



REDWOOD



Factory Method Statement

Opaque Coatings





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1. Introduction and Purpose of Method statement

The purpose of this method statement is to provide an overview of the application of factory-applied opaque finishes to joinery produced from Accoya. This method statement helps manufacturers to adopt the best protection and quoting practices to enhance the lifecycle of Accoya products. Please refer to the relevant technical data sheets and the Accoya Wood Information Guide in conjunction with this method statement.

2. Design Consideration

Water plays an important role in the degradation mechanism of joinery. Windowsills and non-vertical surfaces shall be inclined to shed the water away from the window with a slope of no less than 9°. Water absorption will modify the physical properties of coatings and may cause chemical change. During the application, thinning of the coating shall be avoided at sharp edges, as surface tension can cause the wet paint to cling under the horizontal surface. Thinning of coating can be avoided by keeping the minimum radius not less than 3mm as per British standard 644. For interior edges we recommend a radius of no less than 1.5mm. Transportation of water through capillary action can be avoided or reduced by widening the gaps or recesses in joinery. Our experts recommend that the gaps should be more than 3mm.

3. Why Opaque Finishes?

The design of any exterior coating for wood requires control of many factors in order to maximise the service life. Opaque coatings protect against moisture, oxidation, and UV light. The opaque coating is highly demanding because of its good resistance to UVA and UVB and corrosive chemical agents. In comparison to a clear “varnish,” the opaque coating is more durable and requires less frequent maintenance. Our product provides protection to the exposed wood surface and offers long-term protection against weathering.





4. Pre-coating activities

4.1. Moisture Content

The prime means of controlling long-term moisture levels is a good design and appropriate preservative treatments. The moisture content of Accoya must be <8% prior to starting the coating procedure by the manufacturer.

4.2. Sanding of Wood Surface

An appropriate grade of abrasive paper shall be selected for sanding the Accoya surface and to avoid ripping of the substrate. The surface of the wood can be rougher if you sand across the grain, the process of sanding shall be done under the supervision of an expert. Care should be taken when using power tools like Orbital sanders to prevent differential erosion between the early and late growth. The grit of the belt should be appropriately selected, ideally 120 with subsequent belt grades coordinated to close the surface and finishing belts 220 or 240 grit.

4.3. Filling of Damaged Surfaces

Prior to starting the coating, the surface of the Accoya shall be checked thoroughly. Any cracks, damaged and defective surfaces shall be filled with suitable material/wooden components.

- The small gaps and cracks can be filled with a fine surface filler “**Zobel Acrylspachtel**”.
- For some significant damages, the wood can be filled with hard wax “**Bonda Woodfill**” to fill the holes.

For external joinery, due to exposure to extreme weather and temperature, the filling with soft wax filler is not recommended.

4.4. Cleaning and degreasing of wood surface

The working area should be free from any dust, salt, and grease. Always keep proper housekeeping in the final finishing area. Don't place the final product directly on the floor, plastic sheets or cardboard shall be used to place the wood on the floor. Ensure that the wood surface is free from remaining cleaner, dirt, powder and contamination. In case of doubt, a test coating should be carried out.

4.5. End Grain Sealer & Knotting Solution

Any exposed end grain must be sealed with “**Zowo-Seal 5008**”. Apply the end grain sealer “**Zowo-Seal 5008**”, 1 coat is normally sufficient but two coats, 45 minutes apart, can be applied for extra protection.

5. Safety, Environment Protection, Storage & cleaning Procedures

Appropriate Personal protective equipment P.P.E (mask, gloves, and safety glasses) shall be used while performing all activities during the joinery coating. All coating products should be stored in a dry and cold area. Coatings should be stored at a controlled temperature which is recommended 10°C and must be kept away from frost and cold draughts. Ensure adequate ventilation in the storage area, never keep material with open lids/covers. Storage should be on racks or pallets, avoid storage directly on the floor as cold weather can lead to the extreme temperature of the floor. No smoking, naked flames, and hot work in/adjacent to the storage area. Stack the material properly and never stack material too high.



Condition	Desired Parameters	
	Temperature	Humidity
Factory Condition	15°C - 25°C	40% - 70%
Drying Area	18°C - 30°C	30% - 50%

Temperature and humidity parameters outside these conditions will impact the coating ability to dry, cure and long-term performance ability. Adequate ventilation should be arranged to replace the damp air with fresh dry air on hourly basis. Tools can be cleaned immediately after use with water or Zowo-Clean Hydro Cleaner.

6. Products

Zowotec 263	Opaque Impregnation Primer for Dipping, flow coating, brush or spray & brush application		
Zowotec 385	Intermediate Opaque Coat for spray or brush application	Wet Film Thickness 150µm – 175 µm	Drying C.a 6 hours
Zowotec 480	Opaque Topcoat for spray or brush application	Wet Film Thickness 150µm – 175 µm	Drying Overnight
Zobel V Joint Filler	V Joint Filler		
Zobel 5008	End grain sealer		
Zobel Acrylpachtel	Fine surface filler		

Pump Settings/nozzle sizes

Spray Parameter	Nozzle (mm)	Pressure (bar)	Atomising Pressure (bar)
Airmix	11/20	100-140	0-1.5

Further details relating to these products can be found on the Technical Data sheets for these products.



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