

HERMAN MILLER FURNITURE SYSTEMS

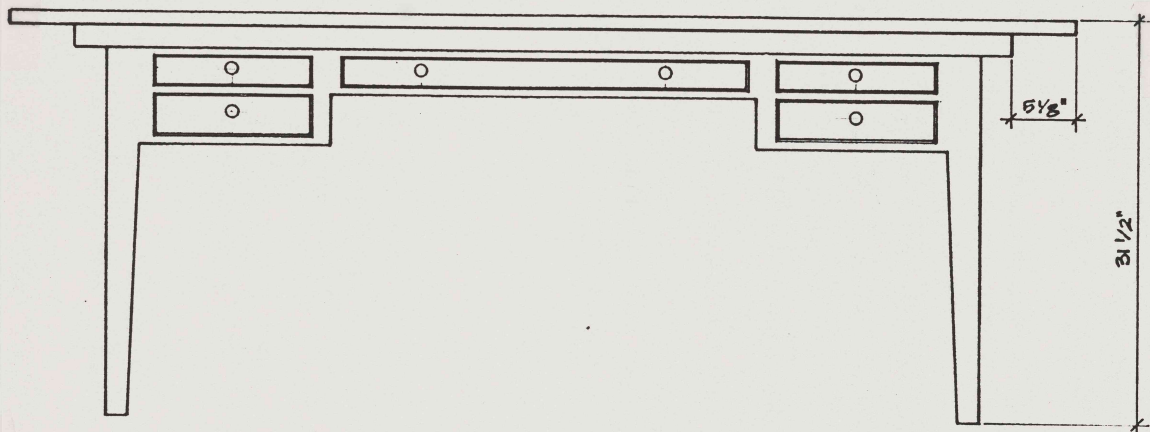
THE CONSTRUCTION PROCESS
ENGINEERING RATIONALE, DESCRIPTION AND SPECIFICATIONS

EXECUTIVE'S DESK

Center for Environmental Structure 2701 Shasta Berkeley CA

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EXECUTIVE'S DESK



FRONT ELEVATION.

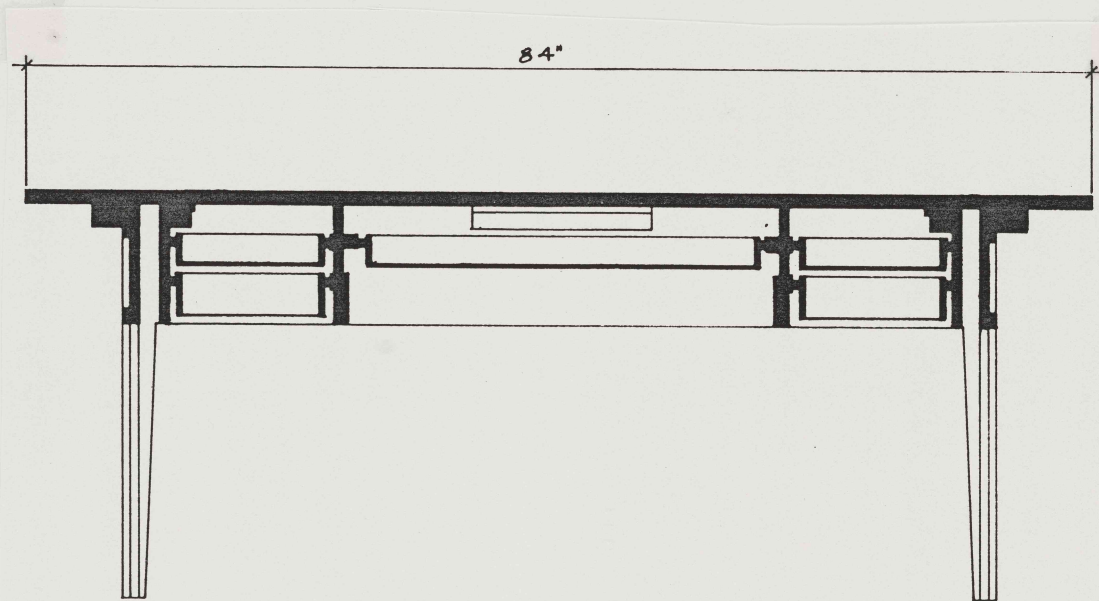
The Executive's desk is available in three different sizes. The dimensions of each individual member of the desk will vary with the size of the desk so as not to lose the elegant proportions of the piece as a whole. The desk is available with a choice of two finishes for the top writing surface which are high pressure laminate or linoleum. All other surfaces of the desk are finished in automotive lacquer. Approximately thirty different colors are available.

The process for building and assembling a desk is described as a series of six sub-assemblies as follows:

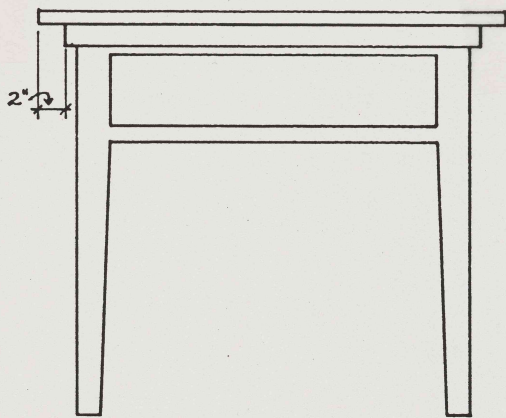
1. The Frame
2. The Trim
3. Ring Beam
4. The Top
5. The Drawers
6. Final Assembly.

All dimensions given here are for a desk 84in. X 36.5in. and 31.5in. high.

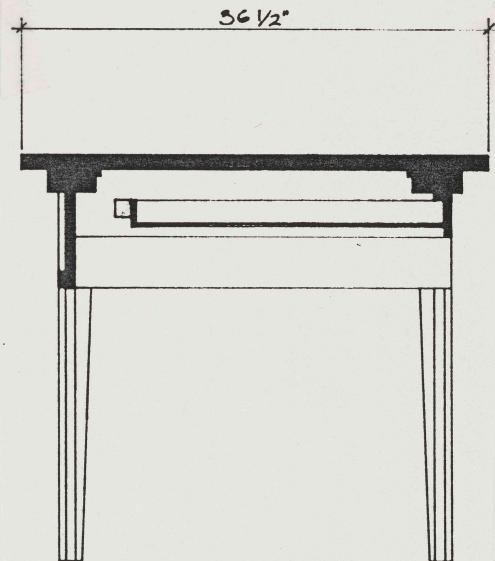
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LONGITUDINAL SECTION.



SIDE ELEVATION.



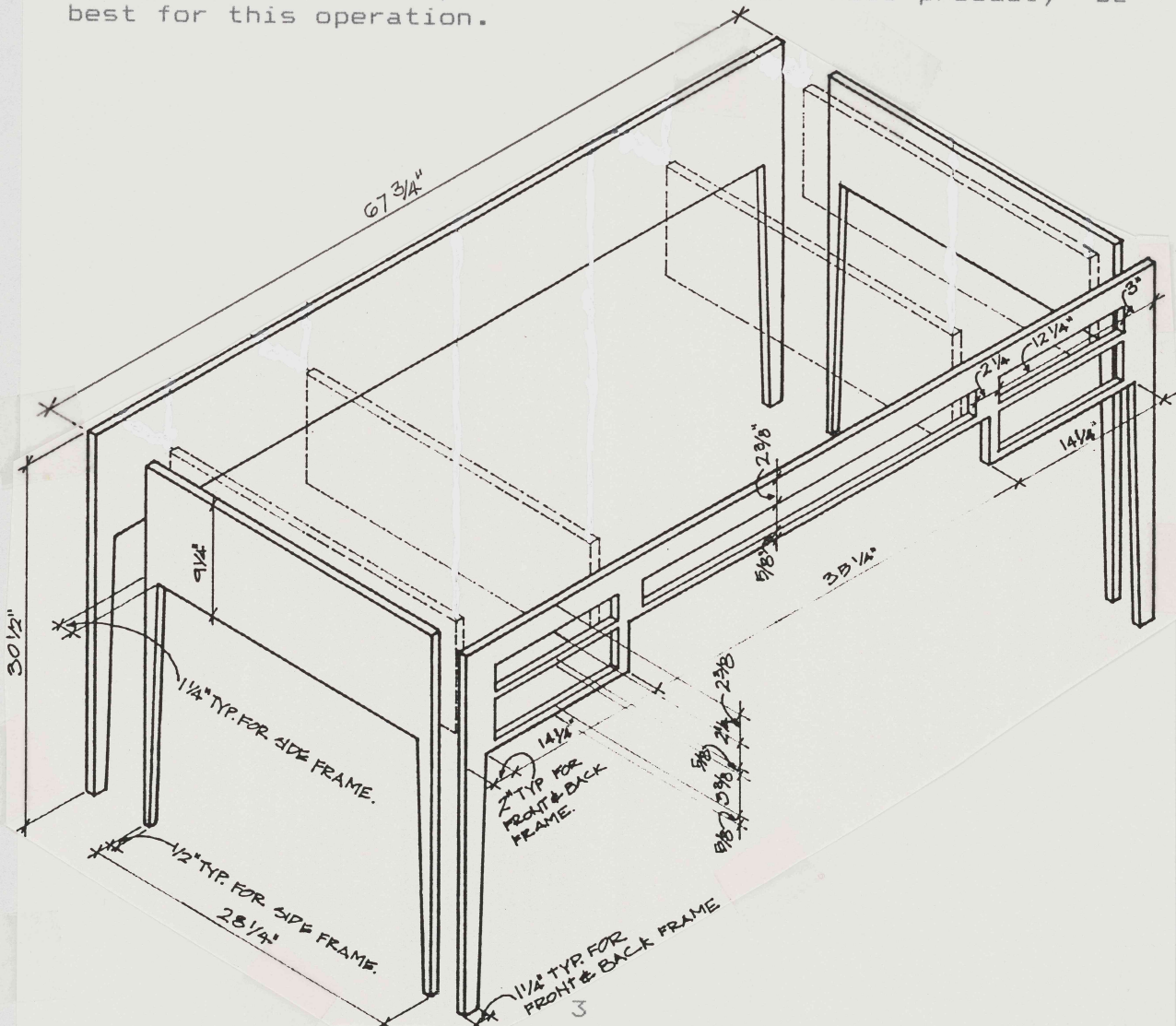
CROSS SECTION.

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I. THE FRAME

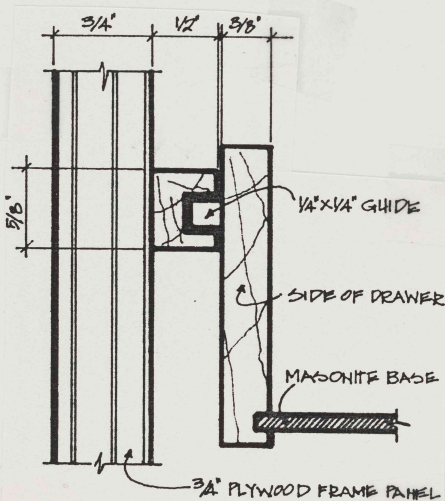
The four outer panels of the frame and the four internal cross panels are made from 3/4 inch fine grade Birch plywood. Each panel becomes a moment resisting frame independent of its connection to another panel. In this system of construction the joints are not stressed whereas in most desks the joints between the leg and the skirt take most of the stress and are weakened with time. The front panel is designed as a veerendeel truss to span between the two front legs.

1. Cut each of the four outer panels from 3/4in. fine grade Birch plywood. A computer driven router will probably be best for this operation.



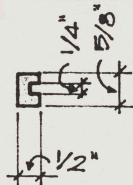
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2. Prime the two side panels and the back panel with two coats of high build sanding primer. Do not prime surfaces that will have trim attached later.
3. Fill and prime all plywood edges at legs.
4. Cut interior cross panels from 3/4in. Birch plywood and drawer guides from solid Oak. Cut also the additional rail for the center drawer and the drawer stops from solid Poplar. Attach rail, drawer guides and stops to the cross panels as shown.
5. Assemble frame with glue and brass screws (for use in plywood).



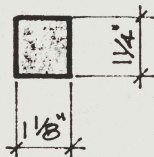
SECTION A-A.

TYPICAL DRAWER GUIDE:



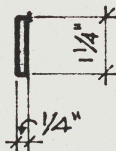
2 PCS. 25 1/4" LONG.
8 PCS. 17 1/2" LONG.

RAIL FOR CENT. DRAWER GUIDE.



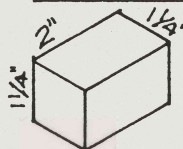
2 PCS. 25 1/4" LONG.

RAIL FOR RIGHT/LEFT DRAWER GUIDES:



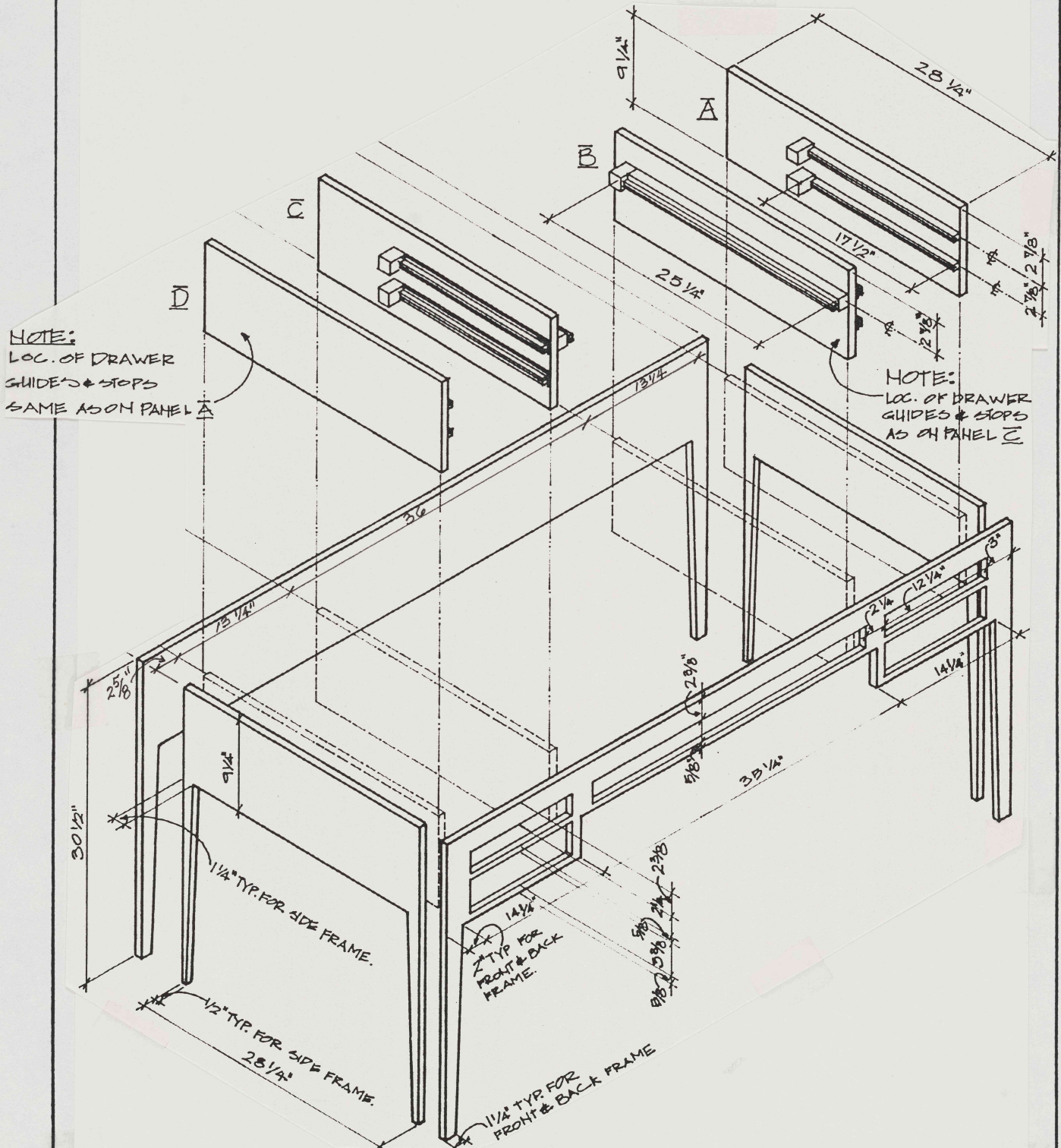
4 PCS. 17 1/2" LONG.
(ONLY WHERE INDICATED.)

TYPICAL DRAWER STOP:



5 PIECES.

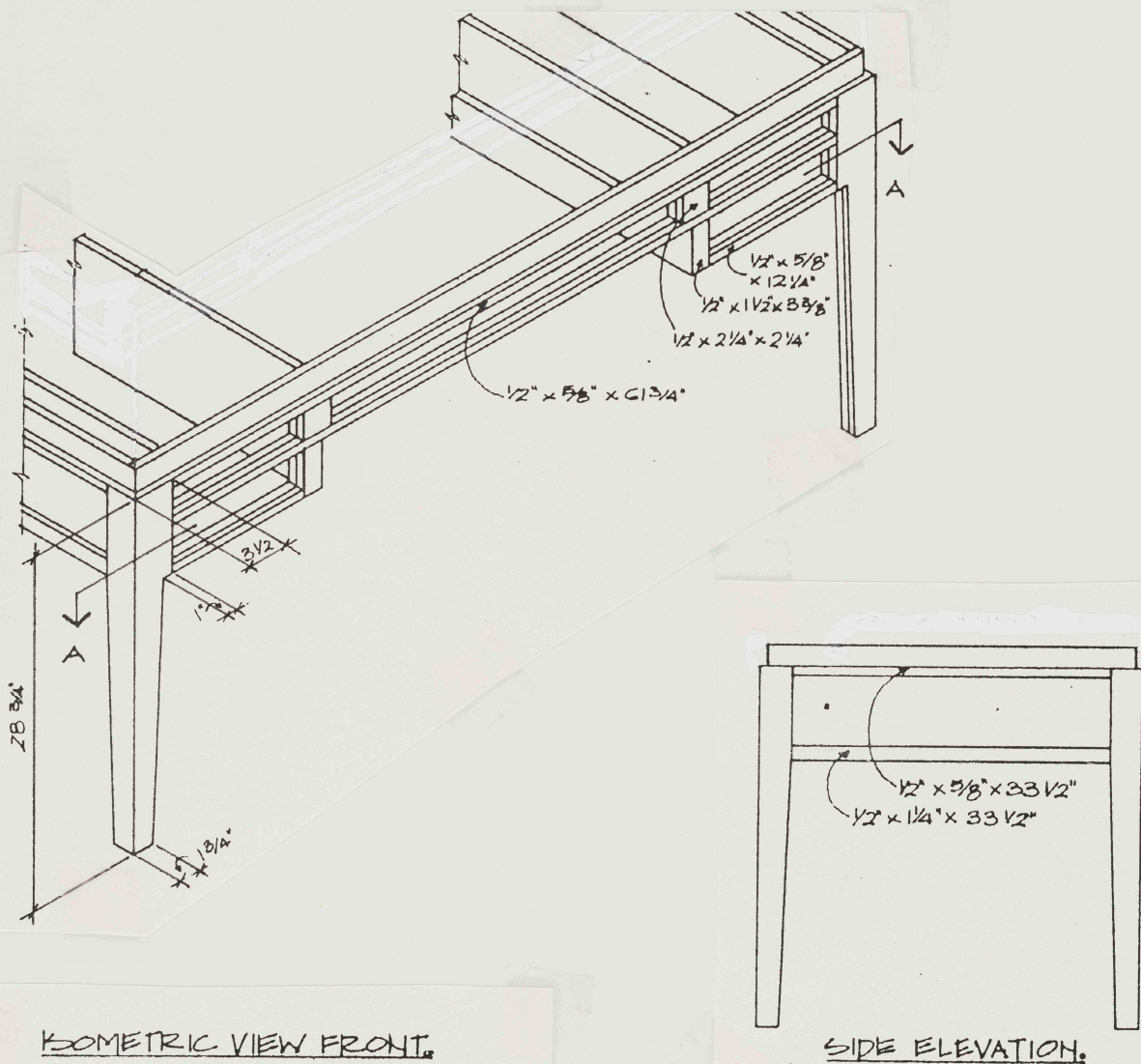
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II. TRIM

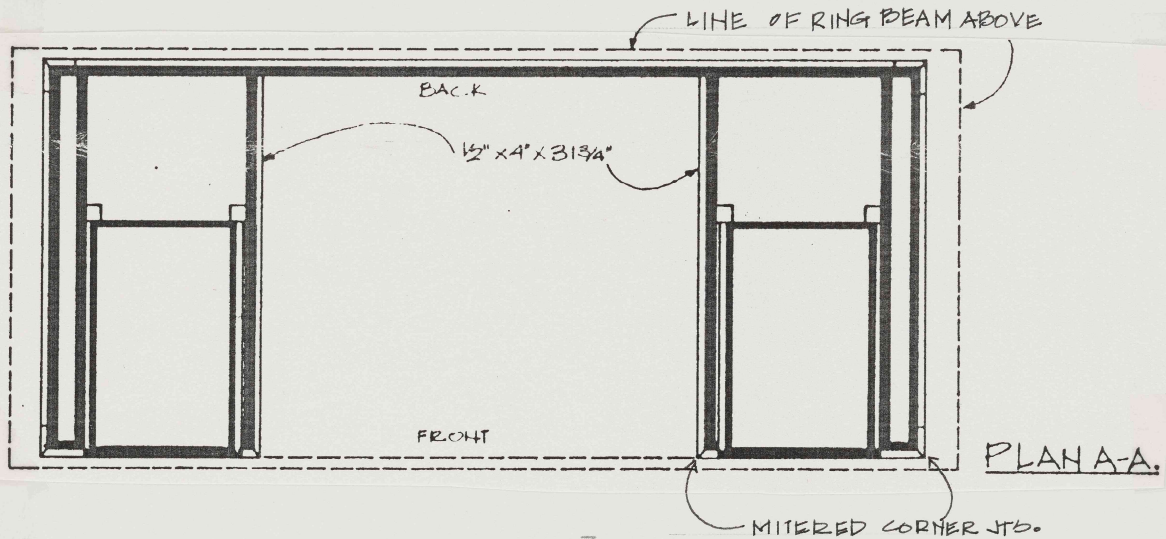
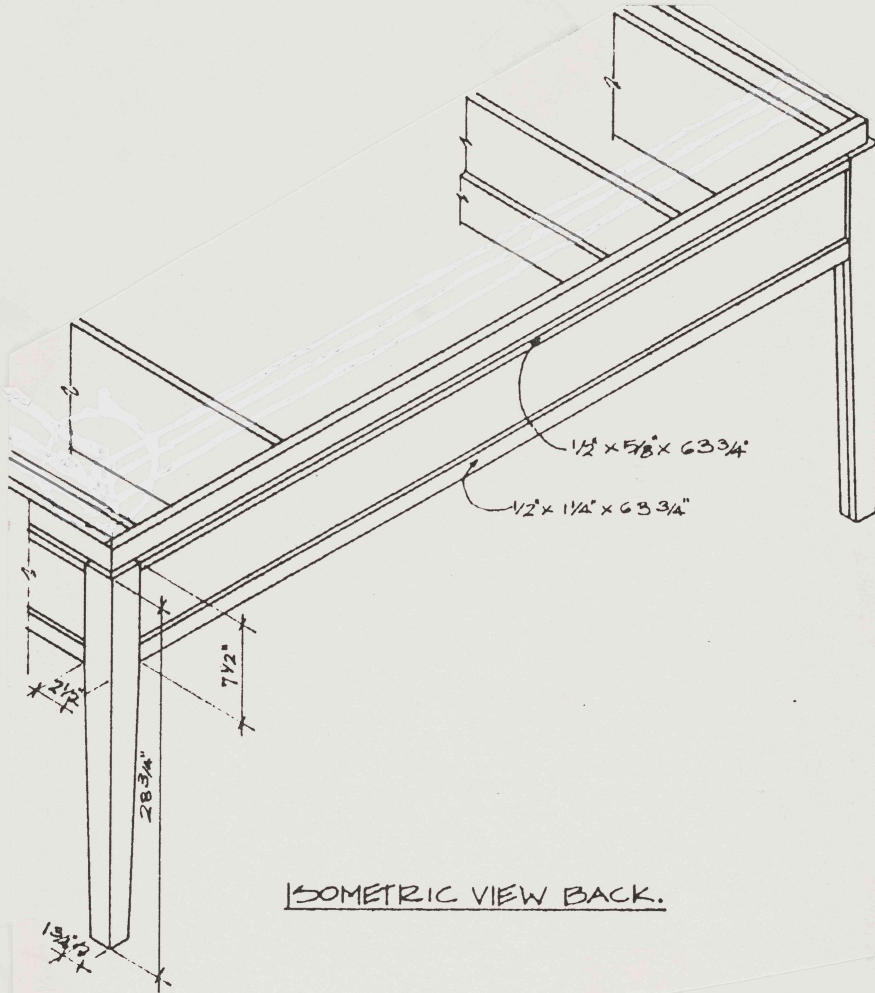
1. Mill the trim pieces for each of the four exterior panels and two center cross panels from 1/2in. solid Poplar. The outer edge of the leg pieces and of the pieces attached to the center cross panels should be cut with a 45 degree miter as shown.
2. Prime all exterior surfaces of trim pieces with two coats of 1815 primer.



ISOMETRIC VIEW FRONT.

SIDE ELEVATION.

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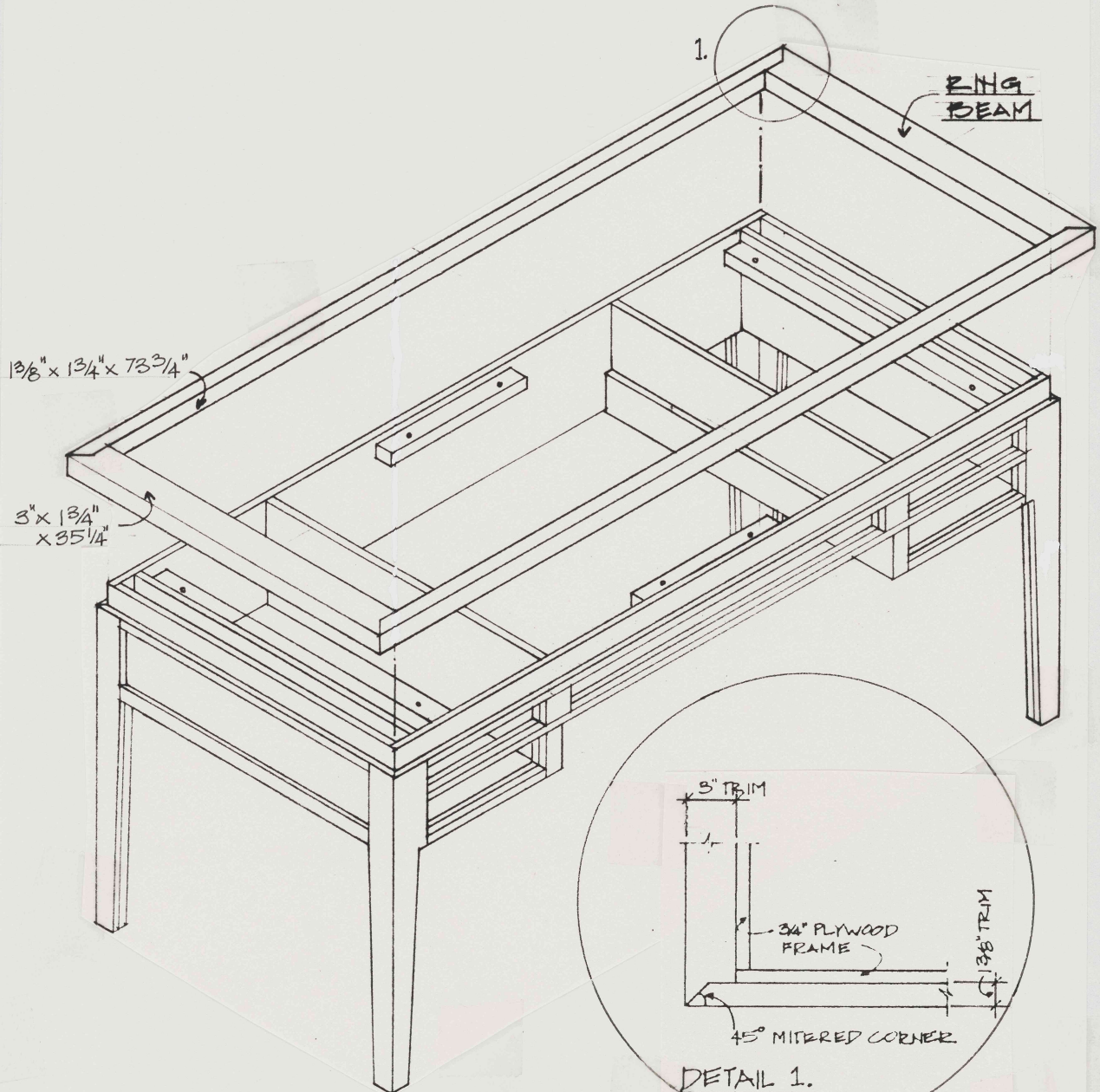


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III. RING BEAM

1. Mill the sections for the ring beam from solid Poplar and cut the pieces to length using a 45 degree miter as shown. Assemble the ring beam with glue.

2. Prime the exterior surfaces of the ring beam with high build primer and fill joints.



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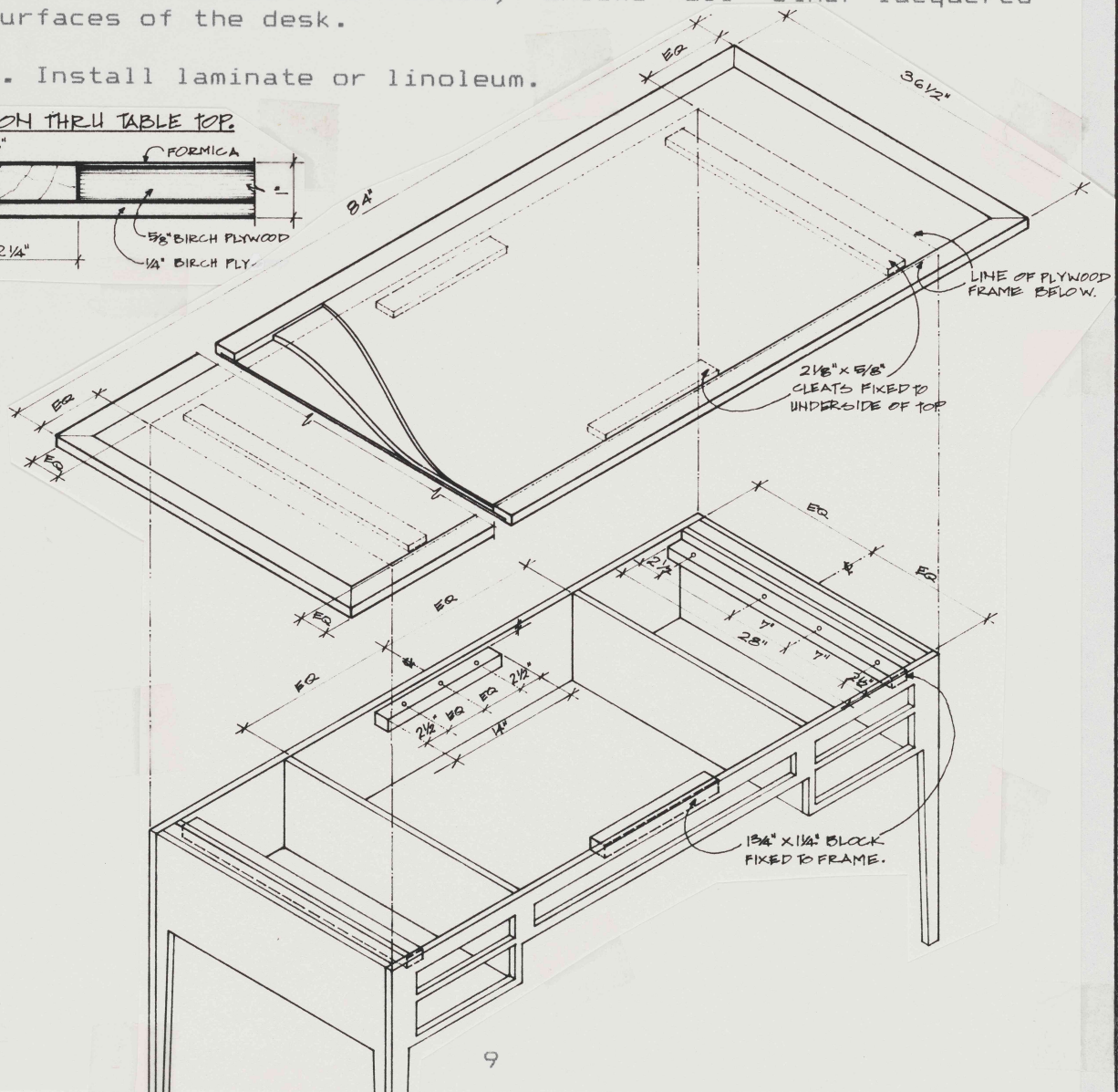
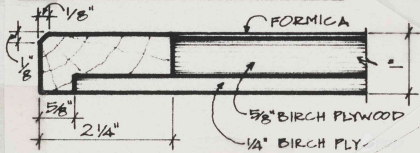
IV. THE TOP

1. Mill the section for the table top frame out of solid Poplar and cut the pieces to length with a 45 degree miter. Cut the two sheets of plywood for the table top from 1/4in. and 5/8in. Birch, respectively, as shown. Mill and cut the cleats and blocking for attaching the table top to the frame.

2. Prime the table top frame with two coats of 1815 primer and finish with four coats of lacquer. The final coat in this case should be rubbed, unlike all other lacquered surfaces of the desk.

3. Install laminate or linoleum.

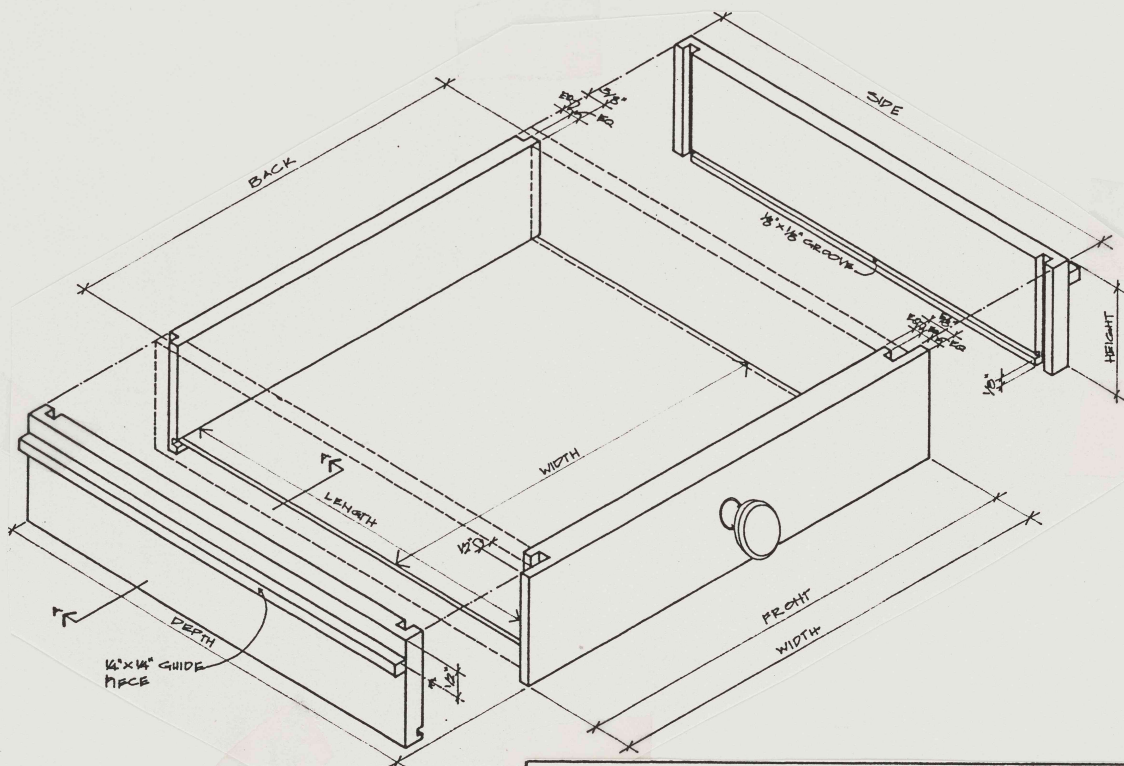
SECTION THRU TABLE TOP.



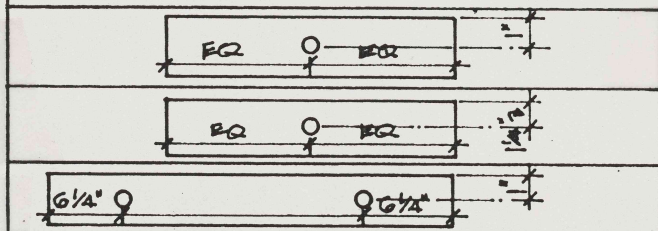
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V. THE DRAWERS

1. Mill the stock for the drawers from $\frac{5}{8}$ in. thick solid Poplar and cut to length as shown. Run the grooves for the corner joints and the base of the drawer. Cut the drawer base from masonite.
2. Prime the drawer fronts with 181S primer and finish with four coats lacquer.
3. Install the drawer knobs - Baldwin cabinet knob, style no. 4702, finish no. 10B.



LOCATION OF DRAWER KNOBS

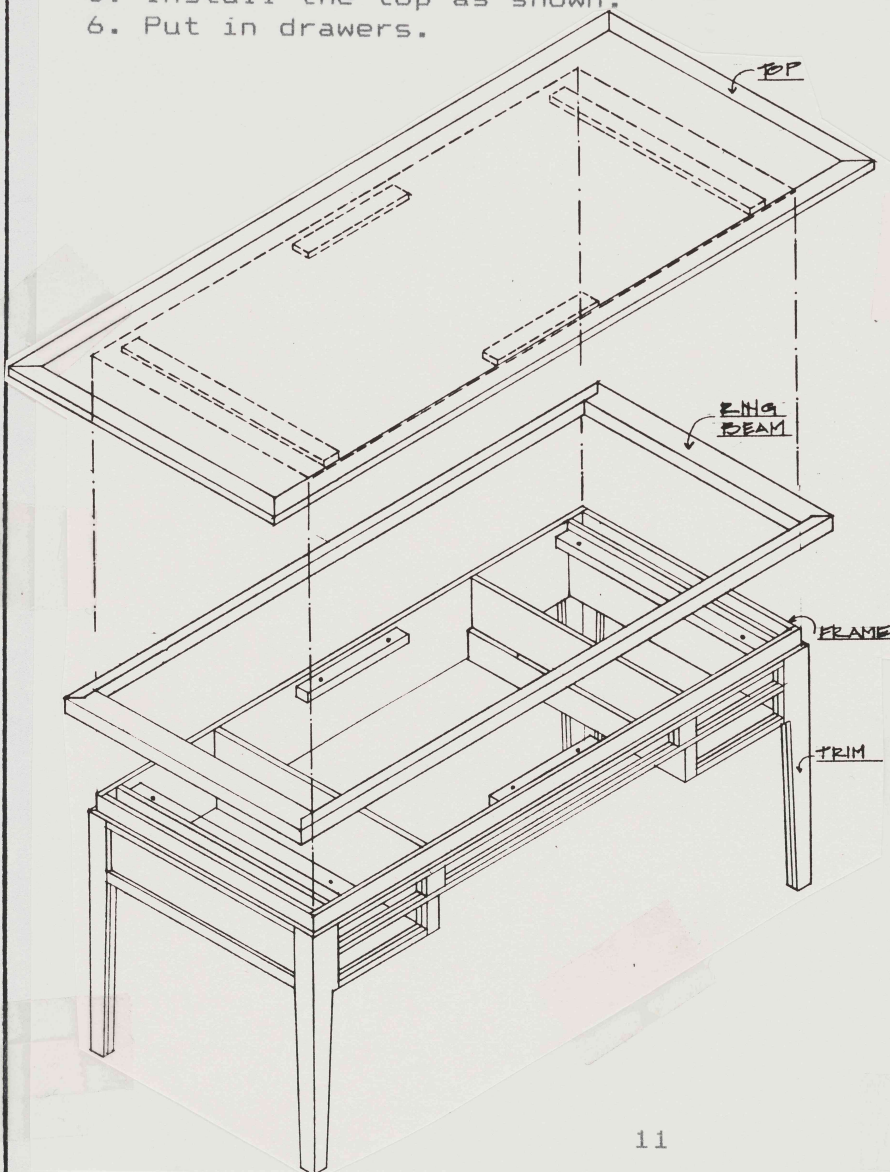


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VI. FINAL ASSEMBLY

Prior to final assembly all visible surfaces are to be primed. This is necessary in order to reduce finishing costs. The table top and drawers should be completely finished at this stage.

1. Glue the trim pieces to the frame.
2. Attach (to the frame) the blocking that will receive the cleats fixed to the underside of the table top.
3. Install the ring beam.
4. Finish the frame with a lacquer top coat.
5. Install the top as shown.
6. Put in drawers.



SECTION SHOWING CONNECTION OF TABLE TOP TO FRAME.

