

Information

Finishing recommendations
for 3D-veneer surfaces

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1. Transparent finishes and general information

All mouldings produced with 3D-veneer surfaces must be primed with a lacquer containing high amounts of solids first. Although, some solvent-based lacquers can be used due to their high content of solids, most of them tend to bring out the joints between the veneer strips. Therefore, a water-based acrylic lacquer is recommended as primer. Most of these hydro lacquers have a high content of solids and the water causes a swelling of the veneer layers and closes the joints.

For the final coating different systems of lacquer can be used in order to create a durable surface. In general premium polyurethane (PUR) lacquers are recommended. It is especially important for seating furniture, as the lacquer system has to be flexible and sweat resistant.

The following finishing procedure was developed and tested together with company Votteler Lackfabrik. The use of Votteler products is only a suggestion, other high quality products may work, as well.

1. Pre-treatment of wooden parts with 3D veneer: Never blow off moulded parts with compressed air, because it could open joints which could then be visible after finishing. Instead, all parts should be wiped off with a cloth or a hand brush only.
2. Priming: Apply a thin layer of water-based acrylic primer (e.g. Hydropol by Votteler), if necessary apply several layers to close all pores.
3. Sanding: Sand with sandpaper (grain 180 or 240).
4. Lacquering: Apply 1st layer of lacquer thick (e.g. Puridur by Votteler).
5. Sanding: Sand with sandpaper (grain 240) or fine steel wool.
6. Finishing: Apply 2nd layer of lacquer thin (e.g. Puridur).
7. Final sanding with fine steel wool, if necessary.

General information:

Avoid "wet on wet" lacquering because pores will stay open. If there are still open pores visible apply several thin layers of hydro based primer, always on a dry surface.

Do not use paints at temperatures below 15 degrees centigrade because of the risk of white discolorations on the surface.

2. Coloured finishes – coloured lacquers

Using pigmented lacquers results in a very uniform and consistent surface colour with visible grain structure but less transparency than staining. Pre-treatment and priming of wooden parts are also required.

1. Pre-treatment, priming and sanding (see point 1).
2. Open pored wood needs an additional layer of water-based primer.
3. Prior to applying any pigmented finish, apply one layer of clear PUR lacquer (e.g. Puridur) on the clean dry surface to avoid the pigments penetrating into the pores.
4. Mix pigments with lacquer thoroughly and apply lacquer evenly – finishing thickness affects colour and transparency.
5. Final coating with PUR lacquer.

3. Coloured finishes – stained surfaces

Generally, it is possible to stain products made with 3D surface veneer. The following work procedure has been developed together with Votteler and was tested at Reholz successfully.

1. Sanding: Sand wooden parts made with 3D veneer surfaces with fine sandpaper. Do not blow off the surface with compressed air, use a cloth or hand brush only.
2. Mix stain (e.g. “Hydroplus Beize” by Votteler) thoroughly and add thinner carefully if required. Remark: It is better to increase the spraying pressure rather than thinning the stain.
3. Apply several thin layers of stain crosswise always on a dry surface until desired colour shade is achieved. Use as little water as possible because of the swelling of the veneer layers. Use a small spray nozzle (0.8 – 1.5 mm).
4. Priming: Apply a thin layer of water-based acrylic primer (e.g. Hydropal).
5. Sanding: Sand slightly with fine sandpaper.
6. Finishing: Apply thin layer(s) of lacquer (e.g. Puridur) (see point 1).

Disclaimer:

Reholz assumes no responsibility for the above information. Every customer has to test our products in order to determine if they are suitable for their manufacturing processes. Wood is a natural product and variations of appearance are possible and should be expected.
