



AVAILABLE SYSTEM SPECIFICATIONS OPAQUE FINISH EXTERIOR JOINERY

Sapele, meranti, red grandis, redwood, pine heartwood, accoya, tricoya, plywood: 2 x spraying

1 st coat			2 nd coat		
Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Isoprimer	200 µm	90 µm	Hydrolux Topcoat thix	180 µm	70 µm



Meranti, red grandis, redwood, pine heartwood, accoya, tricoya, plywood: 2 x spraying

1 st coat			2 nd coat		
Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Filling primer or Hydrolux Basecoat	200 µm	80 µm	Hydrolux Topcoat thix	200 µm	80 µm



Meranti, red grandis, redwood, pine heartwood, accoya, tricoya, plywood: 2 x spraying

1 st coat			2 nd coat		
Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Topcoat thix	200 µm	80 µm	Hydrolux Topcoat thix	200 µm	80 µm



Idigbo, iroko, utile, sapele, meranti, red grandis, pine heartwood, accoya, tricoya, plywood: 3 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Isoprimer	135 µm	60 µm	Hydrolux Iso-primer	135 µm	60 µm	Hydrolux Topcoat thix	120 µm	45 µm



Sapele, meranti, red grandis, redwood, pine heartwood, accoya, tricoya, plywood: 3 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Isoprimer	135 µm	60 µm	Hydrolux Filling primer or Hydrolux Basecoat	160 µm	60 µm	Hydrolux Topcoat thix	120 µm	45 µm



Sapele, meranti, red grandis, redwood, pine heartwood, accoya, tricoya, plywood: 3 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Isoprimer	135 µm	60 µm	Hydrolux Top-coat thix	130 µm	50 µm	Hydrolux Topcoat thix	130 µm	50 µm



Meranti, red grandis, redwood, pine heartwood, accoya, tricoya, plywood: 3 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Filling primer or Hydrolux Basecoat	165 µm	60 µm	Hydrolux Filling primer or Hydrolux Basecoat	160 µm	60 µm	Hydrolux Topcoat thix	120 µm	40 µm



Meranti, red grandis, redwood, pine heartwood, accoya, tricoya, plywood: 3 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Filling primer or Hydrolux Basecoat	165 µm	60 µm	Hydrolux Topcoat thix	130 µm	50 µm	Hydrolux Topcoat thix	130 µm	50 µm



Idigbo, iroko, utile, sapele, meranti, red grandis, pine heartwood, accoya, tricoya, plywood:

1 x flowcoat + 2 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Flowcoat	100 µm	10µm*	Hydrolux Isoprimer	170 µm	80 µm	Hydrolux Topcoat thix	190 µm	70 µm

*most of flowcoat penetrates into timber



Meranti, red grandis, redwood, pine heartwood, accoya, tricoya, plywood:

1 x flowcoat + 2 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Flowcoat	100 µm	10µm*	Hydrolux Filling primer or Hydrolux Basecoat	170 µm	80 µm	Hydrolux Topcoat thix	190 µm	70 µm

*most of flowcoat penetrates into timber



Meranti, red grandis, redwood, pine heartwood, accoya, tricoya, plywood:

1 x flowcoat + 2 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Flowcoat	100 µm	10µm*	Hydrolux Topcoat thix	200 µm	80 µm	Hydrolux Topcoat thix	200 µm	80 µm

*most of flowcoat penetrates into timber



Meranti, red grandis, redwood, pine sapwood and heartwood, accoya, tricoya, plywood:

1 x flowcoat, dip or saturation spray + 2 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Impregnation	120 µm	0µm*	Hydrolux Filling primer or Hydrolux Basecoat	170 µm	80 µm	Hydrolux Topcoat thix	190 µm	70 µm

*Hydrolux impregnation penetrates completely into timber



Meranti, red grandis, redwood, pine sapwood and heartwood, accoya, tricoya, plywood:

1 x flowcoat, dip or saturation spray + 2 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Impregnation	120 µm	0µm*	Hydrolux Topcoat thix	200 µm	80 µm	Hydrolux Topcoat thix	200 µm	80 µm

*Hydrolux impregnation penetrates completely into timber



SYSTEM SPECIFICATIONS

TRANSLUCENT FINISH EXTERIOR JOINERY

Meranti, red grandis, accoya, tricoya, plywood:

1 x flowcoat, dip or saturation spray + 2 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Ankolux Impregnation Primer	120 µm	0µm*	Woodcoat TP	150 µm	50 µm	Woodcoat TP	150 µm	50 µm

*Ankolux Basestain penetrates completely into timber



Meranti, red grandis, redwood, pine sapwood and heartwood, accoya, tricoya, plywood:

1 x flowcoat, dip or saturation spray + 2 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Impregnation	120 µm	0µm*	Woodcoat TP	150 µm	50 µm	Woodcoat TP	150 µm	50 µm

*Hydrolux impregnation penetrates completely into timber



Meranti, red grandis, redwood, pine sapwood and heartwood, accoya, tricoya, plywood:

1 x flowcoat, dip or saturation spray + 2 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Impregnation	120 µm	0µm*	Hydrolux Transparant	170 µm	50 µm	Hydrolux Transparant	170 µm	50 µm

*Hydrolux impregnation penetrates completely into timber



Meranti, red grandis, redwood, pine heartwood, accoya, tricoya, plywood:

3 x spraying

1 st coat			2 nd coat			3 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Transparant (with darkest color)	120 µm	35µm	Hydrolux Transparant	150 µm	45 µm	Hydrolux Transparant	150 µm	45 µm



Meranti, red grandis, redwood, pine sapwood and heartwood, accoya, tricoya, plywood:

1 x flowcoat, dip or saturation spray + 3 x spraying

1 st coat			2 nd coat			3 th coat			4 th coat		
Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film	Product	Wet film	Dry film
Hydrolux Impregnation	120 µm	0µm*	Ankolux Aqua Iso Primer	150	30	Woodcoat TP	150 µm	50 µm	Woodcoat TP	150 µm	50 µm

*Hydrolux impregnation penetrates completely into timber



Surface preparation

Timber moisture content should be between 12% and 16%. For Accoya moisture content should be below 8%. The substrate must be clean, dry and free from dust, dirt, grease, silicone and wax. Follow the appropriate Anker Stuy coating specification for other system products such as top coats and end grain sealers.

Filling of gaps, defects and v-joints

Small gaps and cracks with a width up to 2mm can be filled with 19-0257 Ankolux Woodfiller. This filler can be applied prior to the application of any coating or in between coats. Due to its white colour it is not suitable for translucent coatings.

Use of timber with cracks, gaps or other defects larger than 2mm is not preferred for joinery facing the weather. If repairs on larger defects need to be made then a 2 pack filler is preferred which has sufficient flexibility to follow dimensional movement of the timber. Due to this regular filling putties are not suitable.

V-joints in (for example) panel doors can best be filled with 25-0353 Hydrolux V-Joint Sealer. This filler can be applied prior to the application of any coating or in between coats. To ensure a smooth finish, it is preferable to lightly sand the application area with 100-120 grit sanding paper prior to the application of Hydrolux V-Joint Sealer. Hydrolux V-Joint Sealer is colourless (also when exposed to moisture) and hence also suitable for translucent systems.

Joint protection

Joints in timber windows and doors require special attention to avoid capillary water-uptake into the joint and subsequent uptake of water into the end grains of the timber inside the joint.

Traditional white wood glues (including those specified for external use) have limitations in protecting the timber from capillary water-uptake into the joint due to their non-filling nature. Sections of the joint that are not in direct contact with the weather can be fixed with traditional wood glues, provided that the guidelines according to EN 204 category D4 are met. Glue lines that are in direct contact to weather or in other words the ones on the external part of the joint, are best glued with 99-000 Frencken 0819 SLS window frame adhesive. This also applies to flush joints.

This adhesive is gap filling and does not shrink when dried. It can be applied with a suitable gun from the cartridge it is supplied in. Excess material can be removed with 99-100 Frencken Cleaning Wipes and 99-200 Frencken Stripping spray. Frencken 0819 SLS can be overcoated with any Hydrolux product between 0.5 and 24 hours of application. If it is expected that time between application of glue and coating is longer the glue can be overcoated with a thin coat of 25-0352 Hydrolux End grain Sealer prior to spray painting.

Frencken 0819 SLS window frame adhesive is also very suitable to glue weatherboards and cassettes on doors as well as to seal gaps between glazing beads and plant-on bars.

End grain protection

Since water uptake in timber is approximately 10 times greater longitudinally, the protection of end grains are paramount in keeping water out of timber. 25-0352 Hydrolux End grain Sealer should be applied on any end grains. For hardwoods one coat of endgrain will be sufficient, for softwoods and Accoya 2 coats of end grain are required. Hydrolux End grain Sealer can both be applied onto bare timber as well as after the first spray or flowcoat primer.

- Outer corners of windows frames, sashes and doors.
- End of glazing beads (if these are cut to length after coating application, end grain sealer must be applied prior to assembly).
- Ends of weatherboards and bottom sections of doors.
- Ends of cladding boards.
- All edges or profiles on wooden panels.

Application possibilities

Product	Airless	Air-assisted airless	Flowcoat	Dipping	Pot-gun / HVLV	Brushing/ rolling
17-0699 Hydrolux Impregnation	Yes, with small nozzle	Yes, with small nozzle	Yes	Yes	yes	Yes by brush only
17-0549 Hydrolux Flowcoat	Yes, with small nozzle	Yes, with small nozzle	Yes	Yes	yes	no
17-0537 Hydrolux Isoprimer	yes	yes	no	no	Yes, if diluted by 20 %	Yes, with brush additive
17-0540 Hydrolux Filling Primer	yes	yes	no	no	Yes, if diluted by 20 %	Yes, with brush additive
17-0535 Hydrolux Basecoat	yes	yes	no	no	Yes, if diluted by 20 %	Yes, with brush additive
17-0648 Hydrolux topcoat thix SM	yes	yes	no	no	no	no
17-0649 Hydrolux Topcoat thix SG	yes	yes	no	no	no	no
17-0650 Hydrolux Topcoat Thix GL	yes	yes	no	no	no	no
17-0706 Hydrolux Transparant SM	yes	yes	no	no	no	no
17-0707 Hydrolux Transparant SG	yes	yes	no	no	no	no
17-0708 Hydrolux Transparant GL	yes	yes	no	no	no	no
11-0141 Hydrotop SM	no	no	no	no	yes	yes
11-0140 Hydrotop SG	no	no	no	no	yes	yes
11-0139 Hydrotop GL	no	no	no	no	yes	yes
16-0200 Ankolux Base Stain	Yes, with small nozzle	Yes, with small nozzle	yes	yes	yes	yes
17-0678 Ankolux Aqua Iso Primer	yes	yes	yes	yes	yes	yes
17-0694 Woodcoat TP	yes	yes	no	no	yes	yes

Drying times after each coat depending on application weight and drying conditions

Product	Wet film thickness μm (μm)		10-15 °C	15-20 °C	15-20 °C	20-30 °
	Minimum	Maximum	No air circulation	No air circulation	With forced air speed > 0.2 m/s	With forced air speed > 0.2 m/s
17-0699 Hydrolux Impregnation	120 g/m ²	140 g/m ²	4 hr	2 hr	1 hr	0.5-1 hr
17-0549 Hydrolux Flowcoat	80 g/m ²	120 g/m ²	4 hr	2 hr	1 hr	0.5-1 hr
17-0537 Hydrolux Isoprimer	150 μm	250 μm	4-6 hr	2-3 hr	1-2 hr	Less than 1 hr
17-0540 Hydrolux Filling Primer	150 μm	250 μm	4-6 hr	2-3 hr	1-2 hr	Less than 1 hr
17-0535 Hydrolux Basecoat	150 μm	200 μm	6-8 hr	4-5 hr	2-3 hr	Less than 1 hr
17-0648 Hydrolux topcoat thix SM	150 μm	200 μm	7-8 hr	4-5 hr	2-3 hr	Less than 2 hr
17-0649 Hydrolux Topcoat thix SG	150 μm	200 μm	7-8 hr	4-5 hr	2-3 hr	Less than 2 hr
17-0650 Hydrolux Topcoat Thix GL	150 μm	200 μm	7-8 hr	4-5 hr	2-3 hr	Less than 2 hr
16-0200 Ankolux Base Stain	120 g/m ²	150 g/m ²	4 hr	2 hr	1 hr	1 hr
17-0678 Ankolux Aqua Iso Primer	120 μm	170 μm	8-12 hr	6-8 hr	4-6 hr	3-5 hr
17-0694 Woodcoat TP	120 μm	170 μm	8-12 hr	6-8 hr	4-6 hr	3-5 hr

NOTE: drying times are provided and to be maintained for each coat. At the end of the drying time, the product can be sanded. The subsequent coat can be applied if the previous coat is ready for handling.

IMPORTANT: see next table for minimum time between application of the last coat and exposure to the weather.

Minimum time between application of the last coat and exposure to the weather

Stored indoors at a temperature between 5 and 10 °C	Stored indoors at a temperature between 10 and 15 °C	Stored indoors at a temperature between 15 and 20 °C	Stored indoors at a temperature between above 20 °C
120 hr	72 hr	60 hr	48 hr

Spray settings for (air-assisted) airless spraying

Product	Airless	Air-assisted airless	Materials pressure (bar)	Support air pressure (bar)	Nozzle size 1/1000 inch	Nozzle angle
17-0699 Hydrolux Impregnation	Yes, with small nozzle	Yes, with small nozzle	50-70	Off	0.007-0.010	10-30
17-0549 Hydrolux Flowcoat	Yes, with small nozzle	Yes, with small nozzle	50-70	Off	0.009-0.012	10-30
17-0537 Hydrolux Isoprimer	yes	yes	90-120	0.5-2	0.012-0.016	30-60
17-0540 Hydrolux Filling Primer	yes	yes	90-120	0.5-2	0.012-0.016	30-60
17-0535 Hydrolux Basecoat	yes	yes		0.5-2	0.012-0.016	30-60
17-0648 Hydrolux topcoat thix SM	yes	yes	90-150	0.5-1.5	0.010-0.014	30-60
17-0649 Hydrolux Topcoat thix SG	yes	yes	90-150	0.5-1.5	0.010-0.014	30-60
17-0650 Hydrolux Topcoat Thix GL	yes	yes	90-150	0.5-1.5	0.010-0.014	30-60
17-0706 Hydrolux Transparant SM	yes	yes	90-150	0.5-1.5	0.010-0.014	30-60
17-0707 Hydrolux Transparant SG	yes	yes	90-150	0.5-1.5	0.010-0.014	30-60
17-0708 Hydrolux Transparant GL	yes	yes	90-150	0.5-1.5	0.010-0.014	30-60
16-0200 Ankolux Base Stain	Yes, with small nozzle	Yes, with small nozzle	50-70	Off	0.007-0.010	10-30
17-0678 Ankolux Aqua Iso Primer	yes	yes	80-100	0.5-1.5	0.010-0.012	30-60
17-0694 Woodcoat TP	yes	yes	80-100	0.5-1.5	0.010-0.012	30-60

Notes:

- Material pressure = air pressure on airless pump x ratio of the pump. 4 bar on a 1:30 pump means 120 bar material pressure.
- Nozzle size is specified as a range. If high throughput is needed a larger nozzle is preferred.
- Nozzle angle should be adjusted to shape of object. Small piece like windows can be sprayed with a small angle whereas doors or panels are sprayed with wider angle