



2-Step Water Stain Toner Application- Typical hardwoods where deep color is desired

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" on next page.

Species Covered:

Cherry	Any other similar
Maple	hardwood where
Beech	deep color is
Red Oak	required.
Hickory	

Specific Colors Covered:

Brandywine Cherry	Brandywine Hickory
Brandywine Maple	Brandywine Red Oak
Brandywine Beech	Cordovan Maple

Step by Steps

These types of colors are achieved in two color steps, consisting of a two-pass no-wipe toner step and a wiping stain step. This method tones the wood prior to applying a wiping stain, resulting in deep color enhancement of the underlying wood.

This method is especially effective on the harder, closed grain woods such as maple in achieving the dramatic colors desired by today's market.

Note: Start all processes from the back of the part

1 First Pass- The first pass should be applied at a 45 degree angle to the profiles with a 50% overlap. This coat 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.

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2-Step Water Stain Toner Application- Typical hardwoods where deep color is desired (continued)

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 wiping stains.

5 Wiping Stain Application- Starting with the back side of the part, Spray Wiping Stain with conventional siphon gun, or apply with a rag, in liberal amounts to completely cover the part.

6 Wiping- After less than 60 seconds of open time, wipe off all excess stain. Focus on Profiles first and flat surfaces second, with Profile touchup being third. Keep rags and hands clean to avoid prints and smudges. Allow to dry for 1 hour before applying clear coats.

7 Clear-coatings- After allowing wiping stain to dry for 1 hour, apply sealers and top-coats. Scuff sand all profiles and surfaces with 320-400 Grit between coats to take off grain-raise. Clean all surfaces with tack cloth between coats for optimal dust free finish.

IMPORTANT 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.