

**WW45**
**4-LAYER LACQUER SYSTEM FOR EXTERIOR WOODEN WINDOWS**

<b>Pinja Wood Stain</b>	<b>314 6909</b>
<b>Pinjalac Solid Dipp</b>	<b>387 6910</b>
<b>Pinjalac HB</b>	<b>485 6910</b>

Waterborne system WW45 is translucent lacquer system for exterior wooden windows, doors, garden furniture etc. The total dry film thickness of this system is about 150 µm. This system is especially recommended for wood types which has deep wood pores (e.g. oak, meranti).

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.

Pinjalac Solid Dipp is fast drying flexible acrylate lacquer which contains efficient UV-absorber to protect wood from yellowing. Viscosity of the Pinjalac Solid Dipp is about 12–15 s (DIN4) and it's possible to use in dipping and flow coating applications.

Pinjalac HB is fast drying flexible acrylate lacquer which contains efficient UV-absorber to protect wood from yellowing. Viscosity of the Pinjalac HB is very high and thixotropic and it's possible to spray with high pressure spraying system more than 300 µm wet film thickness. Pinjalac HB is tintable in Akvi Tone tinting system.

**4-layer treatment for exterior wooden windows, doors etc.**

<b>Treatment</b>	<b>Product</b>	<b>Application method</b>	<b>Wet film thickness</b>
1x Impregnation	Pinja Wood Stain	Dipping, flow coating	60–80 µm
1x Priming	Pinjalac Solid Dipp	Dipping, flow coating	80–100 µm
1x Lacquering	Pinjalac HB	Spraying	120–150 µm
1x Lacquering	Pinjalac HB	Spraying	120–150 µm

**PRODUCT PROPERTIES**

<b>Solid Content</b>	10 volume %	(314 6909)
	35 volume %	(387 6910)
	37 volume %	(485 6910)
<b>Gloss (ISO 2813/60°)</b>	30–40	(485 6910)
<b>Application methods</b>	Dipping, flow coating, spraying, brushing	(314 6909)
	Dipping, flow coating, spraying, brushing	(387 6910)
	Spraying, brushing	(485 6910)
<b>Thinner</b>	Water	
<b>Cleaning of equipment</b>	Water	
<b>Colours</b>	Akvi Tone tinting system.	

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

Stir Pinjalac HB well before application. The right spray nozzle size is 0.011 or 0.013" and angle 20 or 40 and the spraying distance from object about 20–25 cm.

Spray Pinjalac HB both times about 150µm wet film thickness and let the lacquer dry about 2–4 hours between layers and sand the surfaces well before second application. After second layer let the lacquer dry minimum 2–4 hours before further processing.

Let the pieces dry in vertical position so that the lacquered 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**

Check the lacquer surfaces every year and relacquer scratches or other damages according following instructions.

Wash down the surface with MAALIPESU detergent and rinse carefully with water. Remove old loose lacquer with scraper. Sand down surface and remove the sanding dust. Stir Pinjalac HB, Merit Jahti or Unica Super well before use. Apply evenly 1–2 coats of lacquer. Sand down lightly between each coat.

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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.