurethane (PUR and PUR-HD), Polypropylene (PP), Styrene Butadiene/K-resin (SB), Thermoplastic Elastomer (PO-PE), Urethane (UR), Vinyl (V).
<b>Recyclability:</b>	ABS, PA, PE and PP – Widely recyclable POM, PP-GF15, PP-MI, PA6-MI, PA-GF15/27/30, PC, PEST, PO-PE, PUR, SB, UR, and V – Not commonly recyclable
<b>Value:</b>	\$0.06/lb. – \$0.35/lb. USD
<b>How to recycle:</b>	ABS, PA, PE and PP – Contact recycling companies or recycle through your municipality (if accepted) POM, PP-GF15, PP-MI, PA6-MI, PA-GF15/27/30, PC, PEST, PO-PE, PUR, SB, UR, and V – Contact local recycling companies.

# Materials and Components



Possible Components	141	BOXCAR	BRANDEN	CAHOOTS
<b>Upholstered Back</b>	Back: Plywood with polyurethane (PUR) foam Divider: Rigid polyurethane (PUR), soft polyurethane (PUR) and fiberboard	Engineered plywood with high density polyurethane (PUR-HD) foam <sup>2</sup>	Engineered plywood with high density polyurethane (PUR-HD) <sup>2</sup> foam	Plywood frame with polyurethane (PUR) foam <sup>2</sup>
<b>Upholstered Seat</b>	Plywood with polyurethane (PUR) foam	Engineered plywood with high density polyurethane (PUR-HD) foam	Engineered plywood with high density polyurethane (PUR-HD) foam	Plywood frame with polyurethane (PUR) foam
<b>Frame</b>	Engineered plywood	Engineered plywood	Engineered plywood	Engineered plywood
<b>Seat Decking</b>	N/A	Woven rubber	Woven rubber	Woven rubber
<b>Glides</b>	♻️ Steel	♻️ Plastic (Sofa: ABS, Chair: PE-HD).	Zinc	Meet and Mingle: Steel with plastic (PA) Swivel base: Plastic (ABS) Work chair: Plastic (PC)
<b>Arms</b>	N/A	Engineered plywood with high density polyurethane (PUR-HD) foam <sup>2</sup>	Engineered plywood with high density polyurethane (PUR-HD) <sup>2</sup> foam	Plywood frame with polyurethane (PUR) foam <sup>2</sup>
<b>Tablet/Table</b>	N/A	N/A	N/A	N/A
<b>Legs</b>	♻️ Solid ash or walnut wood	♻️ Steel	♻️ Steel frame legs	Steel (Swivel base)
<b>Disassembly Screwdriver(s)</b>	Quadrex, No. 2 Quadrex, No. 3 5/32" Hex bit 1/4" Hex bit 1/2" Socket	Quadrex Robertson 1/2" Socket 5/32" Hex bit	Quadrex Robertson 1/2" Socket	Quadrex 1/4" Hex bit 3/16" Hex bit
<b>Average Weight (kg)</b>	65.60	47.26	36.43	33.81
<b>Average Recyclability*</b>	74.96 %	78.21 %	82.12 %	86.06 %

\* See Document Disclaimer (p 2)

<sup>4</sup> Dependent on model

♻️ Component replaceable

<sup>5</sup> Trained Keilhauer Service Technician required

<sup>1</sup> 1 Back and seat are one unit

<sup>6</sup> Arms, back, seat, and frame are one unit

<sup>2</sup> Arms and back are one unit

<sup>7</sup> Arms and seat are one unit

<sup>3</sup> Only cushions can be replaced



Possible Components	CANAL	CELIA	COY	DALLY
<b>Upholstered Back</b>	Hardwood with high density polyurethane (PUR-HD) foam <sup>2</sup>	Rigid and flexible polyurethane (PUR) foam	Back: Rigid polyurethane (PUR), steel, and plywood overmolded with flexible polyurethane (PUR) <sup>6</sup> Cushions: Plywood with cut polyurethane (PUR) foam	N/A
<b>Upholstered Seat</b>	↻ Hardwood with high density polyurethane (PUR-HD) foam	Rigid and flexible polyurethane (PUR) foam	Back: Rigid polyurethane (PUR), steel, and plywood overmolded with flexible polyurethane (PUR) <sup>6</sup> Cushions: Plywood with cut polyurethane (PUR) foam	↻ CFC Free molded polyurethane flex foam
<b>Frame</b>	Hardwood	Steel	Rigid polyurethane (PUR) with steel	3/4" engineered plywood
<b>Seat Decking</b>	Woven rubber	N/A	N/A	N/A
<b>Glides</b>	↻ Plastic (PE-HD)	↻ Plastic (PA-MI)	↻ Plastic (PA)	↻ Nylon
<b>Arms</b>	Hardwood with high-density polyurethane (PUR-HD) foam <sup>2</sup>	N/A	Rigid polyurethane (PUR) overmolded with flexible polyurethane (PUR) <sup>6</sup>	N/A
<b>Tablet/Table</b>	N/A	N/A	N/A	N/A
<b>Legs</b>	↻ Steel	↻ Steel	↻ Solid ash or walnut wood	N/A
<b>Disassembly Screwdriver(s)</b>	Quadrex Robertson	Quadrex	Quadrex, No. 2 Square, No. 2 3/16" Hex bit 5/32" Hex bit	N/A
<b>Average Weight (kg)</b>	47.02	21.79	12.66	7.49
<b>Average Recyclability*</b>	86.43 %	55.68 %	77.85 %	94.57%

\* See Document Disclaimer (p 2)

<sup>4</sup> Dependent on model

↻ Component replaceable

<sup>5</sup> Trained Keilhauer Service Technician required

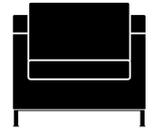
<sup>1</sup> 1 Back and seat are one unit

<sup>6</sup> Arms, back, seat, and frame are one unit

<sup>2</sup> Arms and back are one unit

<sup>7</sup> Arms and seat are one unit

<sup>3</sup> Only cushions can be replaced



Possible Components	DANBER	DARIO	DOKO	DOON
<b>Upholstered Back</b>	Back: Steel and plywood overmolded with cut polyurethane (PUR) foam <sup>2</sup> Cushions: Polyester (PEST) fill <sup>3</sup>	♻️ Engineered plywood with high density polyurethane (PUR-HD) foam <sup>2,3,5</sup>	Hardwood with high-density polyurethane (PUR-HD) foam	♻️ Engineered plywood with high density polyurethane (PUR-HD) foam <sup>2,3,5</sup>
<b>Upholstered Seat</b>	♻️ Plywood overmolded with cut polyurethane (PUR) foam <sup>3</sup>	♻️ Engineered plywood with high density polyurethane (PUR-HD) foam	Hardwood with high density polyurethane (PUR-HD) foam	Engineered plywood with high density polyurethane (PUR-HD) foam
<b>Frame</b>	Plywood, Steel	Engineered plywood, steel	Hardwood	Engineered plywood, steel
<b>Seat Decking</b>	Plywood	Woven rubber	Woven rubber	Woven rubber
<b>Glides</b>	N/A	♻️ Plastic (PE)	N/A	Plastic (PE)
<b>Arms</b>	Steel and plywood overmolded with flexible polyurethane (PUR) <sup>2</sup>	Engineered plywood with high density polyurethane (PUR-HD) foam <sup>2,3,5</sup>	N/A	Engineered plywood with high density polyurethane (PUR-HD) foam <sup>2,3,5</sup>
<b>Tablet/Table</b>	N/A	N/A	Steel with overmolded polyurethane (PUR)	N/A
<b>Legs</b>	♻️ Solid ash or walnut wood	♻️ Steel	Aluminum	Steel
<b>Disassembly Screwdriver(s)</b>	Quadrex, No. 10 Quadres, No. 14 Phillips Drive, No. 10 Robertson, No. 10 1/4" Hex bit 5/16" Hex bit	Quadrex 1/2" Socket	Quadrex 1/2" Socket	Quadrex 1/2" Socket
<b>Average Weight (kg)</b>	78.30	59.10	10.65	42.66
<b>Average Recyclability*</b>	60.37%	75.28 %	17.08 %	83.44 %

\* See Document Disclaimer (p 2)

<sup>4</sup> Dependent on model

♻️ Component replaceable

<sup>5</sup> Trained Keilhauer Service Technician required

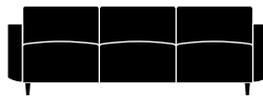
<sup>1</sup> 1 Back and seat are one unit

<sup>6</sup> Arms, back, seat, and frame are one unit

<sup>2</sup> Arms and back are one unit

<sup>7</sup> Arms and seat are one unit

<sup>3</sup> Only cushions can be replaced



Possible Components	ELECTRIC	EGLINTON	ELLABY	FORSI
<b>Upholstered Back</b>	Engineered plywood with cut polyurethane (PUR) foam	↻ Hardwood with high-density polyurethane (PUR-HD) foam	↻ Back: Rigid polyurethane (PUR), steel, and plywood overmolded with flexible polyurethane (PUR) <sup>6</sup> Cushions: Plywood with cut polyurethane (PUR) foam	Polyurethane (PUR) foam, molded over steel rod and plate.
<b>Upholstered Seat</b>	Engineered plywood with expanded polyurethane (PUR) foam	↻ Hardwood with high density polyurethane (PUR-HD) foam	Back: Rigid polyurethane (PUR), steel, and plywood overmolded with flexible polyurethane (PUR) <sup>6</sup> Cushions: Plywood with cut polyurethane (PUR) foam	↻ Thermoplastic standard blend used is 50% consumer and 50% post industrial PP/PE and CFC Free Polyurethane Flex Foam
<b>Frame</b>	Steel	Hardwood	Rigid polyurethane (PUR) with steel	Steel
<b>Seat Decking</b>	N/A	Woven rubber	N/A	
<b>Glides</b>	FCI Glide 5/8 DIA OD	N/A	↻ Plastic (PA)	N/A
<b>Arms</b>	N/A	N/A	Rigid polyurethane (PUR) overmolded with flexible polyurethane (PUR) <sup>6</sup>	N/A
<b>Tablet/Table</b>	N/A	N/A	N/A	N/A
<b>Legs</b>	Steel	Steel	↻ Solid ash or walnut wood	↻ Steel and aluminum
<b>Disassembly Screwdriver(s)</b>	M5 Hex Key Drive Roberston, No. 2 3/16" Allen Hex Bit	3/16" Hex bit Flathead	Quadrex, No. 2 Square, No. 2 3/16" Hex bit 5/32" Hex bit	5/32" Hex Allen Key 1/8" Hex Allen Key
<b>Average Weight (kg)</b>	51.7	33.94	27.03	13.19
<b>Average Recyclability*</b>	81.73 %	76.95 %	55.62 %	71.97%

\* See Document Disclaimer (p 2)

<sup>4</sup> Dependent on model

↻ Component replaceable

<sup>5</sup> Trained Keilhauer Service Technician required

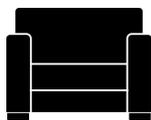
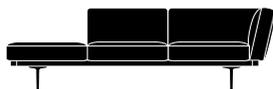
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<sup>6</sup> Arms, back, seat, and frame are one unit

<sup>2</sup> Arms and back are one unit

<sup>7</sup> Arms and seat are one unit

<sup>3</sup> Only cushions can be replaced



Possible Components	GARNER	GRAND	GSD	JUMBLE
<b>Upholstered Back</b>	↻ Engineered plywood with high density polyurethane (PUR-HD) foam <sup>2</sup>	↻ Engineered plywood with high density polyurethane (PUR-HD) foam <sup>6</sup>	CFC Free Polyurethane Cut Foam with Plywood Panel	Engineered plywood with high density polyurethane (PUR-HD) foam
<b>Upholstered Seat</b>	↻ Engineered plywood with high density polyurethane (PUR-HD) foam	Engineered plywood with high density polyurethane foam <sup>6</sup>	CFC Free Polyurethane Cut Foam with Plywood Panel	Engineered plywood with high density polyurethane (PUR-HD) foam
<b>Frame</b>	Aluminum	Engineered plywood	Steel	Engineered plywood, aluminum
<b>Seat Decking</b>	N/A	Woven rubber		N/A
<b>Glides</b>	↻ Plastic (SB)	↻ Plastic (PE)	N/A	↻ Plastic (PE-HD)
<b>Arms</b>	Engineered plywood with high density polyurethane (PUR-HD) foam <sup>2</sup>	Engineered plywood with high density polyurethane (PUR-HD) foam <sup>6</sup>	↻ Aluminum bracket, CFC-Free Polyurethane Foam, Plywood	N/A
<b>Tablet/Table</b>	Laminated/veneered MDF, or quartz	N/A	N/A	Painted MDF
<b>Legs</b>	↻ Aluminum	↻ Steel	Steel and aluminum	N/A
<b>Disassembly Screwdriver(s)</b>	3/16" Hex bit	Quadrex 1/2" Socket	5/32" Hex Allen Key 1/8" Hex Allen Key 3/16" Hex Allen Key #14 Wrench	Quadrex 1/8" Hex bit
<b>Average Weight (kg)</b>	77.49	55.52	53.02	25.42
<b>Average Recyclability*</b>	78.50%	67.58%	88.97%	88.10 %

\* See Document Disclaimer (p 2)

<sup>4</sup> Dependent on model

↻ Component replaceable

<sup>5</sup> Trained Keilhauer Service Technician required

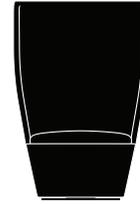
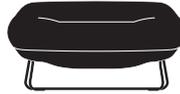
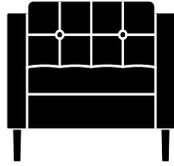
<sup>1</sup> 1 Back and seat are one unit

<sup>6</sup> Arms, back, seat, and frame are one unit

<sup>2</sup> Arms and back are one unit

<sup>7</sup> Arms and seat are one unit

<sup>3</sup> Only cushions can be replaced



Possible Components	K-MODERN	LO	LULL	LUNO
<b>Upholstered Back</b>	Engineered plywood with high density polyurethane (PUR-HD) foam <sup>2</sup>	N/A	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR)	Outer shell: Rigid polyurethane (PUR) with fiberglass inlay Back: Rigid polyurethane (PUR) with fiberglass inlay molded over with flexible polyurethane (PUR)
<b>Upholstered Seat</b>	Engineered plywood with high density polyurethane (PUR-HD) foam	↻ Rigid polyurethane (PUR) foam with down cushion	Plywood frame with polyurethane (PUR) foam	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR)
<b>Frame</b>	Engineered plywood	Steel	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR)	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR)
<b>Seat Decking</b>	Woven rubber	N/A	N/A	N/A
<b>Glides</b>	↻ Steel tacks on wood legs	↻ Plastic (PC)	Plastic (ABS)	↻ Plastic (SB)
<b>Arms</b>	Engineered plywood with high density polyurethane (PUR-HD) foam <sup>2</sup>	N/A	N/A	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR)
<b>Tablet/Table</b>	N/A	N/A	N/A	N/A
<b>Legs</b>	↻ Steel or wood	↻ Steel	Swivel base: Steel	Aluminum base: Aluminum Wood base: Steel base with wood caps
<b>Disassembly Screwdriver(s)</b>	Quadrex Robertson 1/2" Socket	5/32" Hex bit	1/4" Hex bit	3/16" Hex bit 5/32" Hex bit Quadrex
<b>Average Weight (kg)</b>	46.66	7.00	49.38	20.97
<b>Average Recyclability*</b>	90.33 %	36.18 %	52.45 %	36.17 %

\* See Document Disclaimer (p 2)

<sup>4</sup> Dependent on model

↻ Component replaceable

<sup>5</sup> Trained Keilhauer Service Technician required

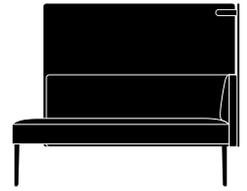
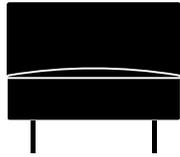
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<sup>2</sup> Arms and back are one unit

<sup>7</sup> Arms and seat are one unit

<sup>3</sup> Only cushions can be replaced



Possible Components	MEANDER	OPT	ORO	PACT
<b>Upholstered Back</b>	Engineered plywood with cut polyurethane (PUR) foam	Rigid and flexible polyurethane (PUR) foam <sup>5</sup>	Steel overmolded with polyurethane (PUR-HD) foam <sup>1</sup>	Plywood with polyurethane (PUR) foam <sup>2</sup> Divider: PET Felt
<b>Upholstered Seat</b>	Engineered plywood with expanded polyurethane (PUR) foam	Rigid and flexible polyurethane (PUR) foam <sup>6</sup>	Steel overmolded with polyurethane (PUR-HD) foam <sup>1</sup>	Polyurethane (PUR) foam
<b>Frame</b>	Engineered plywood, steel spring coils	Rigid and flexible polyurethane (PUR) foam <sup>6</sup>	Steel	Plywood
<b>Seat Decking</b>	N/A	N/A	N/A	Plywood
<b>Glides</b>	N/A	Plastic (PA)	↻ Plastic (PA)	↻ Plastic (PA)
<b>Arms</b>	Engineered plywood with cut polyurethane (PUR) foam	Rigid and flexible polyurethane (PUR) foam <sup>3</sup>	Plastic (PA)	Plywood and rigid polyurethane (PUR) with woven rubber and flexible polyurethane (PUR) foam <sup>2</sup>
<b>Tablet/Table</b>	N/A	N/A	N/A	Urethane: Steel with overmolded Urethane (UR) Laminate: Laminated MDF
<b>Legs</b>	Steel	↻ Solid ash or walnut wood	↻ Solid ash or walnut wood	↻ Aluminum
<b>Disassembly Screwdriver(s)</b>	5 mm Hex bit	Square, No. 2 3/16" Hex bit 5/32" Hex bit	1/8" Hex bit	Hex bit set
<b>Average Weight (kg)</b>	26.16	16.46	12.13	41.34
<b>Average Recyclability*</b>	65.64 %	34.12 %	93.15 %	75.11 %

\* See Document Disclaimer (p 2)

<sup>4</sup> Dependent on model

↻ Component replaceable

<sup>5</sup> Trained Keilhauer Service Technician required

<sup>1</sup> 1 Back and seat are one unit

<sup>6</sup> Arms, back, seat, and frame are one unit

<sup>2</sup> Arms and back are one unit

<sup>7</sup> Arms and seat are one unit

<sup>3</sup> Only cushions can be replaced



Possible Components	PARLEZ	PLUNK	PONDER	SETLE
<b>Upholstered Back</b>	Plywood with polyurethane (PUR) foam <sup>2</sup>	N/A	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR) <sup>6</sup>	Plywood with molded polyurethane (PUR) foam
<b>Upholstered Seat</b>	Plywood with polyurethane (PUR) foam	Polyurethane (PUR) foam	Chair/Stool: See upholstered back material Ottoman: Plywood insert molded over with flexible polyurethane (PUR)	Plywood with molded polyurethane (PUR) foam
<b>Frame</b>	Steel	Wood	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR) <sup>6</sup>	↻ Steel
<b>Seat Decking</b>	N/A	N/A	N/A	↻ Woven rubber
<b>Glides</b>	↻ Plastic (SB)	Plastic (PE)	4-Leg: Plastic (PA) 4-Star: Aluminum Sled/Wire Base: Plastic (PC) or felt	Plastic (ABS)
<b>Arms</b>	↻ Plywood with polyurethane (PUR) foam <sup>2</sup>	N/A	N/A	Plywood with molded polyurethane (PUR) foam
<b>Tablet/Table</b>	Laminated/veneered MDF, or quartz	N/A	N/A	N/A
<b>Legs</b>	↻ Aluminum	N/A	↻ 4-leg: Wood ↻ 4-star: Aluminum ↻ Sled: Steel	N/A
<b>Disassembly Screwdriver(s)</b>	Quadrex, No. 2 3/32" Hex bit 1/8" Hex bit 3/16" Hex bit 5/32" Hex bit	N/A	5/32" Hex bit 1/8" Hex bit 3/16" Hex bit 1/4" Hex bit Robertson	5/32" Hex bit 1/2" Socket Wrench
<b>Average Weight (kg)</b>	67.77	4.60	9.88	46.30
<b>Average Recyclability*</b>	81.25 %	8.69 %	40.76 %	80.27 %

\* See Document Disclaimer (p 2)

<sup>4</sup> Dependent on model

↻ Component replaceable

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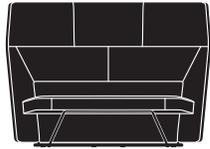
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<sup>7</sup> Arms and seat are one unit

<sup>3</sup> Only cushions can be replaced



Possible Components	TALK	VAGABOND	VERGE	VISIT BENCHES
<b>Upholstered Back</b>	↻ Steel, engineered plywood with high density polyurethane (PUR-HD) foam	N/A	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR) <sup>2</sup>	Plywood with cut polyurethane (PUR) foam
<b>Upholstered Seat</b>	↻ Steel, engineered with high-density polyurethane (PUR-HD)	CFC Free molded polyurethane flex foam	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR) <sup>2</sup>	Wood molded with polyurethane (PUR) foam
<b>Frame</b>	↻ Steel, engineered plywood base	↻ 3/4" engineered plywood	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR) <sup>2</sup>	Steel
<b>Seat Decking</b>	N/A	N/A	N/A	N/A
<b>Glides</b>	↻ Plastic (SB)	Plastic	↻ Plastic (SB)	↻ Plastic (PA)
<b>Arms</b>	N/A	N/A	Rigid polyurethane (PUR) with fiberglass inlay, molded over with flexible polyurethane (PUR) <sup>2</sup>	Plywood with cut polyurethane (PUR) foam
<b>Tablet/Table</b>	N/A	N/A	N/A	Laminated MDF
<b>Legs</b>	↻ Steel	N/A	Aluminum base: Aluminum Wood base: Steel and Aluminum base with solid ash or walnut wood	↻ Solid ash wood
<b>Disassembly Screwdriver(s)</b>	1/2" Hex bit 1/4" Hex bit 3/16" Hex bit 5/32" Hex bit 1/8" Hex bit 1/2" Socket Quadrex	N/A	Quadrex, No. 8 Quadrex, No. 10 1/4" Hex bit 5/16" Hex bit 1/4" Hex bit	3/16" Hex bit 5/32" Hex bit 1/4" Hex bit Robertson
<b>Average Weight (kg)</b>	48.94	6.30	32.57	68.04
<b>Average Recyclability*</b>	79.85 %	8.13%	40.45 %	86.00 %

\* See Document Disclaimer (p 2)

<sup>4</sup> Dependent on model

↻ Component replaceable

<sup>5</sup> Trained Keilhauer Service Technician required

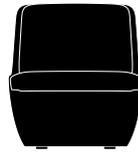
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<sup>7</sup> Arms and seat are one unit

<sup>3</sup> Only cushions can be replaced



Possible Components	VISIT SOFAS	WUNDER
<b>Upholstered Back</b>	Steel molded with polyurethane (PUR) foam, plywood	Steel and plywood with molded polyurethane(PUR) foam <sup>2</sup>
<b>Upholstered Seat</b>	Wood molded with polyurethane (PUR) foam	Side chair: Rigid polyurethane (PUR), molded over with flexible polyurethane (PUR) foam <sup>2</sup> Lounge chair: Plywood with molded flexible polyurethane (PUR) foam
<b>Frame</b>	Steel	Steel, and rigid polyurethane (PUR) with fiberglass inlay <sup>2</sup>
<b>Seat Decking</b>	N/A	N/A
<b>Glides</b>	↻ Plastic (PA)	↻ Plastic (PA)
<b>Arms</b>	N/A	N/A
<b>Tablet/Table</b>	N/A	N/A
<b>Legs</b>	Solid ash wood	↻ Aluminum base: Aluminum Wood base: Solid ash or walnut wood
<b>Disassembly Screwdriver(s)</b>	3/16 " Hex bit 5/32" Hex bit 1/4" Hex bit Quadrex	Quadrex 1/4" Hex bit Robertson
<b>Average Weight (kg)</b>	62.69	25.25
<b>Average Recyclability*</b>	49.64 %	51.15%

\* See Document Disclaimer (p 2)

↻ Component replaceable

<sup>1</sup> 1 Back and seat are one unit

<sup>2</sup> Arms and back are one unit

<sup>3</sup> Only cushions can be replaced

<sup>4</sup> Dependent on model

<sup>5</sup> Trained Keilhauer Service Technician required

<sup>6</sup> Arms, back, seat, and frame are one unit

<sup>7</sup> Arms and seat are one unit

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