

## Factory Finishing

Harring Doors offers 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.I. TR-6. Its non-yellowing, water white formula, was specifically designed for wood surfaces where extreme moisture and chemical exposure is a concern. It can be pigmented to be used as a solid color, or applied on our hand wiped stains to help 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 woods 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 by 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, we use a durable exterior finish. It leaves excellent clear visibility of the grain pattern, thus highlighting the natural beauty of the wood. The ultraviolet absorbers that are incorporated into our products resin, 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.

## Finishing Procedures

The following paragraphs are the procedures taken when we are applying the various finishes available from Harring Doors.

Primer:

- Doors are sanded with 120 grit paper through the wide belt sander.
- All sharp edges are broken with the wide brush sander.
- Primer is applied by state of the art spray equipment.
- Doors are passed through the wide brush sander for a smooth uniform finish.
- 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 Finishing:

- Doors are sanded with 120 grit paper through the wide belt sander.
- All sharp edges are broken with the wide brush sander.
- Primer is applied by state of the art spray equipment.
- Doors are passed through the wide brush sander, prepared to receive opaque pigments.
- Doors are sprayed with a high solids, catalyzed pigmented formula.
- Step 5 is repeated. (if necessary)
- Doors are packed with foam and crated or palletized depending on method of delivery.

## Transparent Finishes:

- Doors are sanded with 180 to a 220 grit paper, (depending on species) to remove all cross grain scratches and break all sharp edges.
- A high solid vinyl wash coat is applied to ensure uniform stain penetration and color.

## **Factory Finishing** (continued)

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

**Note: If a filled finish is required, a filler is applied after step 2, creating a smooth surface.**

### **Exterior Finishes:**

Our exterior finish would be the same process as we use for our interior transparent finishes. The difference would be in the finish product itself. The durable exterior product that we use requires more drying and cure time, therefore, creating a slightly longer lead time.

### **Field Finishing:**

All field finished doors must be handled with clean gloves and lightly sanded with the grain prior to finishing. All 6 sides, including hardware cutouts, must be sealed with a wash coat prior to staining. We strongly urge not to use a water based stain when field finishing. An additional sealer must be applied to all 6 sides, including hardware cutouts, after any staining of the doors, this sealer must be sanded prior to top coating. In any event, Harring Doors cannot be responsible for field finishing.

Please refer to "**How to store, handle, finish, install and maintain wood doors**".

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