

BRUSHING METHOD

TRANSLUCENT FINISHES ON ACCOYA®

APPLICATION GUIDELINES



The following information provides an overview of the application of brushed translucent finishes to manufactured joinery items such as windows, doors and conservatories. It has been designed to help manufacturers adopt good working practices in their manufacturing and coating process, ensuring service life is maximised. This information must be used in conjunction with the relevant coating specification and product technical data sheets. Additional, more detailed information sheets are also available.

KEY CONSIDERATIONS

DESIGN

- Cills and non-vertical surfaces must show efficient water shedding characteristics, with a slope angle of no less than 9°.
- Surface tension causes wet paint to flow away from sharp edges leaving them relatively unprotected. A minimum radius of no less than 3mm is required to avoid thinning of the coating system in accordance with British Standard 644.
- Interior edges should be rounded to at least 1.5mm radius.
- The design must preclude obvious water traps. Any gaps or recesses in the joinery should be sufficiently wide to prevent capillary draw of water into holding areas. We typically recommend a 3mm gap.
- Fixing pins, particularly on horizontal glazing beads, must not allow the ingress of water. If pins are punched below the surface, filling must be carried out to ensure that a water collecting hollow is not produced. Secondary filling may be necessary to account for shrinkage.
- As a minimum, the construction guidelines set out in BS 644 should be followed at all times.

TIMBER QUALITY

Accoya is a chemically modified softwood with excellent stability in damp climates, Accoya is one of a number of chemically and heat modified timbers now being offered in the market. The treatment can affect the timber's resistance to surface mould growth and application of a surface applied preservative is recommended.

Accoya readily accepts both translucent and opaque coating systems where its inherent stability can extend coating life. Exposed end grain should be sealed with two coats of TEKNOSEAL 4000 to minimise moisture ingress.

MOISTURE CONTENT

Moisture content of the timber at the time of coating should be below 10% on Accoya timber. Readings above 10% suggests free water is present in the substrate which could result in impeding the curing of the coating system.

SANDING

- Sanding is commonly used for small scale, purpose-made, joinery and finishing results can be greatly improved by limiting sanding and denibbing processes, and selecting the appropriate grade of abrasive paper.
- This is very important where automatic drum sanders are used. The grit of the belt on the first drum should be as fine as possible to prevent the substrate being ripped open, ideally 120, with subsequent belt grades coordinated to close the surface and the finishing belt 220 or 240 grit.

FILLERS

- Any significant defect should be filled using a two component filler suitable for use with wooden components and in colour to the finished shade prior to the application of the coating system.
- Some hard wax fillers are suitable for use with Teknos products although we do not recommend the use of soft wax fillers on external joinery due to the extremes of temperature that can occur.

ENVIRONMENTAL & STORAGE CONDITIONS

- All coating products must be kept away from frost and cold draughts, and they should ideally be stored at a constant temperature above 10°C. Containers should never be stored on the floors, which can become very cold in winter.
- Do not apply in extremes of temperature. The most suitable temperature range is between 10°C and 20°C. Humid conditions will prolong the "wet edge" time of the coating and warm windy conditions will reduce it. When possible avoid application in direct sunlight.
- When painting, surface temperatures must be at least 3°C above the dew point to prevent moisture condensation during the drying process.

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PREPAINTING TREATMENTS

TEKNOSEAL 4000

After applying the Combi Primer 2907 any exposed end grain must be sealed using TEKNOSEAL 4000. TEKNOSEAL 4000 is supplied ready to use and should not be thinned. Re-seal containers after use to prevent evaporation and skinning.

APPLICATION

In order to achieve optimum performance two generous brush coats must be applied to all areas of exposed end grain. Vulnerable areas such as doors, stiles, projecting cills and cut glazing beads require special attention.

DRYING TIME @ 23°C/60% RH

1. Touch dry after 30 minutes
2. Recoatable after one to two hours



TEKNOSEAL 4000 applied by brush to exposed end grain after applying Combi Primer 2907.

PAINT PRODUCTS

This section gives a general description of a typical brushing Translucent coating system. It should be read together with the detailed specification and technical data sheets for your particular application.

PRESERVATIVES	
Combi Primer 2907	Waterborne tinted preservative that protects against Blue stain fungi.
TOPCOATS	
Helo Aqua 20/40/80	A water-based tinted translucent topcoat, which enhances the natural beauty of timber
ANCILLARY PRODUCTS	
Teknos V JOINT SEALER	Teknoseal 4009
TEKNOSEAL 4000	End grain sealer

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BRUSH APPLICATION GUIDE

The brush application of waterborne and solvent borne materials requires different techniques, mainly due to the shorter drying times of waterborne coatings and their reduced flow.

Most of the application principles which apply to waterborne materials also apply to solvent borne coatings, but the application tolerance of waterborne coatings is lower and they are less forgiving of abuse. However, the benefits of very low solvent levels, rapid drying and good durability, due to the flexibility of the dry coating, far outweigh the application differences which are easily overcome by experience and following a few simple steps.

Use a good quality long haired synthetic brush; a short haired or worn brush may leave lines in the dry coating film. Prior to application thoroughly wet the brush with water, ensuring that the base of the bristles (the heel of the brush) is fully wetted.

A variety of brushes are now readily available which are specifically made for the application of waterborne coatings. The bristles are generally manufactured from synthetic materials.

STEP BY STEP

For the best results a three stage application technique should be developed:

1. Load the coating generously onto the substrate and disperse over the surface.
2. Even out the coating with light diagonal cross strokes - DO NOT OVERBRUSH - the coating will flow and level naturally.
3. Finish the application with light brush strokes in the direction of the grain.

With practice an even coat to be applied quickly. An even coating film is important for durability and also for appearance, particularly in the case of translucent wood stain.

Do not apply in extremes of temperature. The most suitable temperature range is between 5°C and 20°C. Humid conditions will prolong the "wet edge" time of the coating and warm windy conditions will reduce it. When possible avoid application in direct sunlight.

EQUIPMENT CLEANING

Application equipment can normally be cleaned using cold water. Under certain circumstances it may be advantageous to use warm soapy water. Please refer to our brushing information sheet.

PAINT APPLICATION

This section describes a typical coating sequence and should be read in conjunction with your specification. Additional information sheets are available, covering issues such as drying parameters, treatment of end grain, site care and storage, surface preparation, and joinery design and installation.

COAT 1: BASE STAIN	
PRODUCT	Combi primer 2907 - Teknos do not recommend colourless coatings for exterior use.
PRODUCT PREPERATION	All products are supplied ready for use, stir thoroughly before application.
APPLICATION	Using a good quality long haired synthetic brush; apply liberal coat to all surfaces, in line with Teknos data sheet guidelines and specification. Touch dry after 1 hour. Recoat after 2 hours. *Weather dependent

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COAT 2: PRIMING	
PRODUCT	Helo Aqua Base 20/40/60
PRODUCTION PREPERATION	All products are supplied ready for use, stir thoroughly before application. Teknos do not recommend Colourless coatings for exterior use.
APPLICATION DRYING TIME (@23°C/60%RH)	Using a good quality long haired synthetic brush; apply a good even coat to all surfaces, in line with Teknos data sheet guidelines and specification. The wet film thickness should be 50 µm. Touch dry after 1 hour. Recoatable after 3 hours. <i>*Weather dependent.</i>
DENIBBING	Denib all surfaces to remove any raised fibres using a fine grade abrasive between 180 and 220 grit. Nylon and foam filled denibbing pads are very useful for denibbing, particularly on mouldings and profiled sections. The fine grit efficiently removes protruding fibres while discouraging over sanding and the removal of coating from edges. Check all surfaces for any defects. Ensure all residual dust is removed from the surface of the joinery items.
V-JOINTS	Apply a continuous bead of Teknos V JOINT mastic to the width of the joint and smooth with a damp sponge, cloth or squeegee, to ensure good penetration and levelling in the joint. Alternatively, apply an adhesive generously to all surfaces to be bonded, using light pressure to form the joints and excess adhesive to seal any exposed end grain and construction joint. This can also be used to cap all lower internal joints in mid and bottom rail rebates.
COAT 3: MID COAT	
PRODUCT	Helo Aqua Base 20/40/80 - Teknos do not recommend Colourless coatings for exterior use.
PRODUCT PREPARATION	All products are supplied ready for use, stir thoroughly before application.
APPLICATION DRYING TIME (@ 23°C/60%RH)	Using a good quality long haired synthetic brush; apply a good even coat to all surfaces, in line with Teknos data sheet guidelines and specification. The wet film thickness should be 50 µm. Touch dry after 1 hour. Recoatable after 3 hours. <i>*Weather dependent.</i>
COAT 4: TOP COAT	
PRODUCT	Helo Aqua Base 20/40/80
PRODUCT PREPARATION	All products are supplied ready for use, stir thoroughly before application.
APPLICATION DRYING TIME (@23°C/60%RH)	Using a good quality long haired synthetic brush; apply a good even coat to all surfaces, in line with Teknos data sheet guidelines and specification. The wet film thickness should be 50 µm. Touch dry after 1 hour. Please allow 2 days for through drying with final hardness achieved in 1 week.

TEKNOS, THE PERFECT COATINGS PARTNERSHIP FOR ACCOYA®

Teknos coated Accoya® has been tested over many years and found to be one of the most effective coatings partnership for external joinery. Accoya® is ideal for windows, doors, cladding, decking and structural wood construction. Coating with Teknos paints not only gives a beautiful finish but also prolongs the service life of the timber and the coatings. Improved service life means reduced maintenance costs.

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