

## WOOD – TRANSPARENT FINISH TABLETOPS

page 1 of 4

### DESCRIPTION

This system describes how a wooden tabletop may be coated with a transparent two component paint system.

### PRINCIPAL CHARACTERISTICS

This system can be applied directly to wood and is scratch resistant, resistant to various chemicals and has an excellent gloss retention.

### SURFACE CONDITION

Wood, dry, in good condition and free from loose particles and other contamination.

### SURFACE PREPARATION

Untreated wood

1. Sand surface untreated wood thoroughly, especially wood like oregon pine, teak, iroko, etc.;
2. The surface should be dry and free from grease, loose particles and other contamination (moisture content maximum 12%);
3. Clean the surface thoroughly.

Already coated wood

1. Clean the surface thoroughly to remove all contamination such as salt deposits, dirt, grease and other foreign matter;
2. Remove previous layers of one component paints completely using grit paper or paint strippers. When using paint strippers the surface should be rinsed with water, allowed to dry and degreased with Double Coat Ontvetter.
3. Remove previous layers of two component paints with insufficient adhesion using grit paper;
4. The surface should be dry and free from grease, loose particles and other contamination (moisture content maximum 12%);
5. Clean the surface thoroughly.

### MATERIALS AND SPREADING RATES

The following materials are used in this paint system:

Variopox Injectiehars	spreading rate approx. 0,2 l/m <sup>2</sup>
Variopox Impregneerhars	spreading rate approx. 1,0 l/m <sup>2</sup>
Double Coat Dubbel UV	spreading rate approx. 0,45 l/m <sup>2</sup>
Double Coat Kwastverdunner	spreading rate depends on application method
Double Coat Ontvetter	spreading rate depends on condition surface

### APPLICATION

1. Apply one layer Variopox Injectiehars (minimum spreading rate approx. 0,2 l/m<sup>2</sup>, the actual spreading rate depend on the condition of the surface);
  2. Sand surface after 24 hours using grit paper P120;
  3. Apply three to four layers Variopox Impregneerhars (minimum spreading rate approx. 1,0 l/m<sup>2</sup>). Subsequent coat may be applied wet-in-wet or after an interval of 24 hours. In the latter case sand surface with grit paper P120;
  4. Sand surface after 5 days using grit paper P180 and degrease thoroughly with Double Coat Ontvetter;
  5. Apply four to five layers Double Coat Dubbel UV (minimum spreading rate approx. 0,45 l/m<sup>2</sup>).
- Maintenance  
Repair damages areas according to the above system.

## WOOD – TRANSPARENT FINISH TABLETOPS

page 2 of 4

### ADDITIONAL INFORMATION

- **Wood**  
Wood is a natural product which may be damaged by a natural process under the influence of moulds, fungus and moisture. The rate of this process depends on different variables such as the type of wood, the temperature, the moisture content, exposure to sweet or salt water, etc. The wood may be protected against natural decay by applying a suitable and durable paint system. Tropical types of hardwood contain materials which may cause problems such as poor adhesion, blistering, slow curing or discoloration. Only through a careful surface preparation these problems may be avoided.
- **Joinery**  
Tabletops often consist of various parts which are joined using adhesives. As adhesive for these parts or for veneer we recommend the use of two component adhesives based on epoxy resins. Using other types of adhesives may cause surface defects in the coating system.
- **Shrinkage**  
At certain conditions such as exposure to high temperatures epoxy resins have the tendency to exhibit excessive shrinkage. Shrinkage may cause surface defects in the coating systems. Shrinkage may be avoided when the epoxy resins is allowed to fully cure at ambient temperatures. Do not apply recoat Epoxy Impregneerhars too soon with Double Coat Dubbel UV but allow sufficient time between the two products.
- **Sanding**  
A durable adhesion will be obtained by thorough preparation of the surface. This may be achieved by sanding the surface. Sanding is also necessary when the time lapsed between application of each coat exceeds the maximum overcoating interval. During application of the finishing coats, we recommend to use for each coat a finer grit paper. The table gives the recommended grit sizes:

Grit paper:	Recommended for:
P24 – P36	Suitable for steel prior to application of IJmopox ZF primer.
P60	Suitable for polyester gelcoat prior to the use of epoxy adhesives and bonding pastes.
P60 – P80	Suitable for: <ul style="list-style-type: none"> <li>• Removal of old coats of paint,</li> <li>• Sanding aluminium prior to application of IJmopox ZF primer.</li> </ul>
P120	Suitable for: <ul style="list-style-type: none"> <li>• Sanding polyester gelcoat prior to repair with fillers,</li> <li>• Sanding of Variopox Injectiehars, Variopox Impregneerhars en Variopox Universele hars.</li> </ul>
P120 – P180	Suitable for: <ul style="list-style-type: none"> <li>• Wood, after application of first coat of paint,</li> <li>• Epoxy fillers,</li> <li>• Polyester fillers,</li> <li>• Sanding of IJmopox ZF primer and/or IJmopox HB coating between each coat.</li> </ul>
P180 – P220	Suitable for: <ul style="list-style-type: none"> <li>• Sanding of Variopox Injectiehars, Variopox Impregneerhars en Variopox Universele hars,</li> <li>• Sanding of IJmopox ZF primer of IJmopox HB coating prior to application of Double Coat.</li> </ul>
P220 – P280	Suitable for sanding gelcoat prior to application of Double Coat.
P320 – P400	Suitable for sanding Double Coat between each coat.
P600	Suitable for sanding Double Coat prior to application of the final coat Double Coat when dark colours are used such as DC 855, DC 854 en RAL 5011, etc.
Finer then	Suitable to remove dull areas prior to polishing.

## WOOD – TRANSPARENT FINISH TABLETOPS

page 3 of 4

Grit paper:	Recommended for:
P600	

- Example application schedule

step		dry film thickness (µm)	spreading rate (m <sup>2</sup> /l)	recoating interval at 20 °C	preparation before next step
1	Pre-treatment				
2	Apply Variopox Injectiehars	n.a	5	24 hours	Sanding P120.
3	Apply first coat Variopox Impregneerhars	n.a	3,3	24 hours	Sanding P120.
4	Apply second coat Variopox Impregneerhars	n.a	3,3	24 hours	Sanding P120.
5	Apply third coat Variopox Impregneerhars	n.a	3,3	24 hours	Sanding P120.
6	Apply fourth coat Variopox Impregneerhars	n.a	3,3	5 days	Degrease with Double Coat Ontvetter and sanding with P180.
7	Apply first coat Double Coat Dubbel UV	40	10,0	24 uur	When recoated within 48 hours no preparation is required, otherwise sanding with P240 - P400. Use between subsequent coats finer grit paper to avoid scratchmarks.
8	Apply second coat Double Coat Dubbel UV	40	10,0	24 hours	
9	Apply third coat Double Coat Dubbel UV	40	10,0	24 hours	
10	Apply fourth coat Double Coat Dubbel UV	40	10,0	24 hours	
11	Apply last coat Double Coat Dubbel UV	40	10,0		

- Wet-in-wet application Variopox Impregneerhars  
Variopox Impregneerhars may be applied wet-in-wet. When the previous layer of Variopox Impregneerhars is still slightly tacky, a next coat may be applied.
- Reinforcing with Variopox Keperweefsel  
When required, the first coat Variopox Impregneerhars may be reinforced with 160 gr/m<sup>2</sup> Variopox Keperweefsel. Press Variopox Keperweefsel in the fresh applied first coat of Variopox Impregneerhars and remove air using a teflon or aluminium de-aeration roller.
- Durability and surface preparation  
The durability of any paint system depends on a number of variables, amongst others: total dry film thickness, method of application, skill of labour, the conditions during which the coating is

## WOOD – TRANSPARENT FINISH TABLETOPS

page 4 of 4

applied and cured, the exposure conditions during service and the preparation of the surface. Insufficient surface preparation might lead to blistering and loss of adhesion.

- Relation dry/wet film thickness

Volume % Double Coat kwastverdunner	0	2	4	6	8
Wet film thickness Double Coat Dubbel UV at 40 µm dry film thickness	80	82	85	87	90

For detailed information on the products mentioned in this sheet, please refer to our technical information sheets.

Date: November 14

### *Disclaimer*

*Although the information and recommendations are presented in good faith and believed to be correct at date of issue, De IJssel Coatings B.V. makes no representations as of the completeness or accuracy thereof. In no event De IJssel Coatings B.V. will be responsible for damages of any nature whatsoever resulting from the use of this information. De IJssel Coatings B.V. reserves the right to change the information sheet without prior notifications. This information sheet supersedes any previous publications.*