

# Materials

Please note that the printed samples only serve as indication of the color.

materials

## Wood

Wood is a natural material and no two trees are the same. Each piece of wooden furniture is therefore a natural reflection of the specific timber from which it was made and has its own unique wood sculpture. Despite our careful selection process, it is nevertheless possible that differences may occur in structure or color.

It is essential for the wood to retain its necessary moisture level. In order to prevent the wood to 'work' (shrinking and expansion) as much as possible, we recommend to maintain the relative humidity in the room as constant as possible (around 60%). The temperature must also be kept as constant as possible. The wood will assume its final color through influence of light and sunlight. In order to avoid differences in color between the table top and the extension leafs, these leafs should also be exposed to light for a few months. Afterwards the extension leafs can be stored (loose extension leafs) or retracted (integrated extension leafs).

### Solid wood (Arco premium quality)

Our solid wooden table tops are composed of solid wooden strips of varying widths which are glued together. The tables can be finished with mat-natural finish (hereafter N-finish), project finish (hereafter P-finish) or with oil. Natural characteristics of the wood such as knots, deformations, black spots etc. are inevitable. With premium quality solid wood, open defects must never be visible, (however, they may for instance be found on the underside of the table top). Solid wood is extremely sensitive to fluctuations in temperature and humidity, which could cause the wood to "work" and create e.g. little cracks in the course of time.

### Solid wood (Local Wood)

Local Wood is wood from the region around the factory of Arco in Winterswijk (the Netherlands). The entire process of Local Wood is realized locally, from raw materials right up to processing (sawing and drying) and production. With Local Wood any "imperfections" in the wood are not disguised. The unique, naturallyshaped knots of the wood and possible color differences are therefore visible in the top. Nature remains visible in the furniture, which gives it a natural character and unique identity.

### Duramas (semi-solid wood)

Duramas is composed of a thin layer of premium quality solid wood, which is glued onto the top and bottom of a supporting core panel (e.g. poplar), which provides for an extremely stable sandwich construction. The advantage of Duramas is that high quality wood is sparingly used, while the top layer is still strong enough to be sanded and oiled like solid wood. Duramas is sensitive to fluctuations in temperature and humidity which could cause the wood to "work" and create little cracks in the course of time.

### Veneer

Veneer is a thin layer of wood glued onto a core panel. The advantage of veneer is that it is real wood, with the corresponding warm appearance and tactility, but it hardly 'works' (shrinking and expansion). Arco uses a special method where the veneer sheets are mirrored so that the patterns in the wood optically continue, thereby creating an even wood image.

# Finishes

## Stain colors

Our oak furniture (including solid wood, duramas and veneer) can be stained in different colors. Staining is a technique where the color is applied to the wood while the wood structure remains clearly visible. Stained wood can be finished with N-finish or P-finish. Finishing with oil is not possible.

## Smoked oak

Oak contains tannin, the same substance that makes red wine and black tea 'dry'. This substance reacts to the ammonia vapours that are dispersed in the drying chamber during the drying process. Due to this the wood takes on a deepbrown color 'through and through'. The tannin concentration determines the color. This concentration is influenced by the soil composition and the living environment of the tree and can therefore differ greatly per trunk and even among different sections of the same trunk. Even though the color is selected during the production process, it is impossible to guarantee that everything will stay in the same color. In other words, color differences always occur in smoked oak. Furthermore, we would like to inform that the smoked oak we use for our tables is no premium quality solid oak. For that reason natural characteristics such as little knots or black spots, deformations, etc. might be visible. Smoked oak can be finished with N- or P-lacquer and oil (only solid).

## Brushed oak (only on solid wood)

Brushing creates a relief between softer and harder growth rings. The depth is influenced by the wood's natural properties: the density, flat or quarter sawn and the structure. There will always be variations in 'depth' and 'coarseness'. The grooves will be deeper in the 'softer' wood parts. Cracks cannot be avoided and will hence remain visible. The table top can become somewhat uneven due to the brushing, thereby creating a risk of splinters. When a product from our Local Wood collection will be brushed, whitish spots, knots, differences in color and all other natural properties of 'Local Wood' will remain visible. Brushed oak can be finished with an N- or P-lacquer.

## Oil finish for solid wood and duramas

Oiled solid wooden and duramas tables show the natural radiance of the wood even better than solid wooden tables with N- or P-finish. Tables with an oil finish are somewhat more sensitive to stains and moisture however, and therefore require some maintenance. Arco solid wooden and duramas tables are treated with a high quality oil, which is only made from ecologically responsible materials. The oil nourishes and protects the wood.

## Lacquer finishes for veneer, solid wood, duramas and color lacquer

We only use finishings which meet the highest quality standards. The finish only reaches its maximum hardness after about two months. During this hardening period it is recommended that you handle your piece of furniture with care. Avoid heavy weights and only clean it with a damp cloth or some soapy water. You can choose from two different finishes: N- or P-finish. The two different finishes provide excellent protection for the wood. N-finish gives the wood an unmistakable mat appearance and the open structure of this finish provides good scratch resistance. On the other hand, N-finish requires a bit more attention when it comes to maintenance. Furniture with N-finish can be cleaned not only with regular, but even with "aggressive" cleaning agents (e.g. solvents such as white spirit). Due to the more open structure of the finish, stains may occur from liquids such as coffee, tea and red wine when remaining on the surface for a long time; the liquid will penetrate into the pores of the finish. P-finish also has a mat appearance, but is harder and more closed compared to N-finish. This makes this P-finish less sensitive to forming stains, while also providing a good scratch resistance. P-finish is easier to maintain than N-finish, which means that it can be used in both residential and professional environments.

## Lacquer colors

A wide range of our furniture can be lacquered in various colors, whereby the color is applied on the material. Lacquer colors are not possible for solid wooden and duramas tables.

# Laminates

## HPL Fenix® NTM

Nano technology is used for FENIX® NTM surfaces. The surface is obtained through the next generation of resins, developed by Arpa Industriale. With this technology, FENIX NTM® has access to advanced features such as an extremely mat surface which is soft to touch, protects against fingerprints and provides thermal recovery from minor scratches. This innovative material also has specific properties that facilitate cleaning and no special maintenance is required. FENIX® NTM is resistant to fungus, has improved anti-bacterial properties and is resistant to rubbing, scratching and abrasion.

# Metals

## Stainless steel

Stainless steel is a maintenance friendly material, which is highly resistant to corrosion and it is exclusively used as a finish for optical reasons. Stainless steel provides the product with a warm, radiant appearance. Our stainless steel basis are available polished or brushed. Polished stainless steel provides the product more luster than brushed stainless steel.

## Aluminum

Aluminium is a material that is easy to cast, which means that an aluminium base can be moulded and finished into the desired shape. Aluminium requires little maintenance, it provides a great shape freedom and it is a lightweight material.

## Artisanal cast aluminum

For the production of the base of the Joist and Trestle, Arco has chosen for a artisanal cast base (sand casting and Coquille casting). In this production method, aluminum is scooped from a crucible in a molten state and then poured into a mold (made of sand or metal).

Due to the rapid solidification in the mold, a fine-grained structure is formed, similar to the texture of an orange peel. Characteristic of this technique is the presence of small visible holes on the surface. It is also possible for shallow streaks or small bumps to occur on the surface. These characteristics are inherent to this casting process.

## Finish: Epoxy fine texture

Epoxy is a thermo-hardening plastic material which adheres to virtually any surface. Epoxy is also abrasion resistant and requires little maintenance. Applying epoxy to metal provides a very durable surface treatment and offers a wide range of colors. We have various epoxy colors available in our collection.

## Finish: Aluminum

We have aluminium basis available both in brushed and polished versions. Optically, brushed aluminium provides the product with a softer look than polished aluminium.

## Finish: Mat chrome

Chrome is a resistant surface material that resists scratches well. In case of a base in chrome, a layer of chrome is applied to metal.

# Concrete

Concrete is composed of the binding agent cement, mixed with water and aggregates such as gravel and sand. By combining the correct amounts, a stone-like and durable material is created which can be shaped as required through a casting process. Concrete has a robust appearance and it is an ideal material for creating a stable table.

# Textile

Our seating furniture is available in many fabrics from different manufacturers, but we closely collaborate with Kvadrat (<http://kvadrat.dk>), De Ploeg ([www.deploeg.com](http://www.deploeg.com)), Gabriel ([www.gabriel.dk/en/](http://www.gabriel.dk/en/)) en Camira ([www.camirafabrics.com](http://www.camirafabrics.com)).

For the complete and current fabric list visit [www.arco.nl/en/downloads](http://www.arco.nl/en/downloads)

# Leather

## Aniline leather

Aniline leather is provided with a protective layer, but is not completely covered. With this method of finishing, the natural properties of the leather are retained as much as possible. In use, the leather will obtain its own character, which is mainly determined by the typical gloss (patina) that leather obtains after a period of time.

## Semi-aniline and dyed leather

These types of leather are not only colored, but they also have a topcoat that partially covers the natural properties. This type of finishing creates a user-friendly surface.

For the current leather collection visit our website: [www.arco.nl/en/downloads](http://www.arco.nl/en/downloads)

**oak: neutrals (solid, semi-solid, veneer)**

1101 oak white



1100 oak natural



1000 oak pure



1200 oak grey



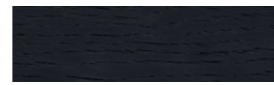
1201 oak smoke



1202 oak morado



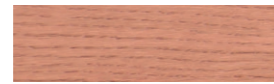
1300 oak black



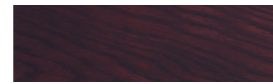
1301 oak carbon

**oak: colors (solid, semi-solid, veneer)**

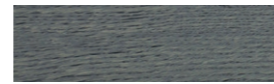
1700 oak dijon



1400 oak terra



1401 oak burgundy



1500 oak moss



1600 oak ocean

**oak: neutrals (solid, semi-solid)**

1000 oak pure (oil)



1101 oak white (oil)



1100 oak natural (oil)

**oak: smoked (solid, semi-solid)**

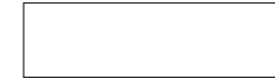
1000 oak smoked pure

**walnut (solid, semi-solid, veneer)**

1000 walnut pure

**wood finish (solid, semi-solid)**

brushed

**color lacquer: neutrals**5100 white  
(GN.02.88/RAL9010)

5101 beige (F2.05.65)



5203 silt (F2.10.40)

5301 black  
(UN.00.07/RAL 9005)

5200 grey (FN.02.77)



5202 mud (F2.10.50)

5201 quartz grey  
(F7.05.37/RAL7039)5703 Deep Brown  
(C2.04.06/RL8022)**color lacquer: yellow, green, red, blue color groups**

G0.55.80 lime



5500 mute green (H8.07.47)



5400 clay (C8.20.40)



5600 slate blue (P0.03.55)



5701 ochre (E8.50.50)



5501 emerald green (L0.20.40)



5401 red (C4.60.30)



5601 petrol blue (R0.30.30)



5702 mustard (E4.30.40)



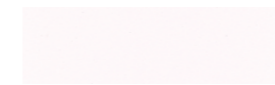
5502 moss green (G0.20.30)



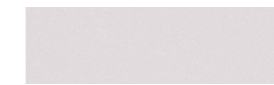
5402 burnt red (C4.35.15)



5602 prussian blue (T0.10.30)

5703 deep brown  
(C2.04.06/RL8022)5503 deep green  
(J5.16.15/RAL6007)5403 wine red  
(B1.16.12/RAL3007)5603 deep blue  
(U1.11.08/RAL5004)**epoxy fine texture: neutrals**

5100 white (RAL9010)



5200 grey (FN.02.77)



5201 quartz grey (RAL7039)



5300 black grey (RAL7021)



5301 black (RAL9005)

**epoxy fine texture: colors**

5404 rust (custom Arco color)



5503 deep green (RAL6007)



5403 wine red (RAL3007)



5603 deep blue (RAL5004)



5703 deep brown (RAL8022)



5600 slate blue (RAL7042)



5400 clay (C8.20.40)

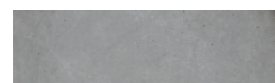


5702 mustard (E4.30.40)



5604 ultramarine (RAL5002)

## concrete



Natural

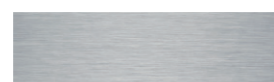
## metal



Mat chrome

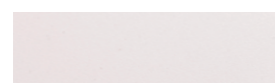


Aluminum

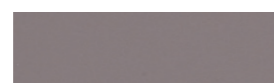


Stainless steel

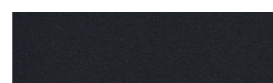
## laminates



7100 HPL Fenix White

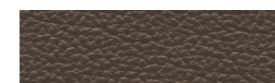


7200 HPL Fenix Grey



7300 HPL Fenix black

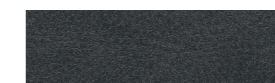
## leather



a.MO



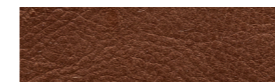
d.NG



b.EG



a.ZW



b.HZ



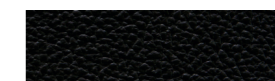
b.HB



b.CL



b.AC



a.BR



c.JD



c.AB



c.BL



d.SK

**Our seating furniture is available in our own leather collection. We also work with the following collections from Ohmann ([www.ohmannleather.com](http://www.ohmannleather.com)) 1012 (leather group C) and 1010 (leather group D). Ohmann leather is possible with the purchase of at least 4 chairs or 1 bench in the same version.**

Onze stoelen en banken zijn leverbaar in onze eigen leercollectie, maar wij werken ook met de volgende collecties van Ohmann ([www.ohmannleather.com](http://www.ohmannleather.com)) 1012 (leergroep C) en 1010 (leergroep D). Ohmann leer kan bij afname van tenminste 4 stoelen/1 bank) in dezelfde uitvoering.

Unsere Sitzmöbel sind in unserer eigenen Lederkollektion lieferbar. Wir arbeiten auch mit den folgenden Kollektionen von Ohmann ([www.ohmannleather.com](http://www.ohmannleather.com)) 1012 (leather gruppe C) und 1010 (leather gruppe D). Ohmann-Leder ist möglich beim Kauf von mindestens 4 Stühlen oder 1 Bank in der gleichen Ausführung.

## textile

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Unsere Sitzmöbel sind in zahlreichen Stoffen von verschiedenen Herstellern lieferbar. Wir arbeiten unter anderem mit Kvadrat (<http://kvadrat.dk>), De Ploeg (<http://www.deploeg.com>), Gabriel ([www.gabriel.dk/en/](http://www.gabriel.dk/en/)) und Camira ([www.camirafabrics.com](http://www.camirafabrics.com)). Die Klassifizierung der Stoffgruppen finden Sie in der Stoffliste auf [www.arco.nl/downloads](http://www.arco.nl/downloads)