

Aspiro Stile and Rail-Factory Finish Information

FACTORY FINISHING

Aspiro Stile and Rail doors offer the highest quality factory finishing available to the market. Due to the nature of Stile and Rail doors, our products are finished in the horizontal position, allowing for a high solid, uniform layer of one of the most durable products available.

Our catalyzed conversion varnish has performance characteristics that are equal to A.W.S.-System 5. Its non-yellowing formula was specifically designed for wood surfaces. Applied as a clear coat or as a top coat over our pigmented solid colors, or applied on our hand wiped stains the finish will enhance the natural beauty of the wood grain. In either case, it will hold its clarity over the years, and will not yellow like conventional finishing products. Our wiping stains are specially formulated to create a natural stain effect that enhances the wood's unique characteristics by allowing the grain to show through. This leaves a much more desirable appearance than a dye stain, which can hide the natural beauty of the wood, (the grain). Each door is meticulously wiped and checked for the matching of the color requested. Although we have a number of standard colors available, we are also more than capable of matching any color that you may desire. We request that a minimum 6x6 sample be sent for matching.

When interior primed doors are requested, our lacquer based primer is an excellent product for filling the pores of the wood, or wood product, creating a smooth uniform surface (after sanding), that is comparable to none. It exhibits excellent adhesion to wood and its bi-products and is a high-quality base coat with outstanding holdout of most commonly used top coats.

For doors that are going to be exposed to the exterior, our finishing system is a NB Acrylic Clear. It leaves excellent clear visibility of the grain pattern, thus highlighting the natural beauty of the wood. The ultraviolet absorbers that are incorporated into the product protect the wood from harmful ultraviolet rays. This flexible coating also penetrates into the wood allowing for expansion and contraction of the wood fibers while allowing moisture to escape, and therefore preventing fungal growth that in turn creates cracking, blistering and peeling.

PRIME/PAINT PROCEDURES

The following paragraphs are the procedures taken when we are applying the various finishes available in Forte™ Opening Solutions's Aspiro Stile and Rail Doors.

PRIMER

1. Doors are sanded with 150 grit paper through the wide belt sander.
2. All sharp edges are broken with the wide brush sander.
3. A lacquer based primer is applied by state of the art spray equipment.
4. Doors are passed through the wide brush sander for a smooth uniform finish.
5. Doors are crated or palletized depending on method of delivery.

PLEASE NOTE: All doors must be field sanded prior to refinishing in order to remove any handling marks.

OPAQUE FINISHES

1. Doors are sanded with 180 grit paper through the wide belt sander.
2. All sharp edges are broken with the wide brush sander.
3. A lacquer based primer is applied by state of the art spray equipment.
4. Doors are sanded with orbital sanders using 400 grit sand paper.
5. Doors are sprayed with a high solids, catalyzed pigmented formula.
6. Step 5 is repeated. (If necessary)
7. Individual doors are bagged and packed with foam layers and are crated or palletized depending on method of delivery.

TRANSPARENT FINISH PROCEDURES

1. Doors are sanded with a 120 to 180 grit paper, (depending on specie) to remove all cross grain scratches and break all sharp edges.
2. A generous coat of stain is applied and then removed with a soft cotton cloth.

NOTE: Step 3 is not necessary for a clear finish.

3. Doors are checked for uniformity of color, (if stained) and two thick coats of vinyl sealer is applied to all 6 sides including hardware cutouts.
4. Doors are sanded with a 400 grit paper and verified for smoothness.
5. Doors receive a coat of catalyzed conversion varnish.
6. Every door is individually inspected, bagged and packed with foam, crated or palletized depending on the method of delivery.

NOTE: If a filled finish is required, a leveling sealer is applied after step 1, additional coats may be required depending on the species.

EXTERIOR FINISHES

This durable exterior product requires more drying and cure time, therefore, creating a slightly longer lead time.

1. Doors are sanded with a 120 to 180 grit paper, (depending on specie) to remove all cross grain scratches and break all edges.
2. Spray stain is applied in multiple coats until desired color is achieved.
3. Doors are checked for uniformity of color, (if stained) and two thick coats of water-based satin varnish is applied to all 6 sides including hardware cutouts.
4. Doors are sanded with 320/400 grit paper and verified for smoothness.
5. Doors receive another coat of water-based satin varnish.
6. Every door is individually inspected, bagged and packed with foam, crated or palletized depending on the delivery method.