

**WW17**
**3-LAYER PAINT SYSTEM FOR EXTERIOR WOODEN WINDOWS AND DOORS**

<b>Pinja Wood Stain TCW</b>	<b>314 6909</b>
<b>Pinja Flex Primer</b>	<b>006 5000</b>
<b>Pinja Flex 30</b>	<b>787-S</b>

Waterborne system WW17 is pigmented paint system for exterior wooden windows and doors. The total dry film thickness of this system is over 90 µm.

Pinja Wood Stain TCW is waterborne fast drying translucent wood stain which penetrates deeply in to the wood and protects wood against moisture, sunlight and dirt. It also decreases the cracking of the wood. Pinja Wood Stain TCW is tintable in Akvi Tone tinting system.

Pinja Flex Primer is waterborne fast drying alkyd/acrylate primer which has very good adhesion to the different kind of wood types.

Pinja Flex 30 is fast drying flexible acrylate top coat. Viscosity of the Pinja Flex 30 is very high and thixotropic and it's possible to spray more than 300 µm wet film thickness. Pinja Flex 30 is tintable in Avatint tinting systems.

**3-LAYER SYSTEM FOR EXTERIOR WOODEN WINDOWS**

	<b>Product</b>	<b>Application method</b>	<b>Wet film thickness</b>
1x Impregnation	Pinja Wood Stain TCW	dipping, flow coating, spraying	80–120 µm
1x Priming	Pinja Flex Primer	Spraying	125–150 µm
1x Top coat	Pinja Flex 30	Spraying	125–150 µm

**PRODUCT PROPERTIES**

<b>Solid Content</b>	10 volume-%	(314 6909)
	35 volume-%	(006 5000)
	40 volume-%	(787-serie)

<b>Gloss (ISO 2813/60°)</b>	25–35	(787-serie)
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<b>Application methods</b>	Dipping, flow coating, spraying	(314 6909)
	Spraying	(006 5000)
	Spraying	(787-serie)

<b>Thinner</b>	Water or Akvi Thinner.
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<b>Cleaning of equipment</b>	Water.
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<b>Colours</b>	Avatint tinting system.
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**SURFACE PREPARATION**

The wood has to be clean and dry. The relative humidity of wood has to be under 20%.

**APPLICATION CONDITIONS**

During application and drying the temperature of the air, paint and surface should be at least +18°C. The relative humidity should not exceed 70%. Best drying conditions are in 20–40°C temperature, relative humidity 50–70% and also good ventilation is needed.

**APPLICATION**

Stir the Pinja Wood Stain TCW well before application and thin with water if necessary. The proper application viscosity is 11–13 s (DIN4). Pour the Pinja Wood Stain TCW to the vessel and let it normalize 10–20 minutes before painting. Check that the Stain covers all the surfaces. Let the stain dry. In normal conditions when temperature is 20–30°C the drying time is about 1–2 hours.

When the surfaces are dry treat the edge parts of the wood with Pinjalac Edge Cover and V-shaped joints and small cracks with Pinjalac Sealant. This treatment prevents the penetration of the water and water vapour to the open pores of the wood. After the treatment surfaces can be sanded with 240 or 320 paper to reach smoother final result.

Stir the Pinja Flex Primer well before application and thin with water if necessary. Normally the paint is used in delivery viscosity but max. 10% thinning with water is possible. The right nozzle size is 0.011 or 0.013" and angle 20 or 40 and the spraying distance from object about 20–25 cm.

Spray the paint evenly about 125–150 µm wet films and let the paint dry. In normal conditions when the temperature is 20–30°C the drying time is minimum 1–2 hours.

Sand the surfaces carefully with paper size 240 or 320 and remove the sanding dust.

Stir the Pinja Flex 30 well before application. Normally the paint is used in delivery viscosity but max. 10 % thinning with water is possible. The right nozzle size is 0.011 or 0.013" and angle 20 or 40 and the spraying distance from object about 20–25 cm.

Spray the Pinja Flex 30 evenly about 125–150 µm wet film thickness and let the paint dry minimum 2–4 hours before further processing.

Let the pieces dry in vertical position so that the painted surfaces touch as less as possible to each other. Between the pieces can be placed for instance cardboard or foam plastic to prevent the damages. The temperature must be under 35°C during the storage of the pieces.

**MAINTENANCE PAINTING**

Check the paint surfaces every year and repaint scratches or other damages according following instructions.

Wash down the surface with MAALIPESU detergent and rinse carefully with water. Remove old loose paint with scraper. Sand down surface and remove the sanding dust. Stir Pinja Flex 30, Unica Akva, Ultra, Teho or Miranol well before use. Apply evenly 1–2 coats of lacquer. Sand down lightly between each coat.

The above information is not intended to be exhaustive or complete. The information is based on laboratory tests and practical experience, and it is given to the best of our knowledge. The quality of the product is ensured by our operational system, based on the requirements of ISO 9001 and ISO 14001. As manufacturer we cannot control the conditions under which the product is being used or the many factors that have an effect on the use and application of the product. We disclaim liability for any damages caused by using the product against our instructions or for inappropriate purposes. We reserve the right to change the given information unilaterally without notice.

The product is intended for professional use only and shall only be used by professionals who have sufficient knowledge and expertise on the proper use of the product. The information above is advisory only. To the extent permitted by applicable law, we shall not approve of any liability for the conditions under which the product is being used or for the use or application of the product.

In case you intend to use the product for any other purpose than that recommended in this document without first getting our written confirmation on the suitability for the intended use, such use takes place at your own risk.