

Industrial Artisan Built™

OPEN SPECIFICATIONS

for:

STEEL BENT LEG PICNIC TABLE KIT

2016-04-26

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** Support for Marketing, Coordinating, Manufacturing, available at hourly rate or at 3% of product sale price. request support: info2@practifab.com



Practifab Inc.

Industrial Artisan Built™
Practical Products for Practical People

Practifab Open Product License

2016-04-26

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Attribution and Package History 2016-04-26

Package Mediator:

Fred de St. Croix
fred@practifab.com
250 898 7317

Package Contributors:

date	name	contribution
2016-04-26	Rick Lichtenhauer	Manufacturing Technical Drawing Review
2015-09-02	Philippe Dauphin	Creation of Table Technical Drawings
1998	John Dylong	Product Initiation

Package History:

2016:

The Picnic Table Kit becomes the very first product in the Practifab Open Library of Practical Products for Practical People. Specifications for products of quality, reliability and durability. Specifications that would allow Industrial Artisans with commonly available materials and equipment to fabricate a small batch of products at reasonable cost. Specifications to allow customers to be better informed in their purchasing options.

2014:

Interest for the picnic table legs provides few sales. Fred de St. Croix, now owner of Practifab decides to begin assembly of document packages in support of open hardware designs. The Picnic Table Kit intended to be the first product of many to be part of this initiative to preserving product designs that can be built by hand using materials and equipment that is readily available by craftsmen without the hindrance of proprietary methods.

1998:

Inventor Unknown

Practical Fabrication owned by Fred de St. Croix was introduced to this Picnic Table design by neighbor and employee John Dylong. An experienced Industrial Artisan he recognized the simplicity of the design of a table that he had owned for over 15 years. While his was made from 1" square tube we decided to increase the size of the tubing to 1 1/4" tube for greater stiffness.

With our in house bender for square tube we produced made a small batch of legs.

Although our sale pricing was close to 50% more than big box retailers, discerning customers recognized the quality and longevity with our product and would purchase.



Practifab Inc.

8630 Lory Rd,
Black Creek, BC, V9J 1B8
phone: (250) 898-7317 fax: (250) 337-0091

Steel Bent Leg Picnic Table Kit

A robust design, manufactured with similar specs for over 15 years. These picnic tables have proven to be a long lasting practical product for backyard, campground or any other exterior, break or picnic area.

Easy to assemble your own picnic table. A great project for everyone ages 13 and up.

Design Advantages:

- Durable steel legs
- Access bench without stepping over
- Moves easily with ski-like legs
- Solid durable design
- Each bench can support over 1000lbs



Practifab's goal is to deliver high quality, long-lasting, repairable products at reasonable prices. Industrial Artisan Built™ to last with care, by people for people who recognize the advantages and value of long term dependable design and quality manufacturing.

Pre-order yours now, at close to wholesale prices!

Steel Bent Leg Picnic Table PRICING		
Preorder Check	Preorder Online	Suggested Retail
\$188.86	\$198.80	\$283.30

We encourage customers to take advantage of our premanufacture order purchasing method.

Mail in Intent to Purchase Form

Terms:

- 1) Customer agrees to pay \$_____ down to reserve _____ Picnic Table Kit(s),
- 2) Practifab Agrees to manufacture and deliver
 - a) within two months of receipt of minimum 25 intent to purchase agreements or
 - b) no later than **Aug. 2016** whichever comes first.
- 3) NET due on delivery, customer agrees to pay the total product price of:
 - a) no more than **\$188.93** + applicable taxes + shipping or
 - b) In the event that costs are less than predicted a discount will be provided..

See reverse.



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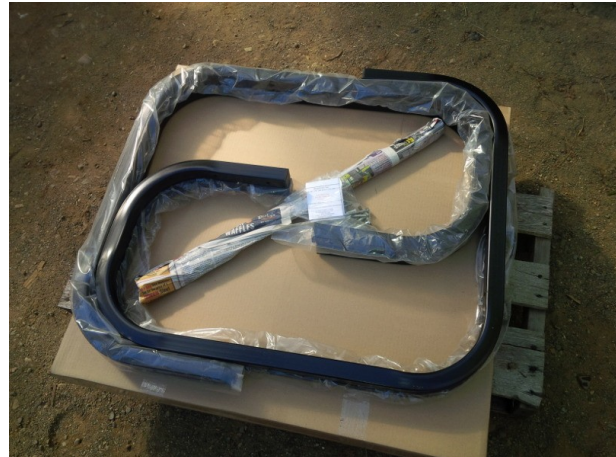
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Black Creek, BC, V9J 1B8
phone: (250) 898-7317 fax: (250) 337-0091

Kit Contents:

- Four Bent Legs: 0.100 X 1.25 X 1.25" square tubing
- Two Braces: 0.067 X .75" round tubing
- Hardware: electroplated zinc
- Packaging: cardboard 32" X 30" X 3"
- Durable Corrosion Protection
- Shipping weight: 50 lbs Additional Material

Materials Required for 8' table (or 6' Table):

- Seven 2X4's X 8' long (or 6' long)
- Four (or Three) 1X4's X 26" long
- Two 2X10's X 8' long (or 6' long)
- Fifty-four #8 X 2" wood screws
- Exterior Paint or Stain



Annual Promotion and Manufacturing in Summer each year. **ORDER YOURS TODAY!**

More of your hard earned money will go into your quality product. Pre-ordering leverages the advantage of economies of scale, lower prices, higher quality, reduces manufacturer risks, waste, stocking fees, and just might help the planet. Learn more at <http://www.practifab.com>

RESERVE YOURS NOW! - Pre-Order cheque, cash or handshake option:

In lieu of monetary commitment, a handshake or hug + initial is accepted to pre-order product.

Terms:

- 1) Customer agrees to pay \$_____ down to reserve _____ Picnic Table Kit(s),
- 2) Practifab Agrees to manufacture and deliver
 - a) within two months of receipt of minimum 25 intent to purchase agreements or
 - b) no later than **Aug. 2016** whichever comes first.
- 3) NET due on delivery, customer agrees to pay the total product price of:
 - a) no more than **\$188.93** + applicable taxes + shipping or
 - b) In the event that costs are less than predicted a discount will be provided..

Mail in Intent to Purchase Form

Customer Name: _____

Phone: _____

Shipping Address: _____

Supplier Name: Fred de St. Croix

Phone: 250 898 7317

Address:

8630 Lory rd
Black Creek, BC
V9J 1B8

Thank you for your Business.

See Reverse.



Bent Steel Leg Picnic Table Kit Assembly Instructions

General Notes:

- We recommend not building your table longer than 8' in length (6' would be small and light) [7' might be ideal]
- it is best if your table top is anywhere from 26" to 30" wide.
- Refer to technical drawings

Additionally Required Materials:

- 7 2X4's 8' long (or 6' long)[or 7' long]
- 2 2X10's 8' long (or 6' long)[or 7' long]
- 4 1X4's 25" -29" long to match table width
- 1 box of #8 X 2" wood screws
- Exterior Paint, Stain or other wood preservative

Step 1:

Cut, sand and completely stain all lumber the desired colour of table and wait to dry. Proceed to next step while it dries.

Step 2:

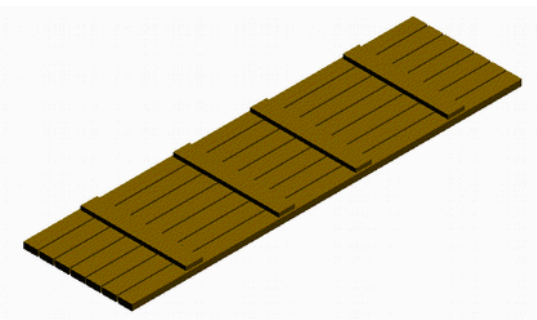
Bolt the bent leg sections together using the 1/4" bolts. The brace must be bolted between them to the middle hole. You must put two 1/4" washers between the frames as spacers on the top and bottom holes to prevent the legs from bending around the brace.

Step 3:

Lay the 2X4's beside each other, good side down. The spacing between them should be approximately 3/8" and the overall table width should be around 27".

Step 4:

Lay the 1X4's cross ways on the 2X4's.(see drawing) they should be 1/2" shorter. The distance from the end of the table to the outer and inner 1X4's should be 14" and 35" respectively (8' table). Check with legs for proper fit.

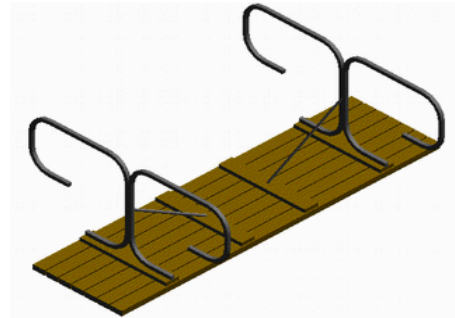


Step 5:

Screw the 1X4's to the 2X4's being careful that your table top is square and that the spacing between the 2X4's remain even. Use 2 screws per joint and stagger the screws leaving the middle of the 1X4's clear for the lag bolts.

Step 6:

Position the assembled leg sections on to the previously assembled table top. (see drawing) Centre the legs on to the 1X4's. Then, using the 2 1/2" lag bolts, bolt the legs to the table top. Then verify that the legs are square to the table and use the 2" lag bolts to bolt the brace to the inner 1X4.



Step 7:

Flip the table over on to its legs. Place the 2X10's benches in position on the frames and bolt into position with the remaining 2" lag bolts. (see drawing)



Step 8:

Light BBQ and invite friends and family over for a party.



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Bent Steel Leg Picnic Table Kit Care, Safety, Testing and End of Life

With proper assembly and regular care this table will easily provide 20 years or more of life for your family. However caution should be taken as injury can result from not being aware. Understanding and being attentive to the potential failure modes, which are similar with many picnic table designs, can prevent injury.

Care:

- General
 - The longevity of your wood will depend on wood type (spruce, pine: 10 years; cedar 25 years)
 - If your table is stored outside expect over 15 years of life on the legs with minimal care.
 - When stored outside it is best to be kept on grass and moved regularly.
 - Dragging your table over gravel, concrete or abrasive surfaces will severely reduce the lifespan of the table legs.
 - Dragging over grass will not limit the lifespan of the legs.
- Each 5 years
 - Inspect bottom of legs for wear. Tapping with a pointy hammer will indicate thin spots. There should be none.
 - Inspect wooden benches for any sign of rot or cracks.
 - Inspect that the braces are both connected to solid wood and the table top is solid, free of rot.
 - To extend life, lightly sand any rusty spots and apply an anti corrosive coating.

Safety and Testing:

- 1st Possible failure mode: Pivot collapse of entire picnic table due to lack of brace integrity.
 - 1 Concern: Over 10 years w/spruce, pine; premature table wood-rot; brace screws can't hold
 - 2 Injury potential: Risk to legs when sitting with legs under bench during collapse.
 - 3 Occurrence: When many heavy people are sitting at the table swaying in time to music.
 - 4 Test your table in spring or before expect heavy use. Without anyone sitting on it, push firmly on the end of the table. If there is any sideways rocking motion a careful inspection of the braces will be needed and any repairs completed.
 - 5 Do not use table if only one brace is connected.
 - 6 Use caution if there is visible signs of rot on the table top.
 - 7 Repair when required.
- 2nd Possible failure mode: will be lack of torsional strength of bottom of legs.
 - 1 Concern: When dragged over 1 Km of abrasive surfaces.
 - 2 Injury potential: Risk of injury to legs as bench pivots to ground
 - 3 Occurrence: When many heavy people are sitting on one bench
 - 4 Inspect the bottom of the legs for visible wear.
 - 5 Do not use if there are any visible holes (other than the drain hole) on bottom of legs
 - 6 Repair can be done by your local repair shop by welding a 1/4"X1.5" hot roll flat bar to bottom of legs.

This table is well designed and engineered to be light, strong and durable. Suitable for home or public spaces, however with anything in life there are risks and being aware is the most important for the safety of you and others.

Obsolescence / End of Life

The durability of these steel picnic table legs have been time tested to provide minimum 20 years life span when treated with minimum care. At end of life all metal components should be returned to a Practifab partner or to your local metal recyclers.



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One Bent Steel Leg Picnic Table Kit



Industrial Artisan Built™ Practical Products for Practical People

This box contains the necessary metal parts to assemble a durable picnic table.
This table can be assembled 5' to 8' long.

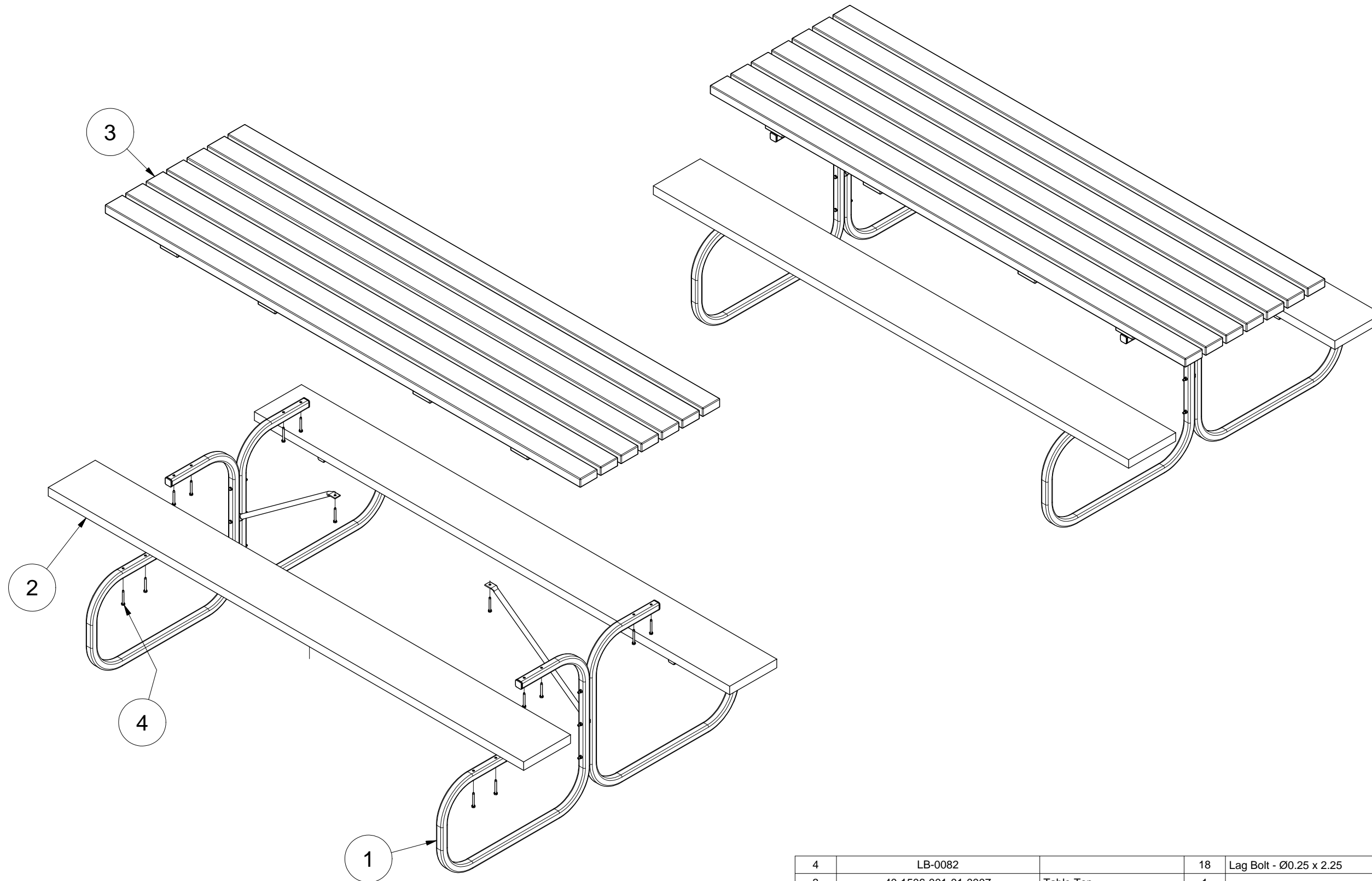
BOX CONTENTS:

- ✓ 4 Bent Steel Legs
- ✓ 2 Braces
- ✓ Hardware
- ✓ Assembly Instructions
- ✓ Care Safety And Testing Documents

ADDITIONALLY REQUIRED MATERIALS:

- 7 2X4's 8' long (or 6' long)[or 7' long]
- 2 2X10's 8' long (or 6' long)[or 7' long]
- 4 1X4's 25" -29" long to match table width
- 1 box of #8 X 2" wood screws
- Exterior Paint, Stain or other wood preservative

Preorders 2015			Practifab Inc.		8630 Lory Rd, Black Creek, BC, phone: (250) 898-7317		
			<i>Pricing:</i>	<i>1</i>	<i>\$75.00</i>	<i>\$113.00</i>	<i>\$188.00</i>
Order #	Date	Contact	Quantity	Monies Down	Due Delivery	Total	



Approximate Weight:
144.13 lbmass

Designed by:
Practifab

Drawn by:
Philippe Dauphin

Date Modified:
2015-09-02

Approved by:

Date:

Status:

Page:
1 of 2

Scale:

All dimensions are in inches
unless otherwise specified

4	LB-0082		18	Lag Bolt - Ø0.25 x 2.25	
3	40-1506-001-01-0007	Table Top	1		
2	40-1506-001-01-0003	Bench	2		
1	40-1506-001-01-0001	Leg Assembly	2		
Item	Part Number	Title	Qty	Description	Rev

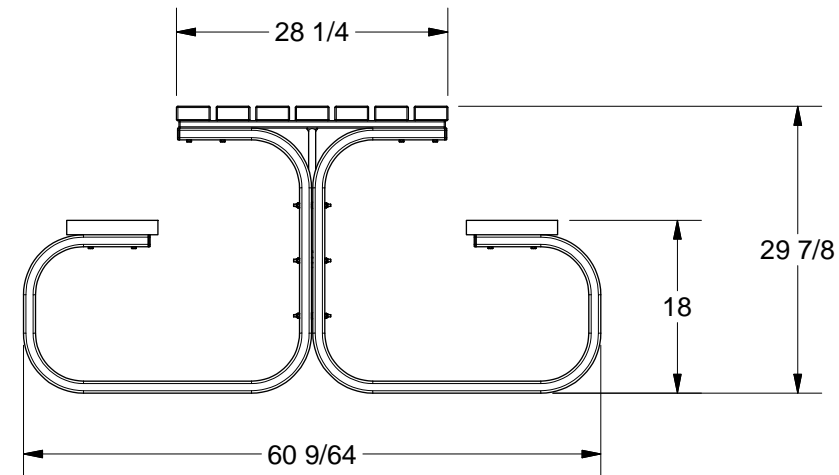
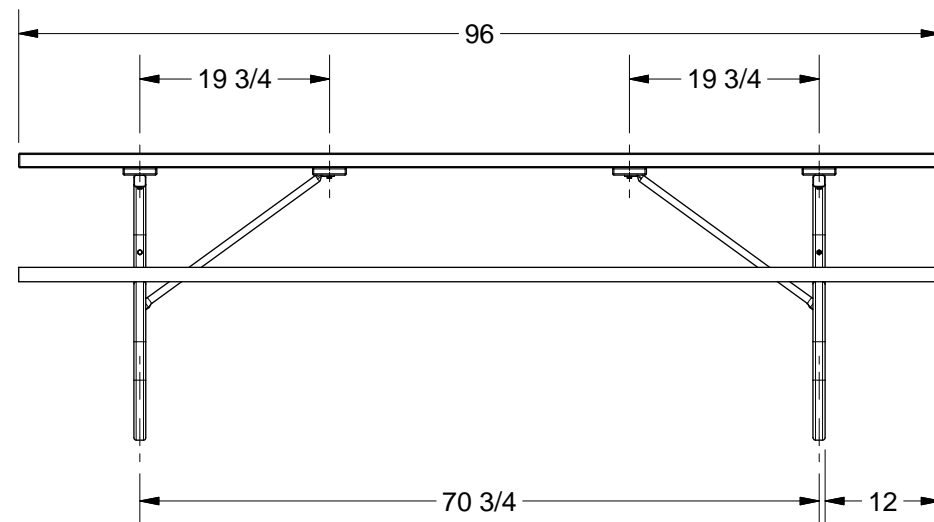
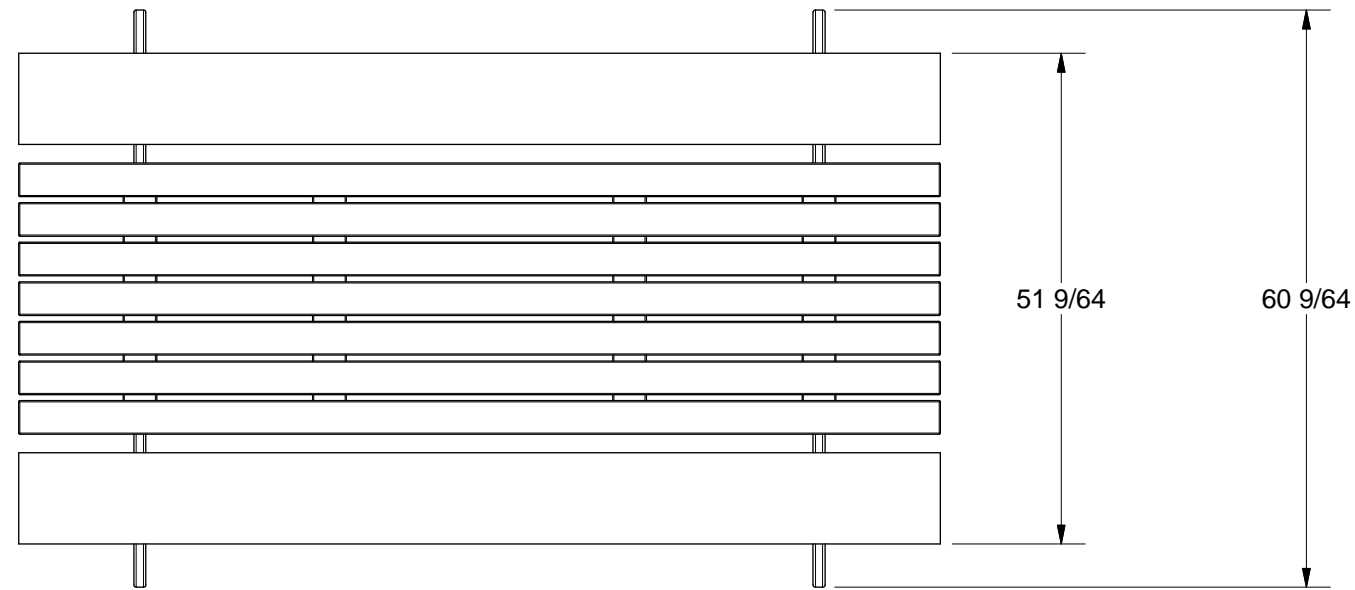
Parts List

Title: Complete Assembly

Project / Model: Picnic Table

Part Number: 40-1506-001-01-0004

Rev: 00 B



Approximate Weight:
144.13 lbmass

Designed by:
Practifab

Drawn by:
Philippe Dauphin

Date Modified:
2015-09-02

Approved by:

Date:

Status:

Page:
2 of 2

Scale:
1:20

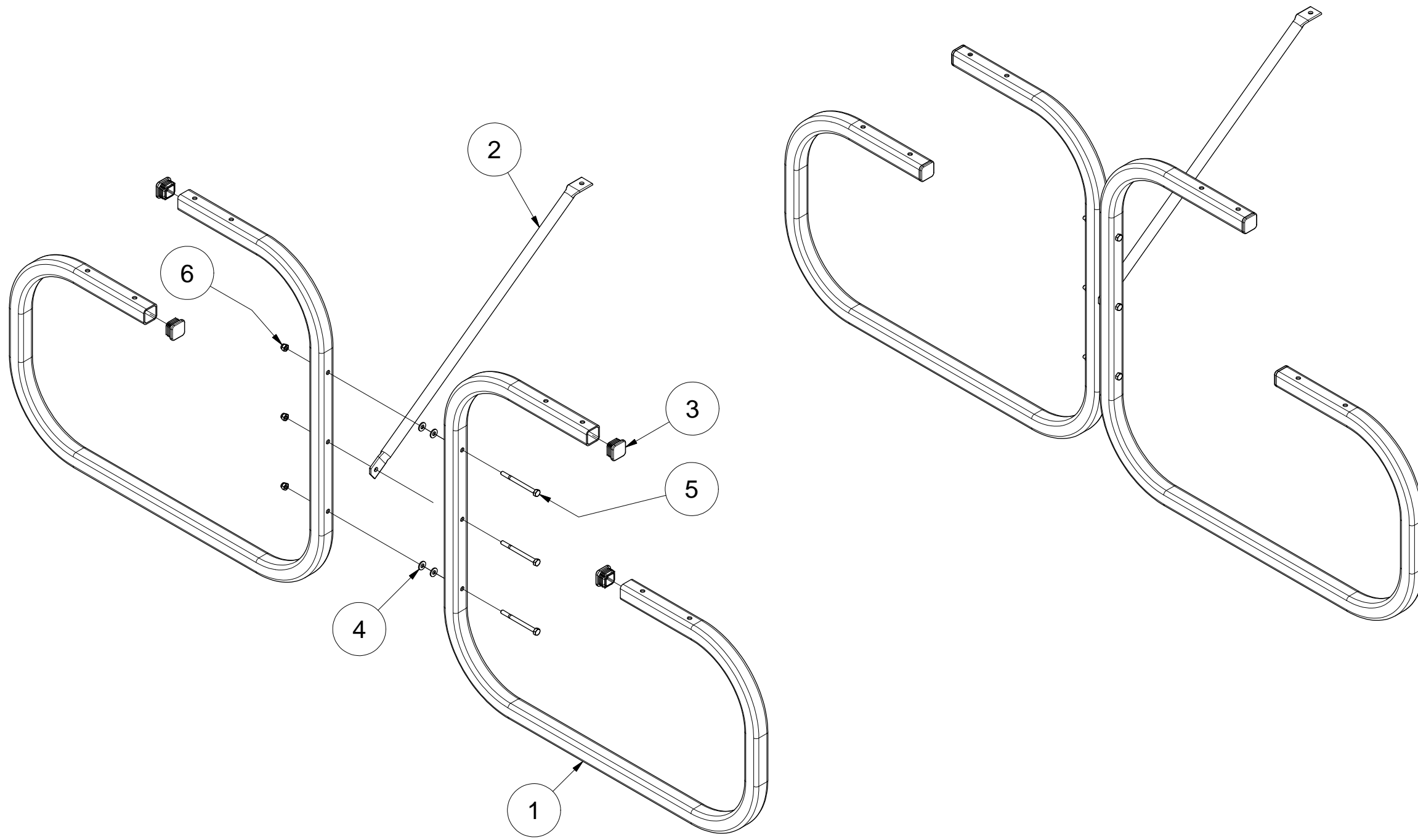
All dimensions are in inches
unless otherwise specified

Title: Complete Assembly

Project / Model: Picnic Table

Part Number: 40-1506-001-01-0004

Rev: 00 B



Approximate Weight:
22.31 lbmass

Designed by:
Practifab

Drawn by:
Philippe Dauphin

Date Modified:
2015-06-22

Approved by:

Date:

Status:

Page:
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Scale:
1:8

All dimensions are in inches
unless otherwise specified

6	LN-0022	Nylon Lock Nut	3	Nylon Lock Nut - 1/4-20 UNC	
5	HB-0014	Hex Bolt	3	Hex Bolt - 1/4-20 UNC - 3.25 - Zinc	
4	FW-0036	Flat Washer	4	Flat Washer 1/4 - narrow - Type A	
3	40-1506-001-01-0014	Square Finishing Plug for Tubing	4	Ribbed, Fits 1-1/4" Tube OD and 1.1"-1.17" Tube ID	
2	40-1506-001-01-0002	Leg Brace	1		
1	40-1506-001-01-0000	Table Leg	2		
Item	Part Number	Title	Qty	Description	Rev

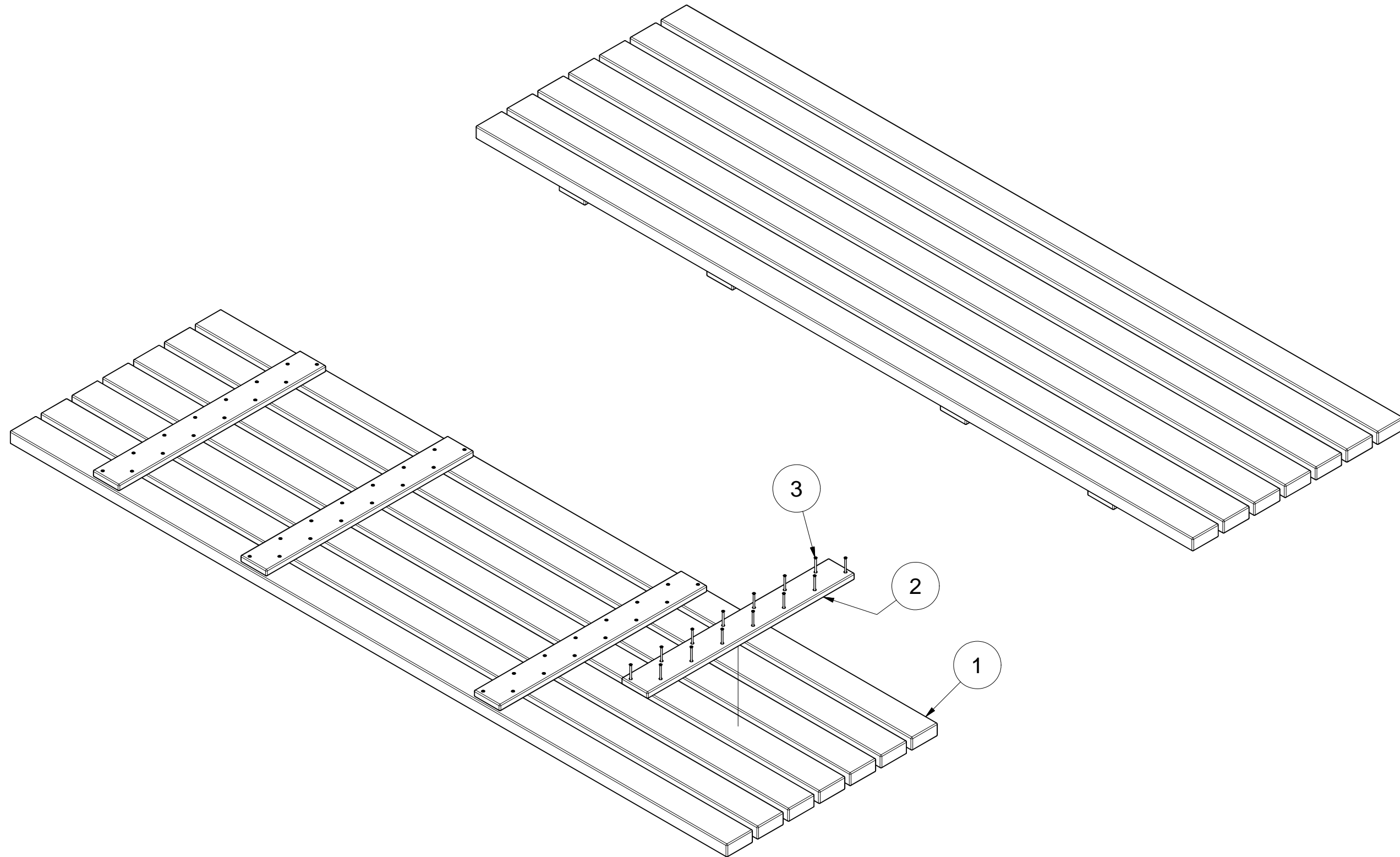
Parts List

Title: **Leg Assembly**

Project / Model: **Picnic Table**

Part Number: **40-1506-001-01-0001**

Rev: **00** **B**



Approximate Weight:
57.77 lbmass

Designed by:
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Drawn by:
Philippe Dauphin

Date Modified:
2015-09-02

Approved by:

Date:

Status:

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Scale:
1:10

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unless otherwise specified

3	40-1506-001-01-0015		56	Deck Screw, #8, 2" Long	
2	40-1506-001-01-0006	Table Top Cross Member	4	Standard 1x4	
1	40-1506-001-01-0005	Table Top Long 2x4	7	Standard 2x4	
Item	Part Number	Title	Qty	Description	Rev

Parts List

Title:

Table Top

Project / Model:

Picnic Table

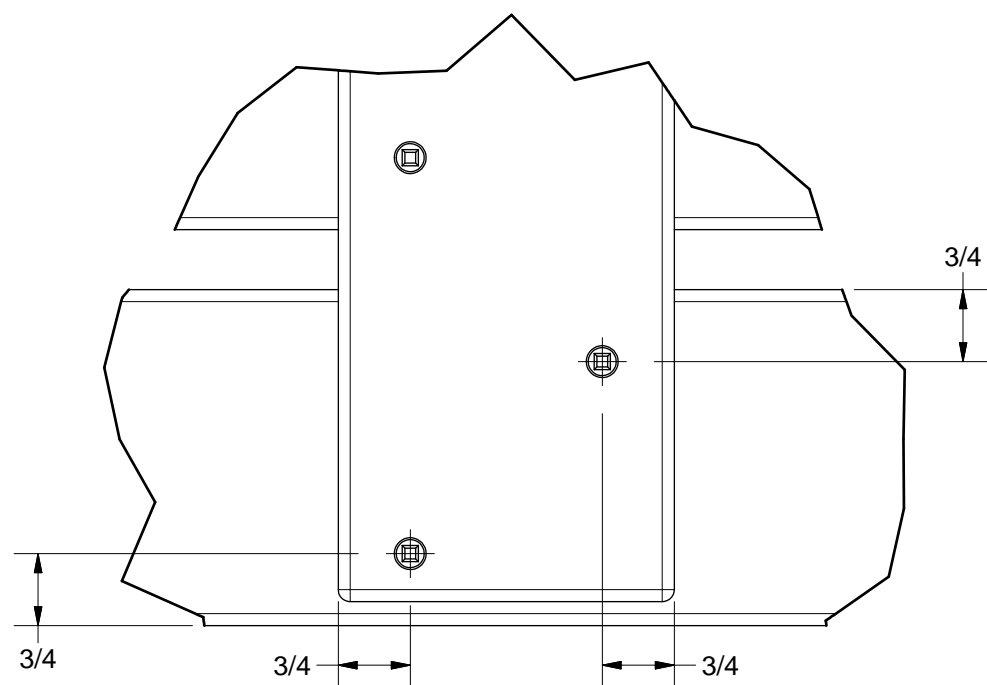
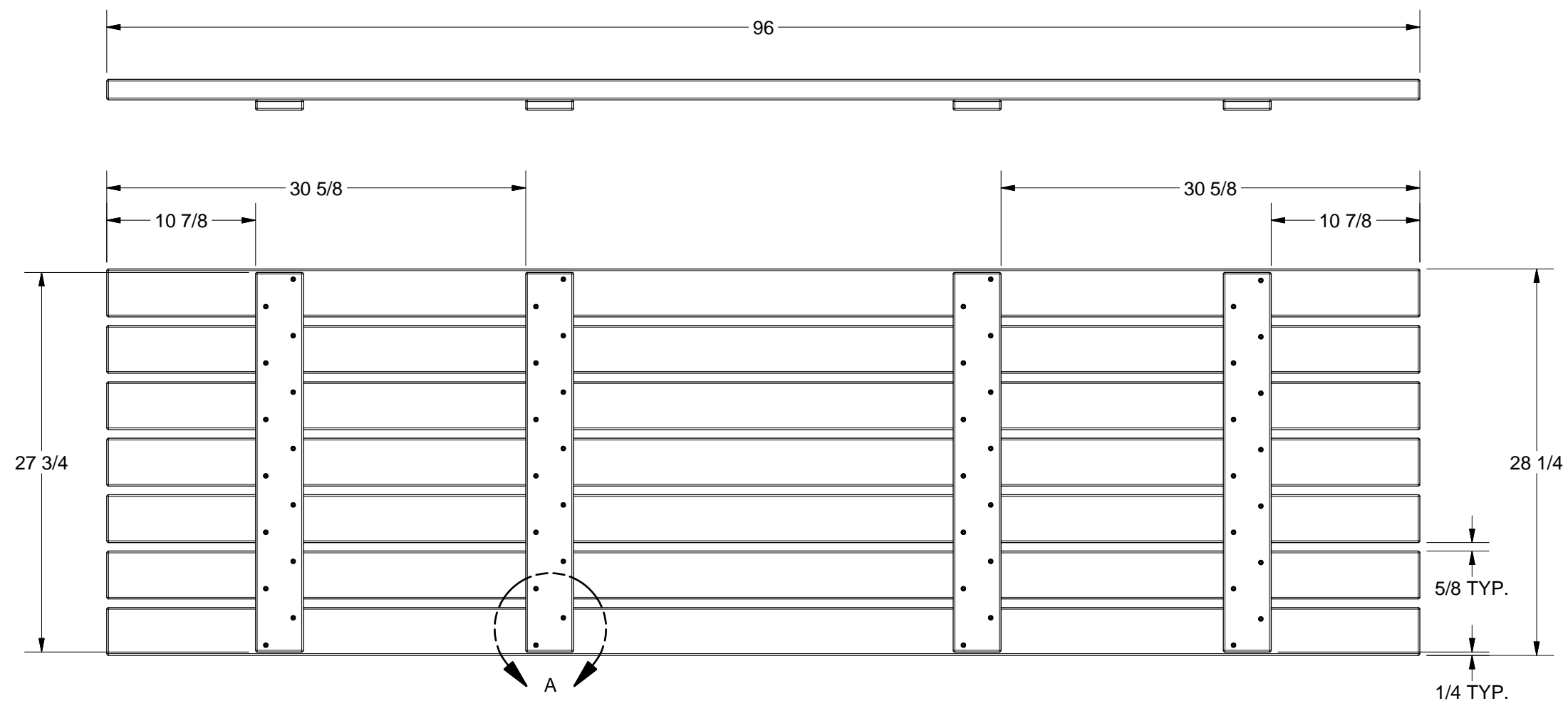
Part Number:

40-1506-001-01-0007

Rev:

00

B



DETAIL A
SCALE 1:2

Approximate Weight:

57.77 lbmass

Designed by:

Practifab

Drawn by:

Philippe Dauphin

Date Modified:

2015-09-02

Approved by:

Date:

Status:

Page:

2 of 2

Scale:

1:10

All dimensions are in inches
unless otherwise specified

Title:

Table Top

Project / Model:

Picnic Table

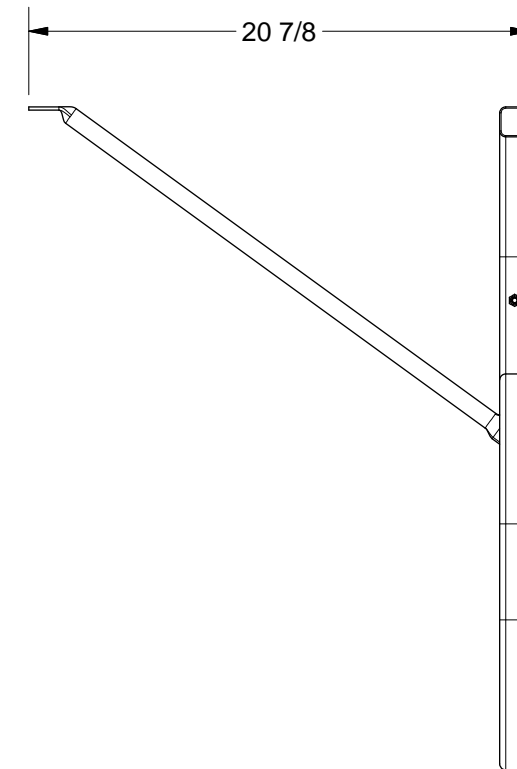
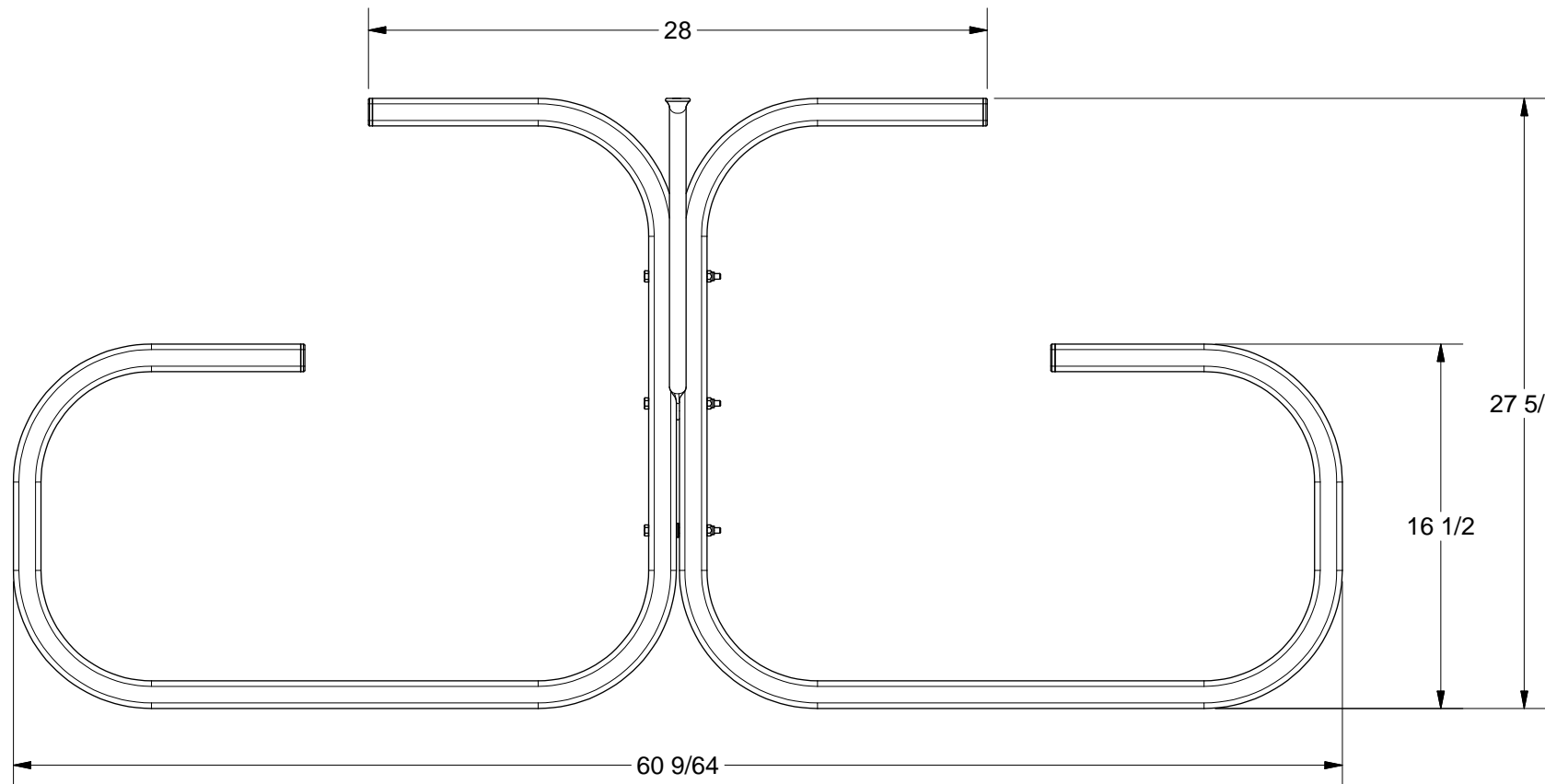
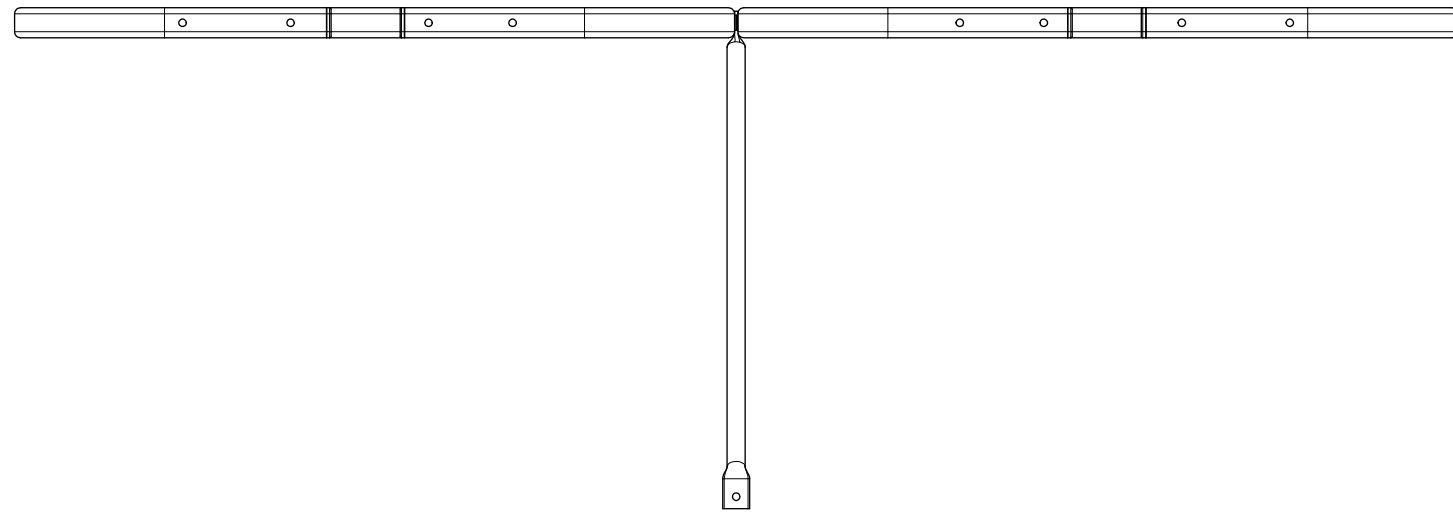
Part Number:

40-1506-001-01-0007

Rev:

00

B



Approximate Weight:
22.31 lbmass

Designed by:
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Drawn by:
Philippe Dauphin

Date Modified:
2015-06-22

Approved by:

Date:

Status:

Page:
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Scale:

All dimensions are in inches
unless otherwise specified

Title:

Leg Assembly

Project / Model:

Picnic Table

Part Number:

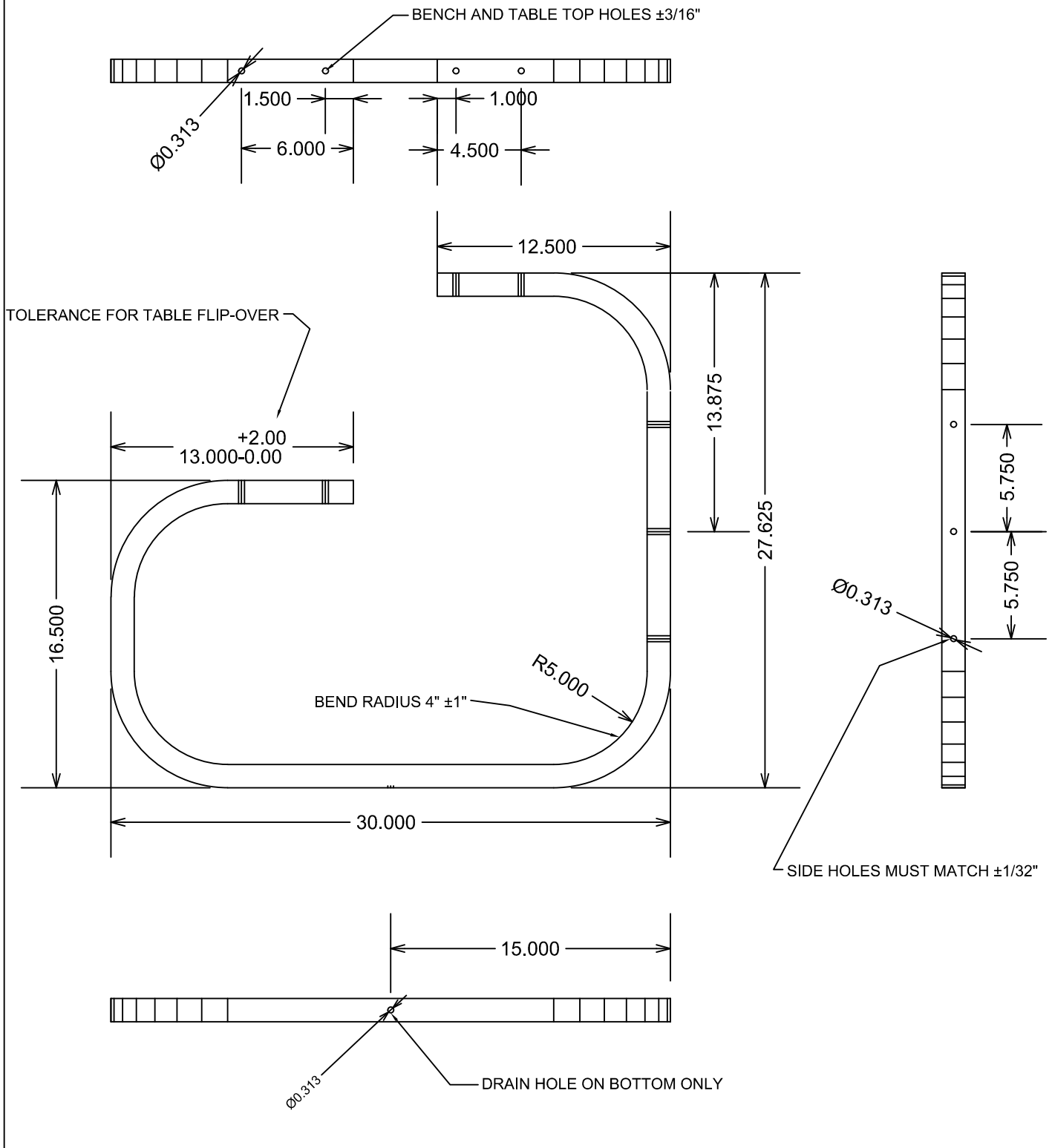
40-1506-001-01-0001

Rev:

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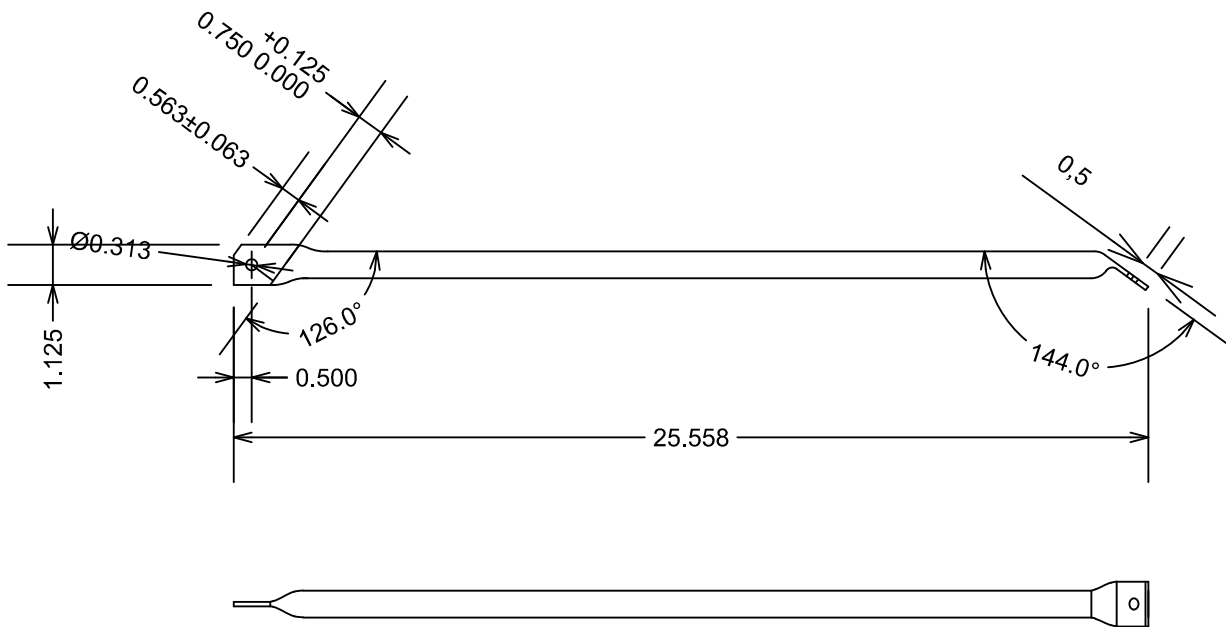
B

NAME:	BENT STEEL PICNIC TABLE LEG
PART#:	PF - 001-001
MATERIAL:	.100 X 1 1/4" HSS SQUARE TUBE
TOLERANCE:	± .25" UNLESS OTHERWISE
UNITS:	DIMENSIONS IN INCHES
FINISH:	LIGHT GRIND - NO SHARP EDGES



design by:	page:	drawn for:	drawn by:
Practifab Inc.		practifab	E. de St Croix
	title:	name:	
	Bent Steel Picnic Table Leg Kit		

NAME:	PICNIC TABLE BRACE
PART#:	PF-001-002
MATERIAL:	.063 x3/4" REW ROUND TUBE
TOLERANCE:	±.125 UNLESS OTHERWISE
UNITS:	INCHES
FINISH:	LIGHT GRIND NO SHARP EDGES



Brace tube cut to 25.75" long before bending
 Ends crushed, drilled and bent

design by: Practifab Inc.	page: 1	drawn for: practifab	drawn by: E. de St Croix
title: Bent Steel Picnic Table Leg Kit		name:	