

ESSENTIAL COATINGS GUIDE FOR JOINERY MANUFACTURERS WHEN USING ACCOYA® WOOD

INTRODUCTION

Accsys Technologies has extensive partnerships with many coating manufacturers and has gained a lot of valuable experience of joinery coating over the years. Although practices may vary from country to country, in line with best joinery practices and coating manufacturers advice, it is important to note the following guidance when coating Accoya wood. We strongly recommend taking good notice of this guidance and would encourage you to adopt these methods whenever possible. As these guidelines are supplemental to advice from coating manufacturers, please consult your coating supplier at all times.

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 joinery 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, preferably an effective and well applied anti 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 Sealers must be used on all end grain throughout the joinery, with a product that is compatible with the paint system and approved by the coating manufacturer.
- 6 Dip and flow coat application of the first coating layer is widely practised in the Netherlands and Germany for all wood joinery and is particularly effective in forming an all-encompassing first coat.
- 7 Coating manufacturer's application methodologies and guidance should be followed with particular focus on avoiding cold coatings (should typically be above 15°C at application), correct film thickness and appropriate drying techniques / conditions.
- 8 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.
- 9 Coated joinery should be stored on site as per coating manufacturers guidelines.
- 10 It is strongly recommended to use corrosion proof hardware with Accoya joinery. However, applying 3 layers of paint behind hardware that may be prone to corrosion helps creating an 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.

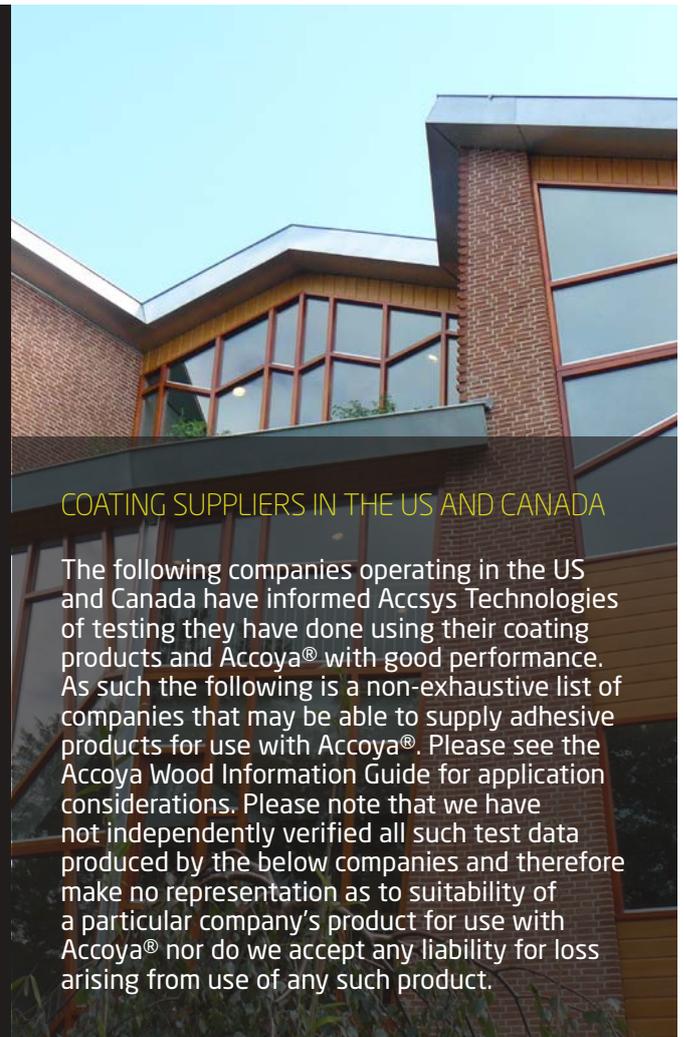
COATINGS ARE APPLIED TO ACCOYA LARGELY FOR AESTHETIC REASONS. GUARANTEED LEVELS OF DECAY RESISTANCE, TERMITE RESISTANCE AND DIMENSIONAL STABILITY APPLY TO ACCOYA WITH OR WITHOUT COATING.

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. Visit the System Suppliers link in the Download section of Accoya.com for a list of suppliers with Accoya® experience in your region. Accsys Technologies Sales or Technical Sales Managers are also on hand to offer additional support and may be contacted at info@accoya.com.

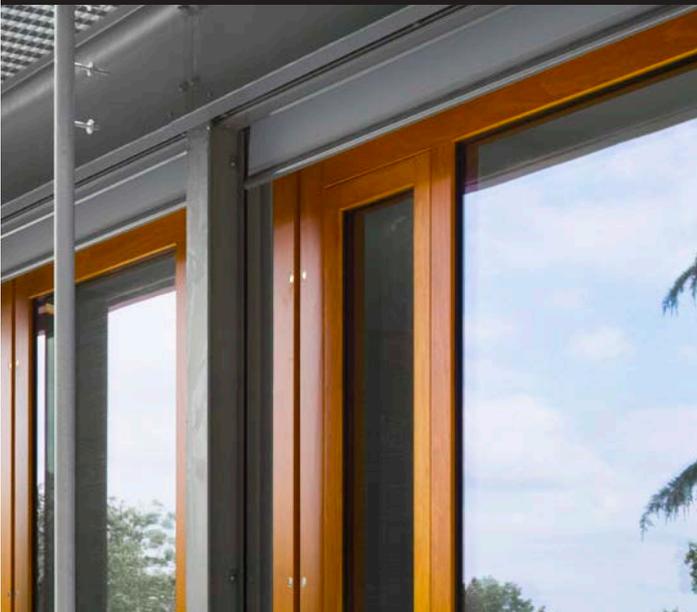
Additional related references at accoya.com/downloads:

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



COATING SUPPLIERS IN THE US AND CANADA

The following companies operating in the US and Canada have informed Accsys Technologies of testing they have done using their coating products and Accoya® with good performance. As such the following is a non-exhaustive list of companies that may be able to supply adhesive products for use with Accoya®. Please see the Accoya Wood Information Guide for application considerations. Please note that we have not independently verified all such test data produced by the below companies and therefore make no representation as to suitability of a particular company's product for use with Accoya® nor do we accept any liability for loss arising from use of any such product.



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