

# Expected outcome of industrial surface treatment of timber elements

**Companies certified in accordance with VinduesIndustriens's Technical Requirements must complete a surface treatment of timber elements which meets or exceeds the following performance requirements:**

(Based on Danish terminology used in the publication Malerfagligt Behandlings-Katalog, Danish Technological Institute)

All surfaces have been treated but uniform layer thickness cannot be expected everywhere.

	Expected result	Function Class*	Comments
Visible faces of closed element	DLGU**	III	Mean value of layer thickness > 60 µm (80 µm)
Visible faces of open element	DG***	III	The surface must be non-absorbing
Hidden faces (against wall)			No requirement

## References:

\* **Function Class III** *Examples:*  
**South and west facing building parts with changing moisture conditions or traffic pollution or other aggressive influence. See also supplementary description of results.**

**Opaque, sealed, smooth and filled surface (DLGU)**

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**Faces, edges and rebates have a uniform colour and sheen and feel smooth.**

**Pores have been sealed. Holes, fissures and joints have been sealed and filled. Unevenness arising from the base may occur. Hardwood is exempt from the requirement of surfaces being filled.**

**Opaque and smooth surface (DG)**

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**Faces, edges and rebates have a uniform colour and sheen and feel smooth.**

**Unevenness, open pores, holes, fissures and joints arising from the base may occur.**

## Supplementary description of outcome

It must generally be accepted that timber is a natural material which is often very inhomogeneous. Therefore, there will be variations in structure and sheen, star shakes and other normal timber variations, e.g. irregularities around knots, where partial flaking, blistering and wrinkling may occur. Particularly in the case of light colours there may be colour penetration from knots. Knots may have been plugged or filled with a suitable material but will remain visible. Similar colour variations may occur in the form of profiles/areas with yellow discolouration.

Another irregularity in the surface treatment may appear as resin buds. The buds may be distributed randomly across the surface or follow the pattern of the grain.

Resin may also penetrate the paint film and form droplets on the surface. When the buds have been on the surface for long enough to have crystallized, they may be removed by brushing or light scraping without deterioration in the surface treatment.

Timber units with high resin content do occur. In such circumstances, resin may cause extensive bleeding.

Manufacturing is at an industrial level with all the advantages this means in terms of uniform high quality and treatment of all faces.

If nothing to the contrary has been agreed, it must be assumed that glazing beads have been fitted using nail guns with ensuing penetration of the surface treatment.

The surface treatment of timber bottom glazing beads may not be expected to be as durable as that of other surfaces.

On south-facing facades with particularly strong sunlight and sea air or where there is substantial moisture impact from the room, maintenance intervals should be adapted to the circumstances.

For maintenance in general please consult "Malerfagligt Behandlings-Katalog" (MBK) or the paint manufacturers.