

**Opaque - 4-layer coating system – SW-900/ZW-425/ZW-425/DW-691**

Operation (application process method)	Material loading
<b>Surface Preparation</b> The substrate shall be prepared by either a suitable quality of planing or where this is not sufficient to provide a smooth finish for subsequent coatings, then we would recommend the surface is prepared by sanding with abrasives between P120 and P180. Ensure the substrate is clean, dry and free from dust, dirt, grease, silicone and wax. When coating timbers with high natural oil or tannin content such as Iroko, degrease first with a suitable thinner.	
<b>Preservative – Induline SW-900</b> Clear impregnating preservative applied by brush, dip, flow coating, low pressure deluge or saturate spraying in closed environments.	80 - 90 ml/m <sup>2</sup>
<b>Primer – Induline ZW-425</b> Stain blocking and grain filling primer. Manual and automatic spraying.	150µm wft
<b>Joint and end grain sealing – Induline SW-910 / Induline AF-920</b> Apply a liberal coat of Induline SW-910 end grain sealer by brush to all exposed end grain sections prior to application of spray finishes. Where V-grooves are present, apply Induline AF-920	
<b>Intermediate Coat – Induline ZW-425</b> Stain blocking and grain filling mid coat. Manual and automatic spraying. Following the intermediate coat, de-nib as necessary and remove all sanding dust.	150µm wft
<b>Top Coat – Induline DW-691</b> Apply by manual or automatic spraying. If a dark colour is being applied then a double layer of top coat may be preferable. In that case the intermediate layer coat of ZW-425 is not required.	150µm wft

wft = wet film thickness

**Notes:**

End grain sealing is very important as the open nature of the grain promotes a high risk of water uptake. Take great care to seal the end grain areas very comprehensively with Induline SW-910 as instructed above. On Accoya, apply the end grain sealer twice.

Higher dry film builds take longer to through dry and become fully water resistant. Excessively high dry film builds of more than 200µm can lead to a non-vapour permeable coating system which is not advisable on timber. A minimum dry film loading of 100µm is recommended.

Application rates and coverage are theoretical and do not allow for surface profile variation, wastage or variation in application technique. Usage will be higher when saturate spraying.

Please read the Technical Application Sheets of each product prior to use to familiarise yourself with the application equipment settings, drying and general use of product.

Joint integrity must be maintained at all times to prevent the ingress of water, therefore a suitable gap filling adhesive, such as Frencken 0819 should be employed. The use of a suitable adhesive and the Remmers end grain and V-joint sealers are critical to reduce water uptake.

It is important to through dry the coating in the factory to achieve full coating resistance to the most severe UK weather conditions. Remmers recommend 72 hours drying at 15°C or above (including good air circulation). During colder periods (winter) factory conditions may change, then the figure of 72 hours must be extended. Further information can be obtained from the Remmers Wood Coatings Technical Department.

Correct care and maintenance of the system are crucial to long-term performance. Refer to the relevant Remmers care and maintenance advice sheet. If you are in any doubt or would like further advice, please contact the Remmers Wood Coatings Technical Department.

The quality of the coating system is only as good as the substrate will allow. Remmers cannot be held responsible for poor joinery design, timber with the wrong moisture content, defects and contamination on the timber surface and issues caused by incorrect handling of the finished item both in the factory and on site. For more information please contact the Remmers Wood Coatings Technical Department.

*This has been prepared based on Remmers' current knowledge and experience of current best practice in the fields of coating application, timber technology and joinery and building design. Such best practice advice is always subject to change. Remmers cannot be responsible for the application of the coating and the extent to which our customers adhere to this best practice. In case of changes in the parameters of the application, such as changes in substrates, or in case of a different application, consult Remmers' Technical Team prior to using Remmers products. Any quantities shown are for guidance only and the user must allow for variations in temperature, surface profile, absorbency and wastage. The user of the product must test the product's suitability for the intended application and purpose. Except as expressly stated in writing Remmers' warranty is governed exclusively by our current Standard Terms and Conditions of Sale. In particular, Remmers does not warrant the correct application of its products.*