Working guideline for coating dimensionally stable and limited dimensionally stable construction elements
Windows –Front doors and Shutters – Garage doors
Coating system - Classic

Classic coating systems are used when value is set on a high speed drying and a high block-resistance, especially for industrial use, preserving the good price-performance ratio.

A general description of the suited coating system is given below. With these coating sistems are connected guarantee declarations. You will find the details in our brochure „Classic – Guarantee for coating systems on windows and casement doors“.

A description of the coating system in dependence of the wood specie can be found in chapter 2 of the present working guideline.

The usable colour shades in dependence of the wood species are listed in the General Part of the Working guideline for coating dimensionally stable and limited dimensionally stable construction elements” in chapter 2 – Suited wood species.

Brief description of the coating systems

1.1. Transparent coating system for windows, shutters and doors

	Application method	Wet film thickness
Coating system AC: With complete weathersealing		
1 x Aquawood TIG HighRes 5432 ff	Dipping or flow-coating	
1 x Aquawood Intermedio 53663 (windows) or Aquawood Intermedio HF 53769 (shutters)	Dipping or flow-coating	
Intermediate sanding		
1 x Aquawood Fensterlasur 53810 ff or 1 x Aquawood Fensterlasur HF 53845 ff	spraying	250 – 275 µm
Coating system BC: High bodied and good insulation effect		
1 x Aquawood TIG HighRes 5432 ff	Dipping or flow-coating	
1 x Aquawood Intermedio ISO 53613 ff	Spraying	100 – 125 µm
Intermediate sanding		
1 x Aquawood Fensterlasur 53810 ff or 1 x Aquawood Fensterlasur HF 53845 ff	Spraying	225 – 250 µm
Coating system CC: Iroko (at the moment the same like Coating system B; before with special products)		
1 x Aquawood TIG HighRes 5432 ff	Dipping or Flow-coating	
1 x Aquawood Intermedio ISO 53613 ff	Spraying	100 µm
Intermediate sanding		
1 x Aquawood Fensterlasur 53810 ff or 1 x Aquawood Fensterlasur HF 53845 ff	Spraying	225 – 250 µm

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1.2. Opaque coating systems for windows, shutters and doors

	Application	Wet film thickness
Coating system DC: With complete weathersealing – **Dark colour shades**		
1 x Aquawood TIG HighRes 5432 ff	Dipping or Flow-coating	
1 x Aquawood Intermedio 53663 or Aquawood Intermedio HF 53769	Dipping or Flow-coating	
Intermediate sanding		
1 x ADLER Acryl-Fensterlack M 43670 ff	Spraying	250 - 300 µm
Coating system EC: With complete weathersealing – **Bright colour shades**		
1 x Aquawood TIG HighRes Weiß 543700101	Dipping or Flow-coating	
1 x Aquawood Intermedio 53663 or Aquawood Intermedio HF 53769	Dipping or Flow-coating	
Intermediate sanding		
1 x ADLER Acryl-Fensterlack M 43670 ff	Spraying	250 – 300 µm
Coating system FC: High bodied with high insulation effect		
1 x Aquawood TIG HighRes Weiß 543700101	Dipping or Flow-coating	
1 x Acryl-Spritzfüller SL 41029 or 41002	Spraying	150 – 200 µm
Intermediate sanding		
1 x ADLER Acryl-Fensterlack M 43670 ff	Spraying	150 – 200 µm
Coating system HC: Okoume multilayer boards		
1 x Aquawood TIG HighRes Weiß 543700101	Dipping or Flow-coating	
Intermediate sanding		
1 x Acryl-Spritzfüller SL 41029	Spraying	150 - 200 µm
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If necessary, slight intermediate sanding		
1 x Acryl- Fensterlack M 43670 ff	Spraying	250 µm
Coating system IC: Mixed coating system with maximum insulation		
1 x 2K-Fenstergrundlack 69511	Spraying	200 µm
Intermediate sanding		
1 x 2K-Fenstergrundlack 69511	Spraying	100 µm
1 x Acryl-Fensterlack M 43670 ff	Spraying	150 – 200 µm

Important advice: For front doors we recommend to apply the top-coat Aquawood Protect 53215 in a two component version (better mechanical / chemical resistance) or to use generally the Protor coating system for front doors.

Please follow the corresponding technical data sheet of each product..

2. Application on different species of wood

2.1. The recommended Classic coating systems for coniferous wood:

Coniferous wood		**Transparent coating systems**			**Opaque coating systems DARK colour shades**			**Opaque coating systems BRIGHT colour shades**		
		Windows	Shutters	Doors	Windows	Shutters	Doors	Windows	Shutters	Doors
Fir tree		AC	AC	BC	FC	DC	FC	FC	EC	FC
Bruce		AC	AC	BC	FC	DC	FC	FC	EC	FC
Yellow Pine		AC	AC	BC	FC	DC	FC	FC	EC	FC
Red Cedar		AC	AC	BC	FC	DC	FC	FC	FC	FC
Hemlock		AC	AC	BC	FC	DC	FC	FC	FC	FC
Pine		AC	AC	BC	FC	DC	FC	FC	FC	FC
Douglas		AC	AC	BC	FC	DC	FC	No recommenda-tion	No recommenda-tion	No recommenda-tion
Larch		BC	AC	BC	FC	DC	FC	No recommenda-tion	No recommenda-tion	No recommenda-tion
Russian Larch		BC	AC	BC	FC	DC	FC	No recommenda-tion	No recommenda-tion	No recommenda-tion

2.2. The recommended Classic coating systems for deciduous wood:

Deciduous wood		**Transparent coating systems**			**Opaque coating systems DARK colour shades**			**Opaque coating systems BRIGHT colour shades**		
		Windows	**Shutters**	**Doors**	**Windows**	**Shutters**	**Doors**	**Windows**	**Shutters**	**Doors**
Kastanie		BC	AC	BC	FC	DC	FC	FC	No recommendation	FC
Eiche		BC	AC	BC	FC	DC	FC	FC	No recommendation	FC
Esche		BC	No recommendation	BC	FC	No recommendation	FC	FC	No recommendation	FC
Framiré		BC	AC	BC	FC	DC	FC	FC	No recommendation	FC
Meranti / Eukalyptus		BC	AC	BC	FC	DC	FC	FC	EC	FC
Mahagoni		BC	AC	BC	FC	DC	FC	IC	IC	IC
Niangon		BC	AC	BC	FC	DC	FC	IC	IC	IC
Acajú		BC	AC	BC	FC	DC	FC	IC	IC	IC
Teak		BC	AC	BC	FC	DC	FC	IC	IC	IC
Okoumé massiv		BC	AC	BC	FC	DC	FC	FC	EC	FC
Okoumé Mehrschicht		No recommendation	AC	BC	No recommendation	DC	FC	No recommendation	HC*	HC*
Iroko		**CC***	**CC***	**CC***	IC	IC	IC	IC	No recommendation	IC
MDF		No recommenda-tion	No recommenda-tion	No recommenda-tion	No recommenda-tion	No recommenda-tion	IC	No recommenda-tion	No recommenda-tion	IC

CC*: Possibility of a mixed coating s systems: TIG HighRes – 2x 2K-Fenstergrund (150-200/100 µm), sanding after the first application – Aquawood Fensterlasur (250 µm)
HC*:Possibility of a mixed coating system: 2x 2K-Fenstergrund (200/200 µm), sanding after the first application – ADLER Acryl-Fensterlack (250 µm)

3. Exceptions, not covered by the Classic-Guarantee

In some extreme cases the stress is so strong, that it is not possible to give a guarantee for the durability.

Elements, continuously and extremely exposed to water

These cases happen rarely, but an eye must be kept generally on it. If the coated wooden elements are located next to a irrigation system, the surface rest in contact with water for a long time. During the phase of drying water evaporates, leaving a trace of chalk on the surface. These spots can only be removed by abrasive cleansing products. If such cleansing products are often used, the surfaces may be damaged highly.

Elements, installed in indoor swimming pools

The perennial and high strain during a maximum concentration of air humidity and the subsequent formation of condense water can be so extreme that a premature damage is caused on the elements. On demand we can recommend special coating systems.

Elements next to the beach, in a distance smaller than 50 m

In a distance of less than 50 m from the beach elements can be exposed to extreme stress, caused by the sand carried on by the wind. Sand is a great abrasive strain on the surface, and a reduction of the coating film can follow-up. In this case the coating film cannot sufficiently protect the wood. Compared to sand the damage caused by salt are very restricted.

Elements, installed in an altidude of more than 1600 m /over the sea

It is known that weathering conditions in alpine zones, especially because of the high intensity of UV radiation, are extremely challenging. Furthermore, because of very great fluctuation in temperature, the wood substrate, as well as the coating film, are exposed to heavier strain.