

Blooming Bath

production design details & specifications

Outline:

- Overall size and shape
- Shell (soft top)
- Liner (mesh bottom)
- Fill
- Stitch and Thread
- Quality
- Packing & Shipping
- Plush Fabric Colors
- Safety Testing

Auxiliary docs: Die lines, sew spec, tag (separate docs to keep on file)

Samples to keep on hand:

Foam Fill sample

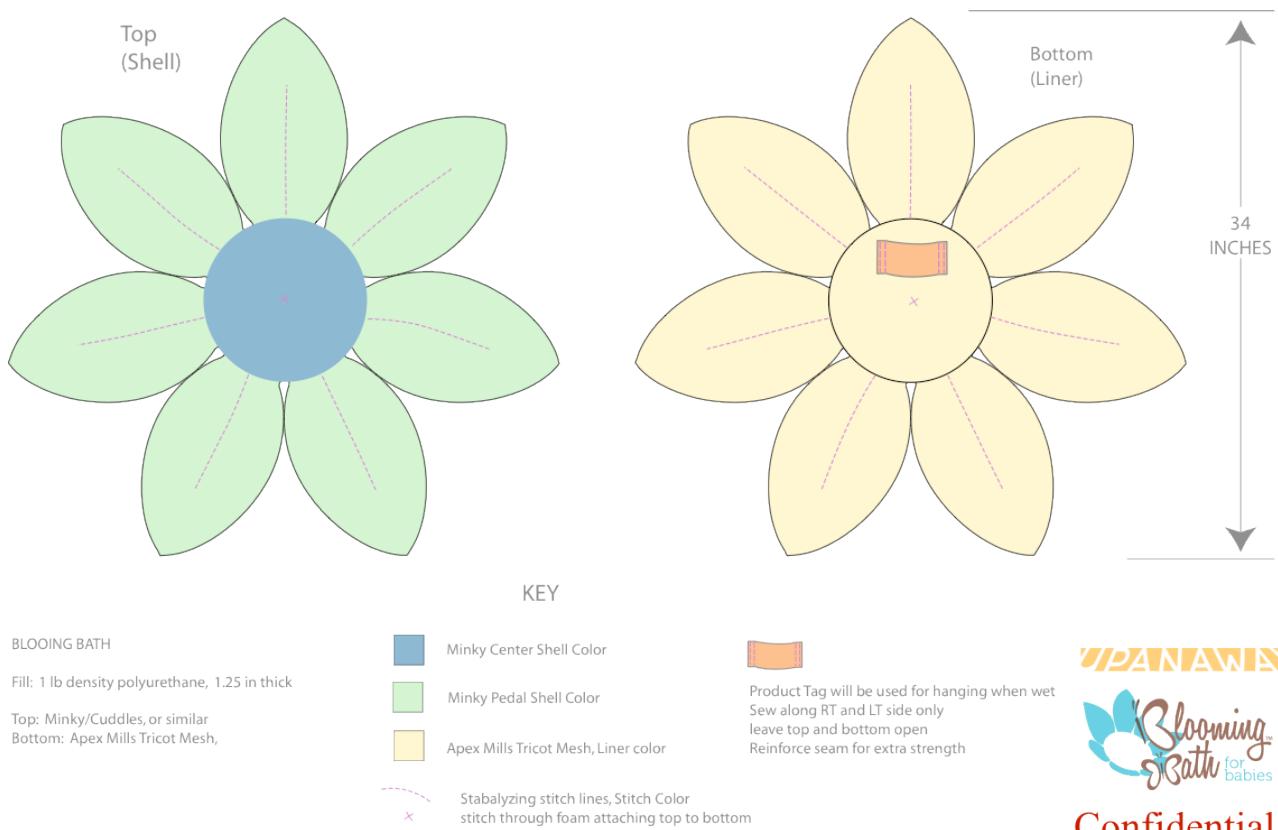
Minky or cuddles swatch cards

Apex mills swatch booklet including tricot mesh

BB samples in each color

Overall finished Size and Shape

Overall diameter: 34 in (86.4 cm)
 Foam thickness: 1.25 in (3.175 cm)
 Number of petals: 7
 Length of petals: 12 in (30.48 cm)
 Width of petals at widest point: 8.5 in (21.6 cm)
 Diameter of center: 9.25 in (23.49 cm)



Confidential

Shell

(top soft surface that touches baby)

The shell is made from 100% polyester material that is commonly used to make baby blankets. The street name is "Minky" Shannon Fabrics distributes the material under the "cuddles" name.

Center:

The center of the flower, circle, shell material utilizes a derivative of the "Minky" material with the street name "Minky Dots"

Shannon fabrics refers to the cuddles derivative as "Cuddles Dimples"
varying colors - reference color spec

Petals:

The petal material is standard Minky. Varying colors - reference color spec

Source:

Many distributors are available for Minky

Sourced by Manufacturer

Known countries of origin are US, China and Korea

Liner

(bottom surface that touches the sink surface)

The liner is a durable, non-elastic, and breathable, 100% polyester mesh-like tricot material. Common usages: suitcase liner, women's undergarments, jacket liners.

We require the use of the Tricot material specified below or equivalent. All deviations from this material must be approved by Blooming Bath. Please submit samples for approval.

Tricot is available in varying mesh densities and patterns.

We selected Apex Mills 6oz Tricot material number NB20

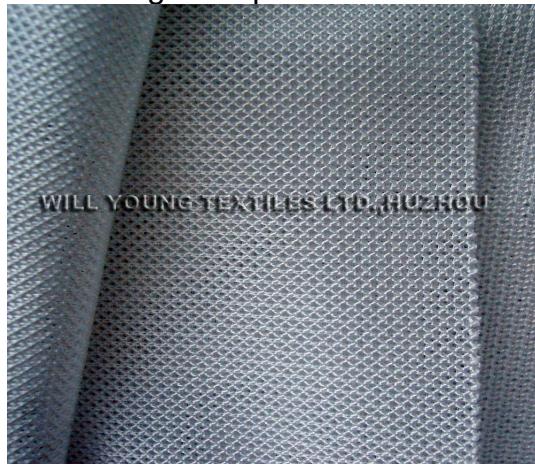
Color - white

USA made, USA based company

This tricot was selected for its combination of breathability and non-transparency and durability.

- Breathability is critical for drying
- Non-absorbent fabric
- Non-transparency is critical for appearance as it hides the foam color

Tricot image sample of similar material:



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Fill (internal padding)

The fill is a common polyurethane open cell foam
common uses: furniture, various padding applications
Hundreds of available distributors.

Foam Specs:

Density - 1 lb/ft³

Thickness - 1.25 in (3.2 cm)

IFD @25% deflection (Softness) – 21 (lbs/50 insq. On 20"x20"x4") (+/- 2)

Color – white

Meets flammability requirements in specifications section

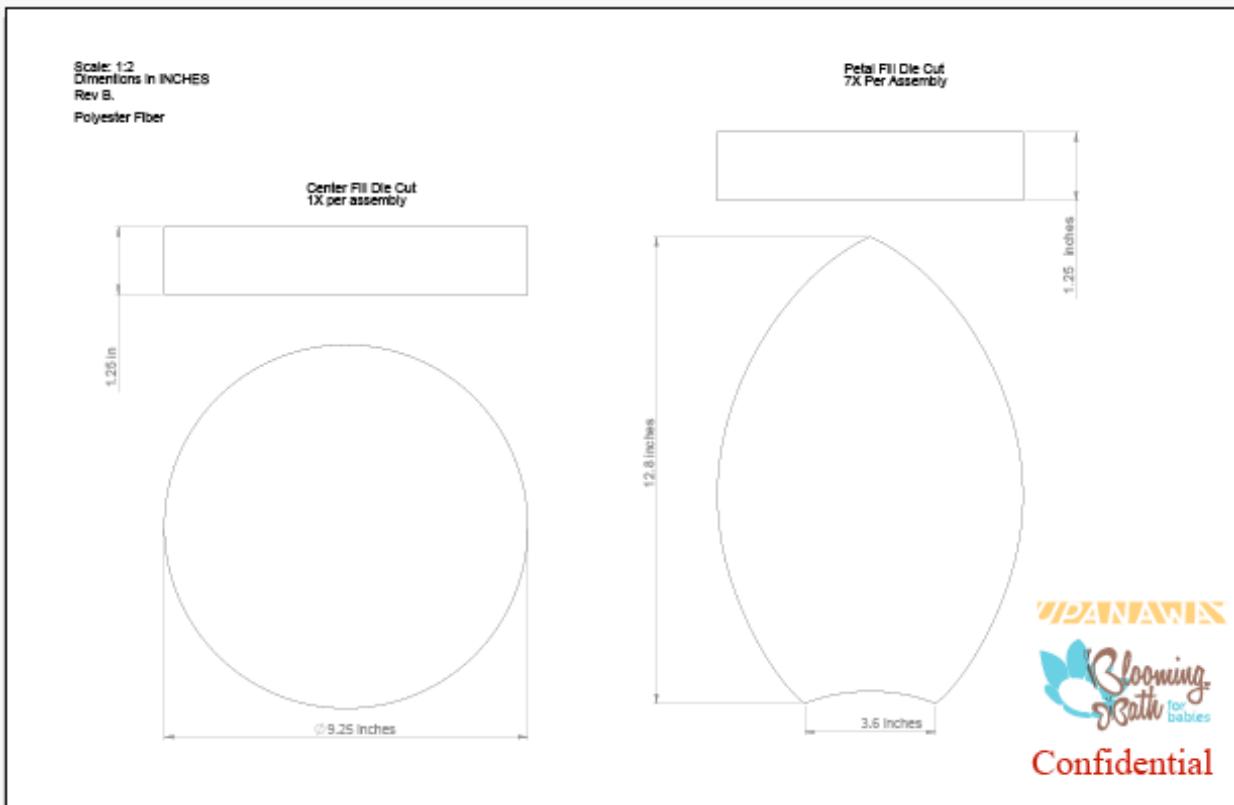
Suitable for repeated water exposure and drying

The color of polyurethane foam is extremely sensitive to UV and will yellow with only a few minutes of direct exposure to the sun. The foam needs to be protected from UV during transport. This should be the responsibility of the foam cutter to properly pack the cut foam parts for shipment.

Pic of white open cell Polyurethane foam



Foam Cut outline:



Stitch and Thread

Marine grade bonded nylon thread (size #92 or similar) should be used to assure durability in a wet environment as well as possible chewing by baby.

Sewing process is executed by the following steps:

1. Sew pre-cut Petals shell and liner material together per pattern, turn inside out
2. Stuff the appropriate fill and sew shut. repeat 7X
3. Sew petals to center shell material
4. Sew Tag to center circle liner with reinforced double stitch lines on each side for hang strength, no stitch on the top and bottom edge so the tag is open for hanging.
5. Sew liner to entire assembly leaving a small seam open for stuffing. note that Liner is pre-cut and tag is pre-sewn to liner with a reinforced double stitch line for hang strength.
6. Stuff and sew closed
7. Sew X in center of circle to stabilize the foam fill in the center
8. Sew straight lines lengthwise down the center of each petal per drawing 9 in long to stabilize foam in petal.

Color match thread to shell material on petals when sewing petals

Color match thread to shell material on center when sewing center

A special stitch is required for the final closing stitch on center to ensure that the brown colored thread does not show.

Skilled sewing of the Blooming bath is difficult, requires experienced sewers, and is critical to the overall look and feel of the product.

the base of each petal should be touching the bases of the two adjacent petals with no gap. There should be no wrinkles or loose material anywhere on the center or petals.

Quality Expectations:

1. Hanging threads: No hanging threads longer than 3mm will be acceptable
2. Material particles under surface: Minky, when cut tends to shed small fiber particles. Minky should be cleaned carefully after cutting so that particles do not become trapped under the liner.
3. Foam cannot have any of the following visible damage: Marker lines, yellow spots from UV exposure, edges must be smooth, no large bubbles, no tears or worn spots and it must be between the tolerance of 1.2 - 1.3 inches thick.
4. Color must have no human eye visible variant from control sample.
5. Petal spacing must be equal and have no gaps between the base or attachment point edges of each petal.
6. Shell, liner, foam must have no dirt or stains
7. Stitch lines must be straight and even

Packing & Shipping:

Individual package – The Blooming Bath must be folded and packaged as specified by the Blooming Bath Package specification. The appropriate UPC Bar Code sticker must be placed on each package in the appropriate location.

Masterpack Box – 4 blooming bath boxes must be placed in each master-pack box.

The size of the master pack box is:

53 x 36.5 x 43 cm.

Plush Fabric Colors:

Plush Fabrics (petals)
Shannon Fabrics Cuddles 3 "Turquoise"
Shannon Fabrics Cuddles 3 "Canary"
Shannon Fabrics Cuddles 3 "Fuchsia"

Dimple Fabrics (center)
Shannon Fabrics Cuddles 3 "Chocolate"

Product Colors Configurations:

Color 001:
Chocolate dimple center - Turquoise petal
Shannon Fabrics Cuddles 3 "Turquoise"

Color 002:
Chocolate dimple center - Canary petal
Shannon Fabrics Cuddles 3 "Canary"

Color 003
Chocolate dimple center - Pink petal
Shannon Fabrics Cuddles 3 "Fuchsia"

Color Deviation Process:

All color deviations must be approved by Upanaway by providing material samples approximately 1 yard in size. Upanaway must provide written permission prior to any purchase of production fabric that deviates from the swatch colors provided and described above.

Safety Qualification Testing

All materials used to produce the Blooming Bath must be compliant with the following testing/specifications:

For EU distribution:
EN71-1/2--83.18/34.86
EN71-3 ---USD72.88×
94/62/EC--USD71.4×2
entry 23 (cadmium) of REACH--USD40×1

entry 51 & 52 phthalates of REACH--USD142.85×2
REACH SVHC--USD972.2

For US distribution

ASTM F963:physical and mechanical test -USD79.22
ASTM F963 Heavy metal--USD100×1
CPSC physical and mechanical test-USD83.18/34.86
CPSIA phthalates USD142.85*5
CPSIA total lead-USD23.8*1

For Canada distribution

physical and mechanical--USD79.
flammability test--USD40.47
CCPSA Toy Reg. Sec. 23 for toxic elements test-- USD72.88 *1
CCPSA Toy Reg. Sec. 27(3)(d) on phthalate content--USD142.85 *1

Upanaway will contract an independent lab to perform the tests mentioned above upon submission of the pre-production samples (one of each color).