

**WW105**
**WATER-BORNE POLYACRYLATE PAINT SYSTEM FOR EXTERIOR WINDOWS AND DOORS**
**PINJA WOOD STAIN  
PINJA FLEX COMBI 25  
PINJA FLEX COMBI 35**

The water-borne system WW105 is priming stain and top paint system for exterior windows and doors.

Pinja Wood Stain is waterborne fast drying translucent wood stain which penetrates deeply into the wood and protects wood against moisture, sunlight and dirt. It also decreases the cracking of the wood. Pinja Wood Stain is tintable in Avatint or Akvi Tone tinting systems.

Pinja Flex Combi is a fast drying water-borne polyacrylate top paint for exterior windows and doors. Pinja Flex Combi is tintable in Avatint -tinting system. Recommended total dry film thickness of this system is minimum 90 µm.

**TYPICAL PAINT SYSTEM**

Treatment	Product	Application method	Wet film thickness
Priming	1x Pinja Wood Stain	Spraying, dipping, flow coating	80-120 µm
Top coat	2x Pinja Flex Combi 25, 35	Spraying	125-150 µm

**PRODUCT PROPERTIES**

<b>Solid Content</b>	10 vol-%	Pinja Wood Stain
	38 vol-%	Pinja Flex Combi 25
<b>Specific gravity</b>	1.0 kg/l	Pinja Wood Stain
	1,2 kg/l	Pinja Flex Combi 25

**Drying times**

Product	Wet film 100–120 g/m <sup>2</sup>	+23°C	+50°C
Pinja Wood Stain	Dry to repaint	1-2 h	5 -20 min
Pinja Flex Combi	Dry to repaint	1-2 h	30-60 min

Stacking temperature below +30°C.

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

<b>Gloss</b>	Semi-matt	Pinja Flex Combi 25
	Semi-gloss	Pinja Flex Combi 35
<b>Application methods</b>	Airless and air assisted airless spraying.	
<b>Thinner</b>	Water.	
<b>Cleaning of equipment</b>	Water.	
<b>Colours</b>	Avatint -tinting system.	

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<b>SURFACE PREPARATION</b>	Dirt, dust and other unfamiliar material must be removed from the surface. Wooden material should be sanded before application with paper grain size 150 – 240. All sanding dust must be removed before application.
<b>APPLICATION CONDITIONS</b>	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%. Good ventilation is needed during drying process.
<b>APPLICATION</b>	<p>Stir the Pinja Wood Stain well before application. The proper application viscosity is 10 - 13 s (DIN4). Apply Pinja Wood Stain and check that it covers all the surfaces. Let the product dry. In normal conditions when temperature is 20 - 30 °C the minimum drying time is about 1-2 hours.</p> <p>Stir the Pinja Flex Combi well before application and thin with water if necessary. Normally the paint is used in delivery viscosity but max. 10 % thinning with water is possible.</p> <p>Spray the paint evenly about 125-150 µm wet films and let the paint dry. In normal conditions when the temperature is 20 - 30°C the drying time is minimum 1-2 hours.</p> <p>Sand the surfaces carefully with paper size 240 or 320 and remove the sanding dust.</p> <p>Apply second layer same way as first layer and let the paint dry minimum 2-4 hours before further processing.</p> <p>Let the pieces dry in vertical position so that the painted 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 30°C during the storage of the pieces.</p> <p>The drying time depends of film thickness, temperature, relative humidity and the air ventilation.</p> <p>Application with airless, air assisted-airless spray. Nozzle size 0.011–0.015” is recommended. Spraying distance from the object is about 20–25 cm.</p>
<b>WARRANTY OF QUALITY</b>	<p>Tikkurila Oyj has designed this application technology and painting system to have a maintenance interval of minimum 7 years if conditions of wooden construction materials are checked annually and possible damages fixed according to the maintenance instructions.</p> <p>These products are tested in Tikkurila R&amp;D laboratory and exterior test field. Long experience of the exterior use has shown that these products are suitable for painting of exterior wooden construction materials. Maintenance interval is a rough estimate, as it depends on the structural features, weather conditions, the geographic location and orientation of the objects.</p>
<b>MAINTENANCE PAINTING</b>	Wash down the surface with MAALIPESU detergent and rinse carefully with water. Remove old loose paint with scraper. Sand down surface and remove the sanding dust. Suitable maintenance product for exterior application is Unica Akva. Stir the paint carefully before use. Apply evenly 1–2 coats of paint. Sand down lightly between each coat.

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.