



# Manufacturing and warehouse complex Burokrat LLC

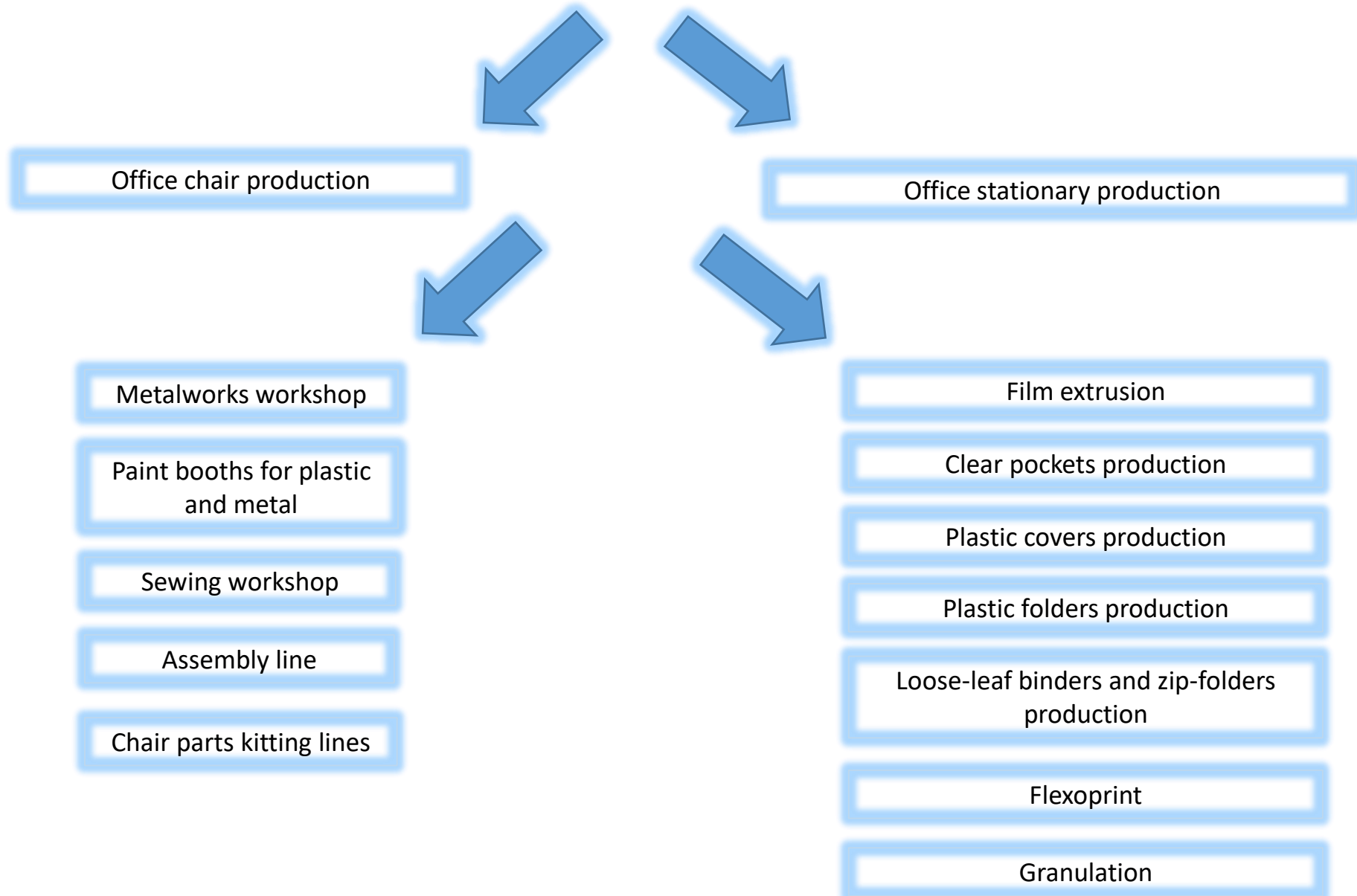


Chekhov town, Moscow region

# Brief introduction of Burokrat

- 1999 – launching of the office chair production project
- 2008 – start-up the of manufacturing and warehouse complex in Chekhov town
- Production area – about 30 000 square meters
- Testing - **ANSI/BIFMA X5.1-2002** – US National standard.
- Main market – the Russian Federation, Kazakhstan, Belarus
- The company counts about 1000 employees, including 30 engineers, 7 Design engineers and 5 Quality engineers
- Certified to ISO 9001 , IKEA I-WAY
- Production facility – about 1 500 units

# Production process



# Extrusion machines for PP film production

In production department Plastic there are :

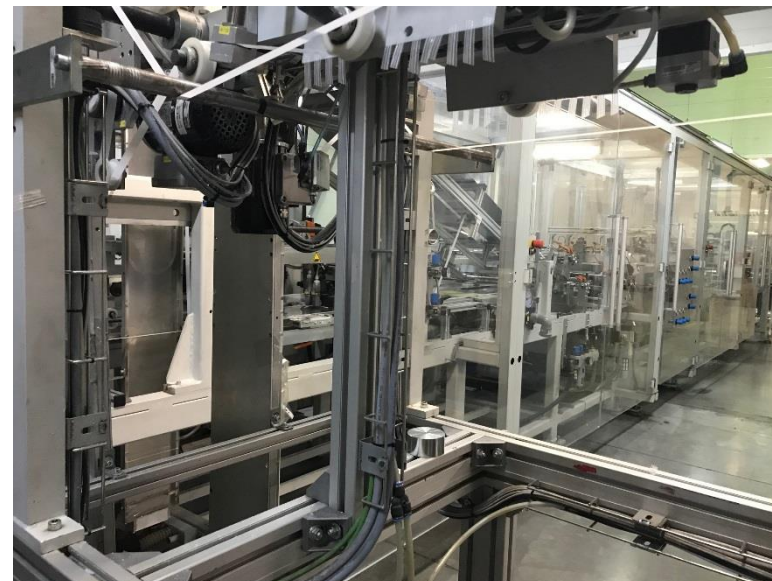
- More than 50 types of equipment for office stationary production
- Two extrusion lines Reifenhauser, with productive capacity up to 1 000 tones for manufacturing PP films with various thickness – from 18 to 200 microns
- Three blown film extrusion machines with productive capacity up to 130 tones;
- Extrusion machine for sheet material production with various stamping texture, the productive capacity of which is up to 50 tones per month;
- Unique PP storage system – 9 tanks for PP granules with a maximum capacity up to 90 tones each. The system provides all-year product safety and high productivity of extrusion lines, due to automatic temperature and humidity control system with supersensitive sensors.





# Equipment for clear pocket production

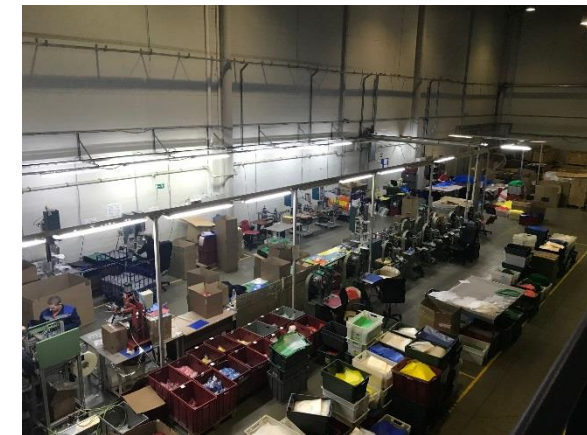
- Widmann – machinery for clear pocket production with complete production cycle with productive capacity up to 1 500 000 pcs per day
- 15 bag welding machine with productive capacity up to 3 000 000 pcs per day
- Kampf – machinery for film and paper tape cutting with productive capacity up to 4 tones per day





# Equipment for office stationary production

- Line for production of plastic covers of various sizes;
- Various machinery for production of various plastic folders (with ring mechanisms, metal and spring clips, elastic, loose leaves);
- High-speed cutting machine YAWA for sheet material products;
- Two lines for loose-leaf binder production;
- Line for L-shaped folder production;
- Line for zip-folder production;
- Line for plastic bag production;
- Equipment for surface activation and flexoprint;
- Equipment for granulation of waste products.



# Burokrat office chairs: production process

Cast moulding of plastic details



Fabric cutting



Cover sewing



Chair upholstery



Metalworks workshop



Paint booths for plastic and metal



Production of mechanisms



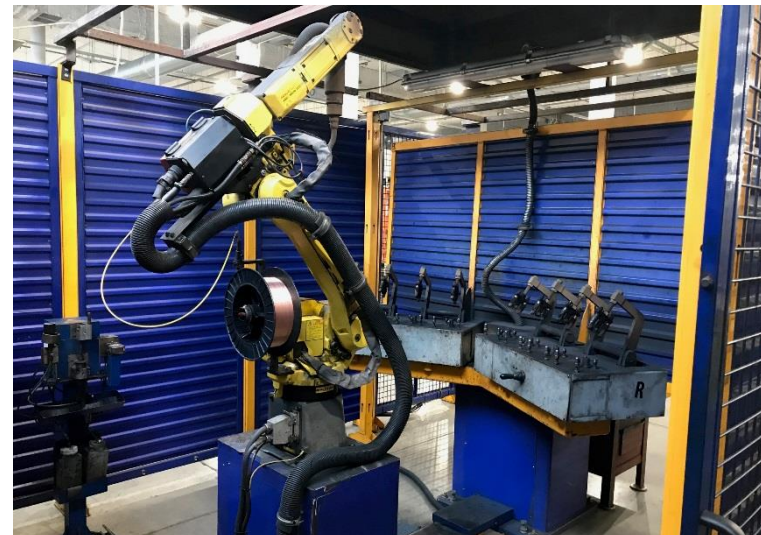
Chair parts kitting lines





# Metalworks workshop targeted at production of mechanisms, backbar, bases, hangers and metal frames for chairs

- Press equipment with pressing power from 6,3 to 400 tones
- Robotic production complexes Fanuc and OTC-DAIHEN
- Various pipe-bending machines
- Belt-saw and belt-grinding machines
- Semiautomatic welding stations
- Vibratory equipment, boring-and-threading machines
- And in-house repair shop for stamps and instrumentation, equipped with turning, milling and grinding machines





# Painting workshop for metal and plastic details

- Automatic painting machinery ITW GEMA
- Line speed is 110 cm per minute
- Powder coating line for plastic details





# Chair production

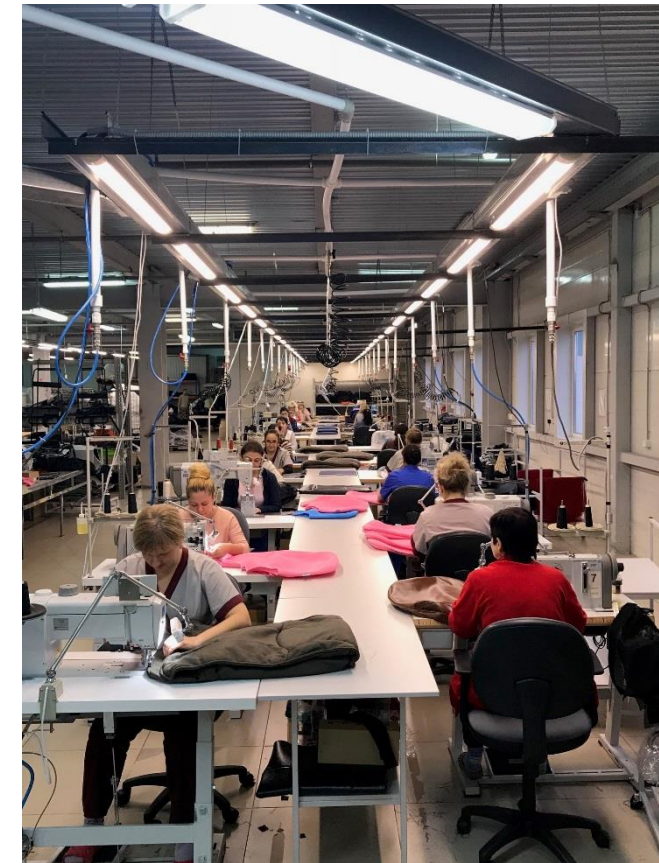
- Assembly and upholstery workshop;
- 8 chair parts kitting lines;
- Separate room for gluing foam;
- 4 lines for final chair assembling;
- Assembly line for chair production.





# Sewing workshop

- The workshop is equipped with high technology cutting machine Gerber, with the speed of automatic laying of fabric up to 17sec/meter. The length of the line table is 18 meters.
- Cutting machine Paragon. This equipment allows to minimize the quantity of defects, to increase production capacity due to optimum cutting process.
- Complicated covers with decorative stitches are sewn on sewing machines Durkopp Adler.
- There are more than 50 sewing machines in the workshop.



# Testing center Burokrat

- 1 Castor testing – 2000 cycles with obstacles and 98000 cycles under load without obstacles



- 2 Back and seat testing – 120 000 cycles under static load



- 3 Armrest testing – 60 000 cycles under static load of 100 kg





- 4 Base testing under static load of 1136 kg



- 5 Stability test dynamic - EN 1022  
Domestic furniture

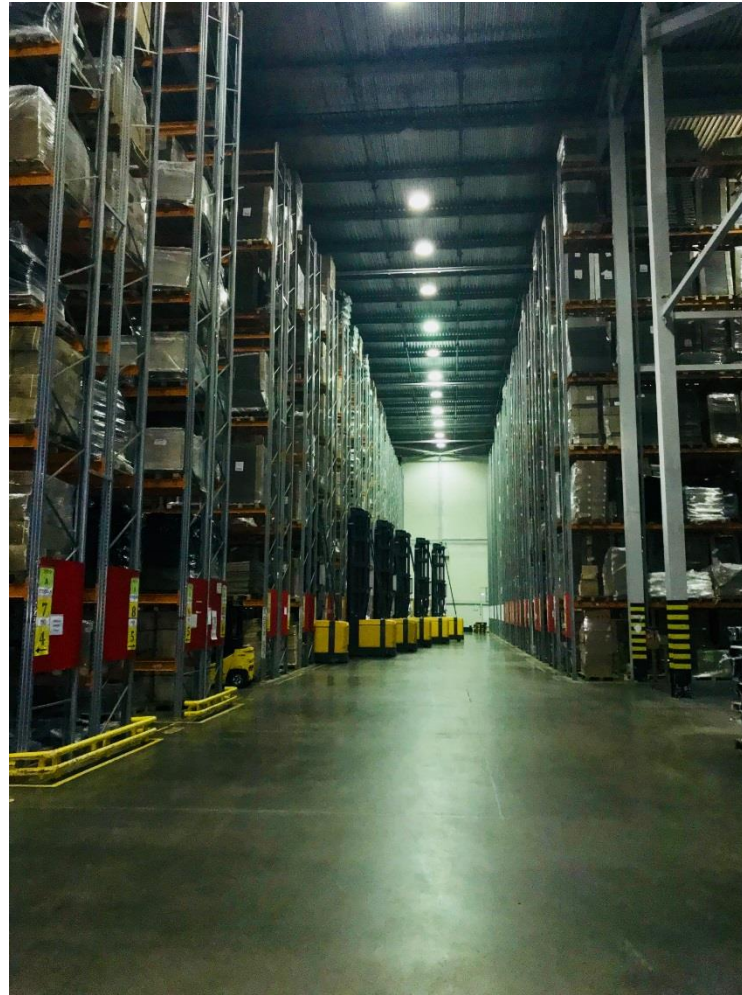


- 6 Gas lift testing – 100 000 cycles standard, testing  
of one item from each lot – 200 000 cycles



# Burokrat warehouses

- 20 000 pallet positions
- High-bay warehouse, H=18 m
- WarehouseManagementSystem (WMS system)
- Narrow high rack stackers Atlet
- Electric loaders
- Dock-levelers Doorhan





# Chair production range

- In Burokrat assortment there are more than 500 various models
- Children chairs – 125 models
- Task chairs – more than 160 models
- Visitor chairs – more than 50 models
- Executive chairs – more than 170 models
- Gaming chairs – 8 models



# Children chairs Burokrat

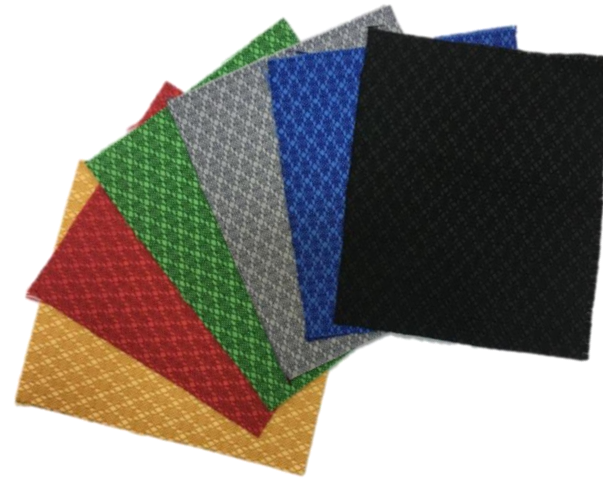
- In Burokrat assortment there are more than 125 various models
- All the plastic details are made of primary polypropylene and polyamid. It guarantees safety and ecological properties of chairs. High product quality is confirmed by the absence of lead and any toxic elements in all the details.
- In our assortment we use fabric and design of the German company TRANSFERTEX
- The spare parts for children chairs are supplied from Europe





# Upholstery variants for Chairs

- In Burokrat assortment there are more than 150 various colours;
- More than 20 various fabric series (from leather to mesh fabric);
- All fabric have Abrasion Resistance ASTM D4966-98 Martindale over 40 000 cycles;
- Flammability Test required;
- Fabric of different texture and composition – Polyester/Acrylic/ Nylon/ Polypropylene.



# Rollyx castors

- In Burokrat assortment there are more than 30 various castor models;
- All the castors are produced in Czech Republic, the manufacturer is certified to IKEA I-WAY;
- Burokrat castors meet BIFMA requirement;
- In the assortment there are castors with diameter 40/50/60mm, for laminate and parquet floors.





# Stationery by Burokrat

- In Burokrat assortment there are more than 2000 various models
- Market share on Russian market more then 40%
- Turnover of PP more then 700 tn per month

