



**sikkens**  
WOOD COATINGS

*Passion for wood*

## Checklist for wood processing

	<b>Recommendation</b>	<b>Reasons</b>
<b>Wood</b>	The moisture content in the wood must be between 12% and 15% for processing; wood very quickly loses its moisture and must then be moistened.	Wood moisture content below 12% mainly causes conifers, but also hardwoods, to swell noticeably.
<b>Coating</b>	Use additional impregnation for coniferous woods.  Use end-grain protection to prevent moisture ingress.	See DIN 68800-3 Sapwood has always resistance class 5  Adding an adhesive to the mortise and tenon area does not guarantee that the end grain will be completely closed everywhere. A capillary gap exerts strong suction force.
<b>Application</b>	Check the viscosity of the primer in dipping systems at least 1x daily, and several times during flowing.  Pay attention to the wet film thickness when spraying: Spray 2 x 150 µm coats wet  Spray stains with a size 9 or 11 nozzle (0.23 to 0.28 mm); Spray white and colored lacquers with a size 11 or 13 nozzle (0.28 to 0.33 mm).  Spray at a material pressure of 80-100 bar, maximum 110 bar.  Spray with an atomizer pressure of 1-1.5 bar, maximum 2 bar.	The daily climate causes some evaporation of the solvent/water so that the viscosity increases.  Too low a wet film thicknesses can result in poor results, and failure to reach the required dry film thickness. Excessive wet film thicknesses lead to delays in drying and entail the risk of blistering and sagging of the applied coat; this also negatively impacts the water vapor diffusion values.  This helps you achieve good atomization of the coating material and reduce overspray.  A higher spraying pressure means more overspray, and higher material consumption; the high application volume leads to thick edges, drips and blistering.  Too much can atomizing air can dry the paint particles on their way from the gun to the building element; the finish is then rippled (orange peel effect).



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<b>Transportation</b>	Mount your windows on the overhead rail in the orientation in which they will be installed later on.	Overspray drops and the painter also habitually paints the lower section more slowly; the effect that results from this is that the window's problem zone is given better physical protection due to a thicker coat thickness.
<b>Climate</b>	A temperature of 20 - 23 ° C and a relative humidity of 60 - 65% is recommended	The parts should be able to lose a large amount of moisture in the first 10-20 minutes after painting, so that the surface slackens well. Lower temperatures lead to delays in drying; higher temperatures can lead to shrinkage cracks and poor results.
<b>Smoothing and dedusting</b>	<p><u>Wood processing:</u></p> <p>A perfectly set up and managed hydro plane produces a very smooth wood surface that removes the need for sanding</p> <p>Sanding produces a uniformly absorbent wood surface and removes planing strokes.</p> <p><u>Intermediate sanding:</u></p> <p>If the wood surface is well prepared, and the primer has been correctly applied, intermediate sanding once only after mid coating is sufficient. You should do this with 150 grain, or a "medium-fine" sanding sponge, in the direction of the grain.</p>	<p>The ability to take up the primer is impaired by the surface tension of the water if the surface is very smooth; additional fine sanding is recommended for this reason</p> <p>Sand the wood with a fine paper (120 grain or finer) in the fiber direction to avoid sanding marks. In the stained area, color differences can otherwise occur due to excessive stain take-up.</p> <p>When sanding after priming, there is a major risk of sanding down to the bare wood.</p>



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#### Dedusting

The sanding shop should not be in the immediate vicinity of paint shop.

Sanding dust settles everywhere (on open containers, open dip tanks, freshly painted surfaces, etc.).

Vacuuming and sweeping the parts are your best options.

In this way, you can keep the work area, equipment and surfaces clean, and not immediately soiled again after dedusting.