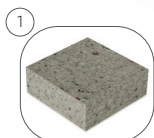
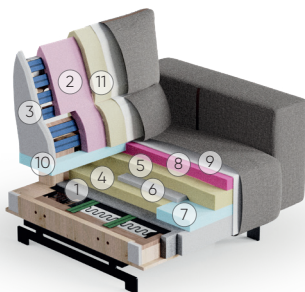


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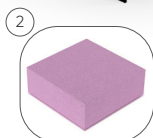
#checklist

# Aria

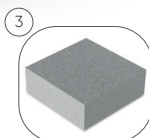
Time to explore the  
technical specifications of  
Aria.



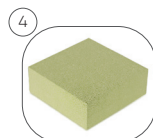
1 cm  $60 \text{ kg/m}^3$   
Felt



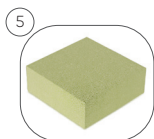
CNC-Cut  
 $25 \text{ kg/m}^3$   
Super Soft Foam



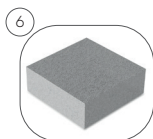
3 cm  $26 \text{ kg/m}^3$   
PU Foam



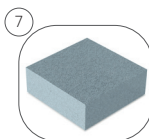
5 cm  $35 \text{ kg/m}^3$   
HR Foam



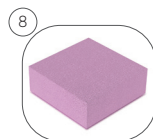
7 cm  $25 \text{ kg/m}^3$   
HR Sünger



2 cm  $26 \text{ kg/m}^3$   
PU Foam



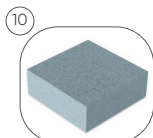
5 cm  $45 \text{ kg/m}^3$   
HLB Foam



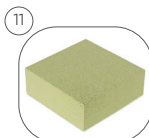
5 cm  $35 \text{ kg/m}^3$   
HR Soft Foam



$200 \text{ gr/m}^2$   
Fiber



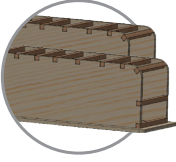
3 cm  $45 \text{ kg/m}^3$   
HLB Foam



5 cm  $35 \text{ kg/m}^3$   
HYPER Soft  
Foam

## KONSTRÜKSİYON

Plywood, beech wood, and MDF are used in the framework as the main construction of the sofa.



(Image 1-1)

Plywood, a high-strength (36 N/mm<sup>2</sup>) layered wood material produced in accordance with EN 636 standards, is obtained by the alignment of wood layers and fibers of around 1.5 mm thickness vertically and pressing with resin followed by cutting in CNC machinery with high precision. (Image 1-1)

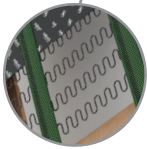
Prime quality beech wood boards of 2x2 cm, 5x2 cm and 7x2.5 cm, kiln-dried and cured for minimum 1 year with relative humidity of 10% or lower are used.



(Image 1-2)

We assemble MDF (Medium Density Fiberboard) of 3 mm thickness, a layer material increasing strength at the back and on the sides of our products to build a box structure.

D3-norm water-based PVAc wood glue with high adhesion strength in accordance with EN 204 standards is used in all joints of wooden components in the framework. In order to improve strength and durability, components of the framework are joined by a notched joining system. (Image 1-1) / (Image 1-2)



(Image 1-3)

Elastic columns with elasticity by 60% and a tensile strength by 350 kg as obtained by weaving polyester threads are used around zigzag springs, manufactured in a special heat treatment furnace to provide extra stiffness, and a total of 105 triple rubber fibers with a width by 7 cm so as to ensure ergonomics and comfort in seating. (Image 1-3)

Plastic materials of various dimensions are used in corners and edges in the framework in order to reduce rigidity and improve aesthetics after furnishing.

## MECHANISM



The DSS32-10 backrest mechanism is used in the Aria model, increasing the seating depth by 31 cm. It provides a deeper seating position and enables the sofa to convert into a bed.

Our mechanism is manufactured using 4 mm thick DKP, HRP, and 6220 sheet metal materials, precisely formed on CNC laser machines and coated with textured electrostatic powder paint.

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## FOAM

A 1 cm thick felt layer made from 100% recycled polyester with a density of 60 kg/m<sup>3</sup> is applied to the bottom layer of the seat as a supportive base. (Image 2-1)

The main seating cushion consists of 7+5 cm thick HR (High Resilience) foam with a density of 35 kg/m<sup>3</sup>, while the top comfort layer features CNC-cut, flexible and soft HR Soft foam with the same density and a thickness of 5 cm.

A CNC-cut soft comfort foam with a density of 25 kg/m<sup>3</sup> is applied to cover both the upper and front sections of the backrest.

A 3 cm thick HYPER Soft comfort foam with a density of 25 kg/m<sup>3</sup> is applied to cover the front section of the backrest.

As the top layer covering the entire seat, a first-class, non-laminated 100% polyester fiber (200 g/m<sup>2</sup>), produced as nonwoven using thermal and chemical bonding methods, is used.

As the top layer covering the entire backrest, a first-class, non-laminated 100% polyester fiber (500 g/m<sup>2</sup>), produced as nonwoven using thermal and chemical bonding methods, is used.

To prevent excessive softening and sagging of the sofa front under heavy use, and to ensure a more aesthetically pleasing front upholstery appearance, a 5 cm thick, 20 cm wide HLB barrier foam strip (45 kg/m<sup>3</sup>) is applied to the front section of the seat.



(Image 2-1)

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## FITTINGS & LOAD-BEARING SYSTEMS

A 20×30×1.2 mm electrostatic powder-coated metal connector profile is used to join the modules and for leg assembly.

The Aria model features laser-cut, 8 mm thick, electrostatic powder-coated metal legs, with protective plastic glides underneath to prevent floor damage and slipping.

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## APPLICATIONS FOR STRENGTH AND DURABILITY

During R&D activities, the products are subject to seating tests for 30,000 seating instances on average.

Foam with thickness increased by 30% to 50% and density increased by 20% to 30% is used in the seat cushion of the conventional products of 100 kg.

Recycled material (felt) is used to replace 12% of foam material. Eco-friendly materials with reduced carbon footprint are used. More than 18% of the product consists of wooden material.

Materials with increased durability by 50% to 100% with wider surface area and having a higher load-bearing capacity are used as fittings.

Factors such as structure, construction, production, shipment, assembly at home, including children jumping on the product, have been taken into consideration from design and production stages to all the way up to the finished product.

A mixed padding and fine woven lining are used in backrest cushion and throw pillows. The current mixed padding is more durable compared to other conventional padding materials.

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## **FABRIC & SEAMS**

Fabrics of the manufacturers carrying out production processes in line with international quality standards are used in all our sofas.

Each lot of our fabrics is subject to all required physical and chemical testing in accordance with the applicable standards, especially including EN ISO 12947-2, EN ISO 13936-2, EN ISO 13937-3, EN ISO 13934-1, EN ISO 14704-1 standards, and fabrics with high Martindale wear (50.000 cycles and above), pile loss (10,000 cycles and above), pilling (5 and above), tear strength (40 N and above) are used.

Average fabric weights are 725 g/m<sup>2</sup> in nubuck series, 450 g/m<sup>2</sup> in woven series, and 325 g/m<sup>2</sup> in velvet series (according to EN 12127).

No. 30, 80 tex low-flexibility, high-strength (5200 cN) lubricated continuous filament polyester threads are used as assembly seam.

No. 20, 135 tex, high-strength (9500 cN) nylon 6.6 threads are used as blind stitches used to improve strength and for aesthetic purposes.

Our sewing threads are certified by Oeko-Tex Standard 100.

In order to maximize sewing strength, assembly seams are used in every 3 mm of length while blind stitches are used in every 5 mm of length and 5 mm in width.