

WORK INSTRUCTION
LATEX FOAM INTERNATIONAL, LLC

W10-40-03-00 Mattress Inspection
Standards - Rolled Molded Finished
Goods
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Initiation Date: 6 April 2004

Revision Date: NEW

Changes from previous revision:

---NEW---

This document details the inspection standard for all mattress products.

All products that are designated to be sold as a molded finished good should be inspected to this standard. When a product is defined as first quality as per this standard, a Molded finished goods label (Form F60-090) should be placed on the finished package next to the roll pack label. Each end of the rolled core should receive a molded finished goods label.

POOR FILL

- **Definition:** This is a mattress missing material from the edge
- **Acceptance Criteria:**
 - 1st Quality:
 - the area of poor filled must be less than ¾" deep
 - Each area of poor fill cannot be more than 6 inches long
 - There can be no more than 2 of the above areas on each side of the core, and no more than 4 of these areas total on the core
 - To be repaired:
 - If not acceptable for first quality, the product is repaired by cutting off the affected area and gluing on a new piece. Refer to the maximum allowable seam specification

DISCOLORATION

- **Definition:** Stains or sections of different tones
- **Acceptance Criteria:**
 - 1st Quality
 - Place a pillow tick over the affected area:
 - If the discolored area is not visible, the core is acceptable for first quality
 - If the discolored area is slightly visible through the pillow tick, allowed as first quality as long as the area is less than 9 square inches (3" x 3"), and there are less than 3 such areas on the surface of the core.
 - To be repaired:

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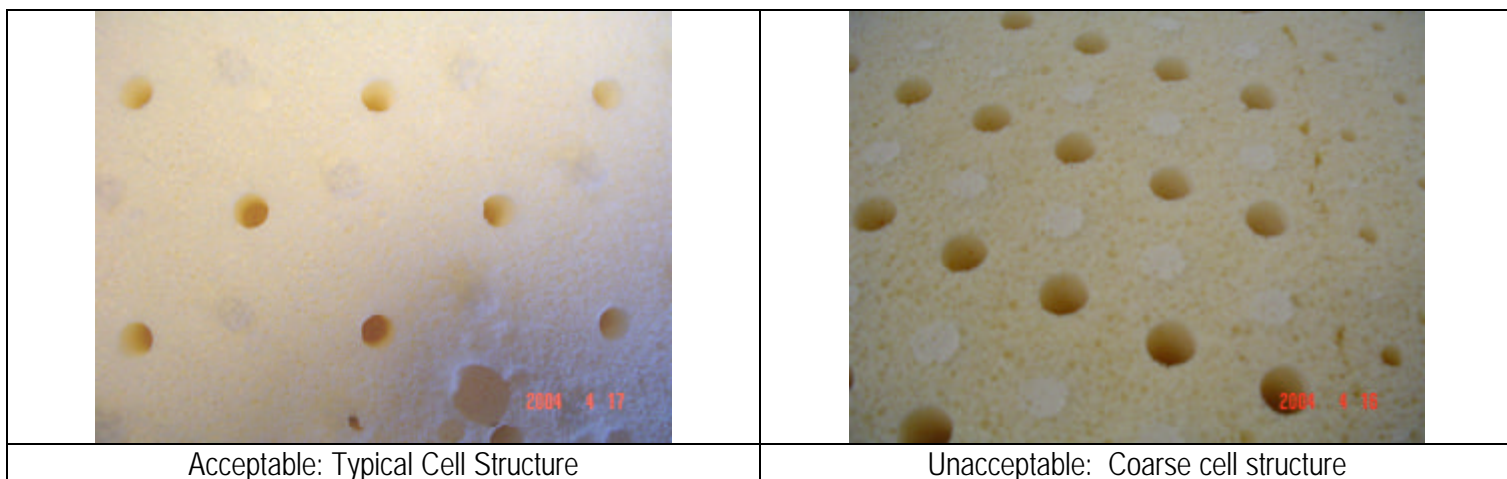
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- If not acceptable for first quality, the product is repaired by cutting off the affected area and gluing on a new piece. Refer to the maximum allowable seam specification

POROSITY / SILICONE / Poor Cell Structure

- **Definition:** small holes on the surface of the mattress or uneven, open cell structure
- **Acceptance Criteria:**
 - 1st quality:
 - Allowed as first quality if intermittent holes that are less than 3/8 inch diameter, the total affected area is less than 300 square inches, and the affected area is soft and not noticeable by touch.,
 - To be repaired:
 - If not acceptable for first quality, the product is repaired by cutting off the affected area. Normally, surface defects caused by silicone can be repaired by cutting off the area.
 - Typically, if poor cell structure is found in a product, it is throughout the entire product, and cannot be repaired.



RIPS & TEARS

- **Definition:** defects due to torn pieces of foam.
- **Acceptance Criteria:**
 - 1st Quality:

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- Any Rip or tear on the surface that is < 3 " in length or shallower than 3/4" can be used as first quality without repairing
 - To be repaired:
 - If not acceptable for first quality, the product is repaired by using the mattress adhesive (Foam fast #77) to repair the area.
 - The product must be allowed to dry for 1 hour before being roll packed.
 - The repair must be soft to the touch or is considered IP/scrap.

Large holes or tear outs on the edge
Pulls or tear outs on the surface

- **Definition:** a hole that is larger than a 1/2 cubic inch, within 2" of the edge of the Mattress
- **Acceptance Criteria:**
 - 1st Quality:
 - Less than 1/2 cubic inch is acceptable (1" x 1" x 1/2" deep) for 1st quality without a repair, and does not affect the feel of the product.
 - To be repaired:
 - If not acceptable for first quality, the product is repaired by using adhesive to repair the area.
 - The repair must be soft to the touch or must be cut out prior to use in finished product

INTERNAL VOIDS

- **Definition:** any hole inside the mattresses that is noticeable by touch or sight
- **Acceptance Criteria:**
 - 1st Quality:
 - Allowed un-repaired for first quality if under 1 cubic inch each, and there are fewer than 6 on a core.
 - To be repaired:
 - If not acceptable for first quality, the product is repaired by using the mattress adhesive to repair the area.

Hard Skin

- **Definition:** hard surface, outer rubbery layer

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- **Acceptance criteria**
 - 1st Quality:
 - not allowed for first quality

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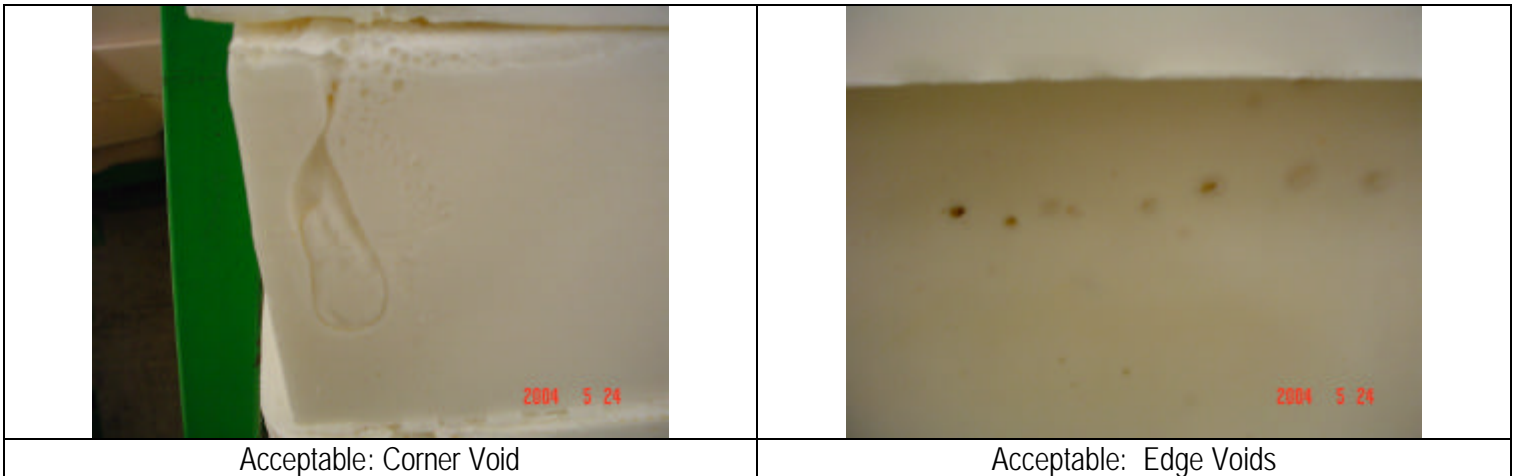
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GLUE SEAMS

- **Definition:** An area where two mattresses are joined to make a larger mattress
- **Acceptance Criteria:**
 - 1st Quality:
 - If any area more than 2 inches long is not properly glued together, then the material is not considered first quality and must be repaired
 - If 2 or more areas less than 2 inches long are not properly glued together, then the material is not considered first quality and must be repaired
 - Glue seams must be soft to the touch.
 - 2 fabricated edges must line up within 1/8"

ILD Stickers

- **Definition:** The sticker on the core end that identifies the ILD and other data pertinent to the core
- **Acceptance Criteria:**
 - All stickers should be out squarely on the core, and should cover the pressroom marking as completely as possible.



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Unacceptable: Torn Edge



Unacceptable: Label not square

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