



Water Stain No-Wipe Application- Typical Closed-Grain Woods

Substrate Prep

Sand wood to 220 Grit finish on all surfaces. Inside profiles can be sanded to 150-180 Grit. Surfaces must be free of grease, oil and silicones. Moisture content must be between 6%-8%.

Ambient Conditions

Temperatures of coatings and products, substrates and ambient conditions should be between 64-85 degrees Fahrenheit with a relative humidity between 20-70%.

Application Equipment (stains only)

Airless Air Assist Equipment-

Reduction-	None
Tip Size-	.229 mm dia. (.009")
Fluid Pressure-	290 psi
Atomizing Air-	11-17psi

HVLP Pressure Pot-

Reduction-	None
Tip Size-	.229 mm dia. (.009")
Fluid Pressure-	7-10 psi
Atomizing Air-	15-20 psi

HVLP Siphon Feed-

Reduction-	None
Tip Size-	.229 mm dia. (.009")
Atomizing Air-	20 psi

The above mentioned application setups are guidelines only. Please refer to your equipment manufacturer's specifications and do your own experimentation before proceeding.

Watch-out For:

Over-Coating Issues- Flooding any part with too much stain in one pass can tend to result in "blotching" and/or "ticking".

High nozzle pressure- Too much nozzle air can cause bounce-back from the profiles, creating the "halo-effect" around the profiles. Low pressure transfer is imperative.

Technique Forgiveness- Sprayer technique can impact color- typically with this product, too little color may result. Apply enough color but avoid over-coating as described above. See "NOTE" at right.

Species Covered:

Alder	Any other similar
Cherry	closed-grain
Maple	wood
Beech	

Step by Steps

Most colors are achieved with a two-pass method. This method gives the sprayer the opportunity to aim his pattern in various directions at the part being sprayed to ensure that all surfaces and profiles are covered equally, and still avoid applying too much stain.

- 1 First Pass-** The first pass should be applied at a 45 degree angle to the profiles with a 50% overlap and should achieve a 50/50 wet/dry look, meaning that immediately after spraying, the stain will "glisten" or "lightly-pool" on roughly half of the surface area of the part, and soak in quickly on the rest of the part.
- 2 End Grains-** Special attention should be paid to any exposed "end-grain," as these areas will more readily absorb stain than the rest of the door. In general, and, as much as possible, extra passes should be directed at these end grain areas before and/or after each pass in a build-up process in order to keep the stain from excessively "bleeding" into the end grain.
- 3 Second Pass-** The second pass can be applied within 20-30 seconds of the first, but the "pools" that appeared after the first pass should be mostly dried up. The part should be turned 180 degrees and the second pass should be applied at the same 45 degree angle to the profiles with a 50% overlap, working to achieve the same 50/50 wet/dry look.
- 4 Dry Times-** The part should dry until no longer cool to the touch, usually about 30 minutes, before applying clear-coating materials.

NOTE- CabDoor strongly recommends that you create a control sample that is comparable to your actual CDS Door Order, prior to spraying your actual parts. Finish colors can vary to some degree from one order to the next depending on wood color and variations between individual sprayers' techniques.