Finishing Instructions

NUXE® PREMIUM WALNUT COLLECTION

1 WHY FINISH NUXE

Walnut is a natural wood specie that ranges in colour from light brown to dark chocolate brown, often with a purplish or reddish cast. Over time, as the wood ages when exposed to sunlight, the veneer will change to a more gold-orange tone if left untreated. We therefore recommend finishing the wood with an oil or varnish combined with staining to reduce the UV impact on the colour.

2 FINISHING OPTIONS

Veneered panels can be finished in a variety of ways, with oils and varnishes being the most common.

- Oil finishing allows the wood to retain its natural appearance. Furthermore, as the oil will be absorbed and fill up the pores, it will prevent water and other liquids to penetrate the wood. The downside of oil finishing is that it requires more maintenance as the wood must be regularly fed with the right products.
- A varnish will seal the wood properly, resulting in a higher resistance to grease marks, making it a more reliable choice for dining tables and worktops. The downside of varnishing is that the natural appearance is more muted as you add a layer on top of the wood. However, matt varnishes can have a very subtle effect.

Furthermore, several options are possible in order to reduce the sunlight impact on the wood.

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- Please ask your supplier for a finishing product including UV blockers. These products provide an additional help in protecting the wood and will lower the overall colour shift upon aging/exposure to sunlight.
- The walnut veneer can also be stained prior to varnishing or oiling in order to achieve a specific color. Especially, using a darker stain will mask the wood colour shift, thanks to the pigmentation in the stain.
- Adding white pigmentation in the treatment of your wood, will help reflect UV light and give the wood additional protection.

3 FINISHING INSTRUCTIONS

1. Inspect the veneer ahead of starting the process.
2. Sand the veneer in the direction of the wood grain to avoid scratches. Remove the wood dust ahead of further steps.
   Decospan offers boards that are pre-sanded to make sure the surface is clean. However, in order to achieve the optimal result, the boards need to be sanded again with a fine grit to avoid potential glue residue that might become visible when staining/finishing.
3. Apply the varnish or oil coats according to the manufacturer's instructions
4. Final touches
   - Allow the final coat to cure completely in a dust-free environment. This could take several days to a week, depending on the varnish type.

4 FINISHING RECOMMENDATIONS

After extensive testing, we determined that best results can be obtained when using the following finishing products for use on veneer to help protect against the effects f exposure to Ultra Violet light:

- Sherwin Williams – ICA (solvent-based finish for spray gun)
- Sherwin Williams – OECO (water-based 2K system for spray gun)
- Hesse (PUR solvent-based finish for spray gun)

Always verify the safety data sheets and the most recent application instructions on the supplier website.

4.1 SHERWIN WILLIAMS - ICA

Solvent-based finish for spray gun

Products applied:

- IS210UVE > insulating primer
- C200 > Hardener
- D1015 > Transparent thinner
- FAC300UVE > primer
- OAC301G5UVE > Topcoat

Procedure

Process	Procedure / Mixture	Lacquer properties	Application and application quantity g/m²
1. Wood sanding	P150 crosswise, P150 lengthwise, P220 lengthwise		
2. Insulating	IS210UVE insulating primer + 10w% C200 hardener + 10w% D1015 thinner	Transparent Lightfast	Pistol:1,8 nozzle 80 – 100 g/m²
3. Drying	Overnight drying at room temperature		
4. Sanding	P320		
5. Primer	FAC300UVE primer + 20% C200 Hardener + 10% D1015 Thinner	Transparent Lightfast	Pistol:1,8 nozzle 80 – 100 g/m²
6. Drying	Overnight drying at room temperature		
7. Sanding	P 400		
8. Topcoat	OAC301G5UVE Topcoat + 10% C200 Hardener + 20% D1015 Thinner	Transparent Lightfast Gloss ca. 3-5 (60°)	Pistol:1,8 nozzle 100 – 200 g/m²
9. Drying	Overnight drying at room temperature		

Notes: Depending on the wanted UV protection: step 5-7 can be repeated upto a total of 3 layers. Please note that the wood structure will be reduced due to the total varnish application weight.
Ensure a good mixing of all components immediately before starting productions
The references on the Decospan website were tested with the basic 3 layer build-up – where only 1 cycle of step 5 & 6 was done.

4.2 SHERWIN WILLIAMS - OECO

OECO (water-based 2K system for spray gun)

Products applied:

- 86V-24 > primer
- IDRO-CEOPAL 41B-0026 > basecoat / Topcoat
- 86A-23 > UV absorber
- 813-54VA > hardener
- Water > thinner

Procedure

Prepare basecoat/topcoat mixture :

IDRO-CEOPAL 41B-0026 : 86A-23 : 813-54VA : water

100 : 3 : 10 : 5 to 10

Process	Procedure / Mixture	Lacquer properties	Application and application quantity g/m²
1. Wood sanding	P150 crosswise, P150 lengthwise, P220 lengthwise		
2. Primer	86A-23	Transparent	Spray gun Maximum 60 – 80 g/m²
3. Drying	Min. 6 hours at room temperature		
4. Sanding	P320		
5. Basecoat	Mixture	Transparent Lightfast	Spray gun Maximum 100 - 120 g/m²
6. Drying	Min. 12 hours at room temperature		
7. Sanding	P 320		
8. Topcoat	Mixture	Transparent Lightfast (gloss 3-5)	Spray gun Maximum 100 – 120 g/m²
8. Drying	Overnight drying at room temperature		

4.3 HESSE- PUR SOLVENT

OECO (water-based 2K system for spray gun)

Products applied:

- PUR Sun-Blocker DE 4295x (x is the wanted gloss level) > base coat / topcoat
- (DE 42950 = low gloss, DE 42952 = gloss 10 and DE 42954 = glos 20 ; under 60°)
- DR4070 > hardener

Procedure

Mixture (volumetric) :
PUR sun:blocker : Hardener
10 : 1

Process	Procedure / Mixture	Lacquer properties	Application and application quantity g/m²
1. Wood sanding	P150 crosswise, P150 lengthwise, P180 lengthwise		
2. Primer	Mixture	Transparent Lightfast	Spray gun 100 – 150 g/m²
3. Drying	Min. 3 hours at room temperature		
4. Sanding	P320		
5. Basecoat	Mixture	Transparent Lightfast	Spray gun 100 - 150 g/m²
6. Drying	Min. 3 hours at room temperature		
7. Sanding	P 320		
8. Topcoat	Mixture	Transparent Lightfast (gloss depending on selected product variant)	Spray gun 100 – 150 g/m²
8. Drying	Overnight drying at room temperature Fully hardened after 7 days at room temperature		

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TIPS

1. **Temperature and Humidity:** Ensure you're working in a well-ventilated area with moderate humidity and temperature, as extreme conditions can affect drying times and finish quality.
2. **Avoid Overworking:** Don't go back over areas that are starting to dry, as this can cause streaks or unevenness.
3. **Varnish Type:** Oil-based varnishes typically provide a richer colour and are more durable, but take longer to dry. Water-based varnishes dry faster and are less odour-intensive but may raise the wood grain slightly.

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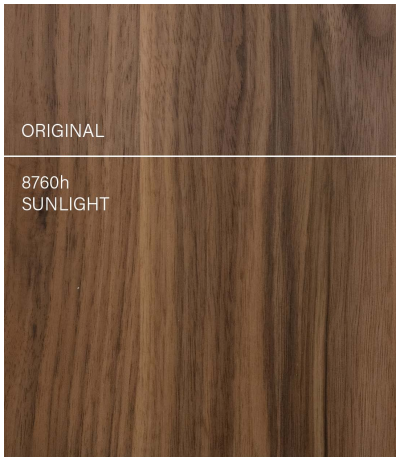
5. Test results

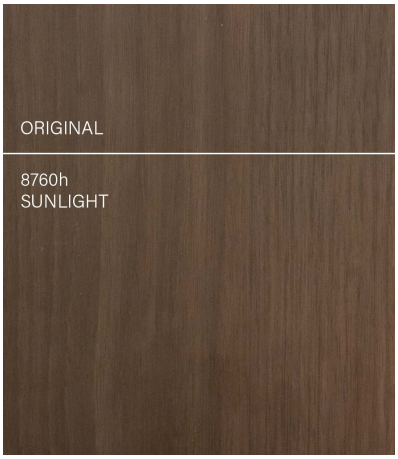
5.1 SHERWIN WILLIAMS - ICA

Naturals

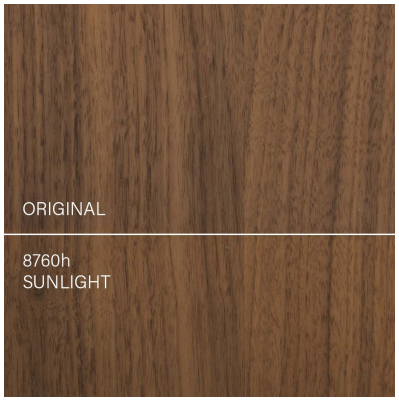


Noble

Spectrum

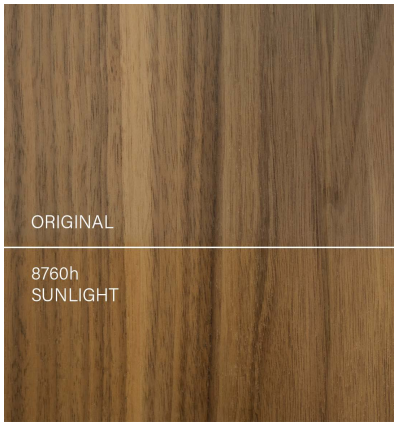


5.2 SHERWIN WILLIAMS - OECO

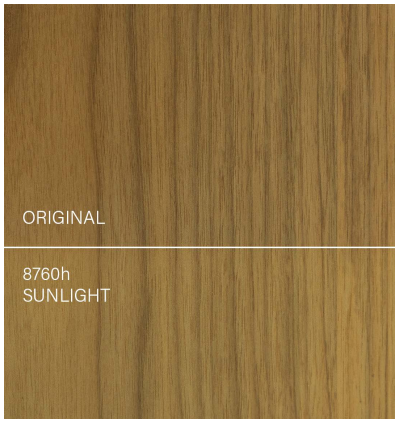


5.3 HESSE- PUR SOLVENT

Naturals



Noble



Spectrum