

CUTEK® OEM FINISHING STANDARD SOP

Coating Chemco SaferWood® Ignition-Resistant Wood



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Prepared By: _____

Approved By: _____

Purpose

This Standard Operating Procedure establishes the recommended preparation and coating process for Chemco SaferWood® ignition-resistant lumber using CUTEK® Wood Oils and Colortones through approved flood coating systems with integrated brushing and recovery.

This procedure supersedes the standard CUTEK® OEM surface preparation requirements when coating Chemco SaferWood® products. All other standard CUTEK® OEM coating procedures remain applicable unless otherwise specified within this document.

1. SURFACE PREPARATION

Unlike conventional wood products, Chemco SaferWood® has an ignition-resistant treatment impregnated into the surface fibers. Excessive sanding or machining can remove treated material and reduce the effectiveness of the ignition-resistant treatment.

For this reason:

- Heavy sanding is not permitted.
- Material removal shall be kept to an absolute minimum.
- Surface preparation is intended only to lightly scarify the surface and remove residual treatment deposits.

Acceptable Surface Preparation

- Flap wheel sanding only.
- 80 grit abrasive.
- Light pressure.
- Remove little to no wood fiber.
- Do not flatten or reshape the surface.

The objective is to lightly scarify the surface, remove residual treatment deposits, and provide improved mechanical adhesion for the Colortone while preserving the integrity of the Chemco SaferWood® treatment.

2. REMOVAL OF SURFACE RESIDUE

Following the Chemco SaferWood® treatment process, a light residual material may remain on the wood surface.

This residue may be removed by:

- Wiping and brushing the surface.
- Light flap-wheel sanding as described in Section 1.

The objective is to produce a clean, uniform substrate prior to coating.

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3A. MACHINE APPLICATION

Apply CUTEK® Wood Oil using the standard OEM flood-coating process.

Recommended process:

- Apply the thinnest uniform flood coat possible.
- Coat all exposed faces and edges.
- Ensure complete surface wetting without excessive film build.
- Utilize the machine's integrated brushing system to evenly distribute the coating while removing excess material.

CUTEK® is a penetrating oil system. Surface film formation is not desired.

3B. HAND APPLICATION

Where machine application is not available, CUTEK® may be applied using standard hand application procedures.

Acceptable application methods include:

- Synthetic lamb's wool applicator.
- High-quality brush.
- Roller followed by back brushing.

Follow the standard CUTEK® hand application procedures, ensuring complete surface wetting while avoiding excess material remaining on the surface.

The only modification to the standard application procedure is the surface preparation requirements outlined within this SOP.

4. SURFACE BLOOM

During coating, operators may observe a temporary white or cloudy appearance developing on the surface of the wood.

For the purposes of this procedure, this condition is referred to as Surface Bloom.

Surface Bloom is:

- An expected process characteristic.
- Temporary in nature.
- Not a chemical incompatibility between CUTEK® and Chemco SaferWood®.
- Not an indication of coating failure.
- Not detrimental to the long-term appearance or performance of the finished product.

Surface Bloom is the temporary appearance of residual treatment material becoming visible during the oil application process.

Surface Bloom should be removed during final quality control prior to down-stacking and packaging for shipment.

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5. QUALITY CONTROL

Following coating, material should be racked to allow the coating to penetrate and level.

Prior to down-stacking:

- Inspect each board for overall uniform appearance.
- Remove any remaining Surface Bloom using a clean cloth where required.
- Verify consistent colour and coating distribution.
- Confirm there are no heavy deposits, runs, puddling or pooling.
- Ensure boards meet the expected visual standard prior to packaging.

Final inspection shall verify that the finished product presents a clean, uniform appearance suitable for shipment.

6. IMPORTANT NOTES

- Do not aggressively sand Chemco SaferWood® products.
- Preserve the treated surface whenever possible.
- Surface preparation shall be limited to cleaning and light scarification.
- Surface Bloom is a normal process characteristic and is not considered a coating defect.
- Proper surface preparation and final quality control will ensure a consistent finished appearance.

REVISION HISTORY

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Date

Description of Change

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Approved By

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Initial release for internal review