

# ESSENTIAL COATINGS GUIDE FOR JOINERY MANUFACTURERS USING ACCOYA® WOOD

## INTRODUCTION

Accsys has gained considerable knowledge and experience of coatings through partnerships developed with several leading coatings suppliers. Although standard practices may vary between countries, it's important to note the following guidelines, in combination with the best practices and advice of the coating supplier. When coating Accoya wood it's strongly recommended to follow these supplemental guidelines whenever possible to achieve a quality finish. For specific coating products enquiries, it's always best to consult the experts at your coating supplier.

## BEST PRACTICE FOR JOINERY MANUFACTURERS:

- 1 A fully factory applied joinery coating is strongly recommended. If site finishing is required, then at least a primer and mid coat should be applied in the factory and the top coat must be applied before the coated product gets wet on site.
- 2 Accoya wood must be dry, clean and free from dust when coated. This is critical when brush applying top coats on site. Please see Section 03 of the Accoya Wood Information Guide for moisture testing techniques.
- 3 When using an opaque base coat an effective and well applied stain blocking primer is included.
- 4 Translucent coating systems should contain an effective mouldicidal component to protect the wood from unattractive moulds and mildew. As with other wood types and being a natural material, the porosity of Accoya may vary. Therefore when applying translucent stains, it is advisable to test a sample area first.
- 5 Surface preparation is recommended to achieve a more uniform appearance with translucent coatings. Planed surfaces that are left for a period also benefit from surface preparation by sanding, fladding or textured brushing, helping to balance and freshen the surface. See "section 4" - Sanding, in the Accoya Wood Information Guide. Accoya has a pH range of 4-5.5.
- 6 Sealers must be used effectively on all end grain throughout the joinery, with a product that is compatible with the paint system and approved by the coating manufacturer.
- 7 Dip and flow coat application of the first coating layer is widely practiced for all wood joinery and is particularly effective in forming an all-encompassing first coat. Monitor and control the level of wetting of Accoya during the flow-coat, dipping and deluge application process. Accoya is more porous than hardwood and some softwoods. Excessive wetting should be avoided as this can significantly extend drying times.
- 8 Coating manufacturer's application methodologies and guidance should be followed with particular focus on, avoiding aeration in the coating film when spraying, cold coatings (should typically be above 15°C at application), correct film thickness and appropriate drying techniques / conditions.
- 9 Opaque coatings with calcium carbonate (chalk fillers) can cause coating blistering on Accoya and should be avoided. Please consult coating supplier.
- 10 Coatings should be thoroughly cured in a moisture and temperature controlled environment and in line with coating manufacturers guidelines. This often involves overnight drying between layers. Control is particularly important in colder months.
- Coated joinery should be stored on site as per coating manufacturers guidelines.
- 10 It is strongly recommended to use corrosion resistant hardware with Accoya joinery. However applying 3 layers of paint behind hardware that may be prone to corrosion helps by creating a partial isolation barrier between it and the wood. It is also good joinery practice to spray inside any lock housings and apply end grain sealer. Please see the Accoya Wood Information Guide Section 06 for more details.

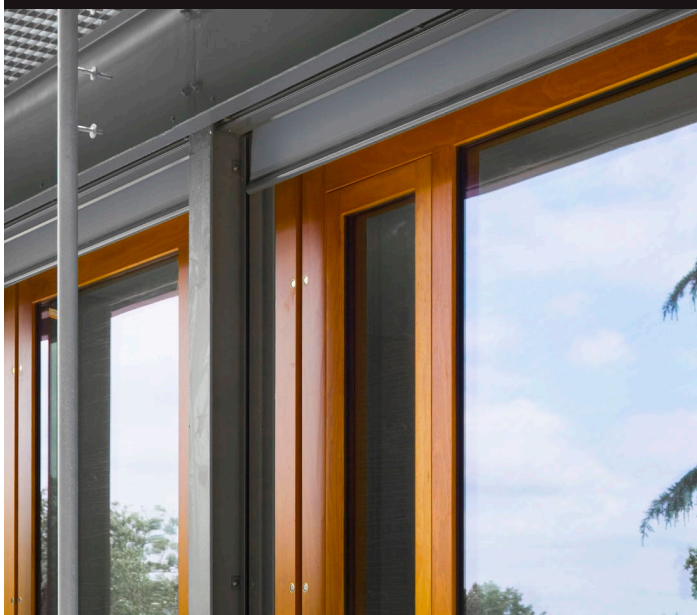
COATINGS ARE APPLIED TO ACCOYA LARGELY FOR AESTHETIC REASONS. GUARANTEED LEVELS OF DECAY RESISTANCE, TERMITE RESISTANCE AND DIMENSIONAL STABILITY APPLY TO ACCOYA WITH OR WITHOUT COATING.

Please note: coating formulations vary per manufacturer and processes vary depending on the application equipment used and the end-product design. Formulations of some manufacturers' products vary by geography. Despite Accoya® wood's excellent compatibility, we highly recommend having the coating manufacturer involved in the process as they have in-depth knowledge of their products, suitable application techniques and how to determine the performance of the finished product.

For further information and support, please be sure to contact your coatings manufacturer.

Additional related references at [accoya.com/downloads](http://accoya.com/downloads):

- System partner information sheet (coatings)
- System partner coating brochures
- Wood Information Guide



Discover more at [www.accoya.com](http://www.accoya.com)

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