



from

CONESTOGA
Wood Specialties Corporation



Sunriver Industries' finishing program is the perfect choice to expand your color palette while minimizing the investment in costly equipment, materials and training. This extensive program offers a wide array of choices with a number of wiping stains, spray stains and glaze combinations; or let us match your finishes with our custom stain match program.

Outsourcing finished components also allows you to identify your true finishing costs for every job, and minimizes your environmental headaches.

And best of all, Sunriver's solid reputation for proven quality, consistency and durability extends throughout our finishing process and is backed by our one-year limited warranty.

Finishing Program Overview

- Sunriver's finishing capabilities allow our customers to simplify their shop process by eliminating the finishing of doors, mouldings and other products. Outsourcing finishing ultimately reduces VOC emissions and helps streamline throughput by minimizing the finishing bottleneck.
- Sunriver's finishing program consists of traditional spray stains, wiping stains, glazes and topcoats. This translates into hundreds of unique combinations.
- Sunriver uses a 20° sheen topcoat. Topcoat glosses will not be custom matched.
- In addition to our standard colors, custom color matching is available. Consult the pricing page of the finishing section for information on custom color charges.

Finishing Process

- Prior to finishing, Sunriver's doors are sanded utilizing both hand and automated sanding techniques to deliver a smooth, "finish-ready" product.
- Doors are finished using a state of the art hanging line. As a result, a hook hole measuring 5/32" in diameter will be drilled in the back of each door and drawer front to accommodate the hanger. These holes are typically positioned in locations that can be concealed by hinges or drawer boxes. The placement of the hole must be specified by the customer at the time of the order placement.
- To apply stains and glazes, Sunriver uses a combination of spray stain and hand-wiped techniques.
- After staining, doors receive sealer and topcoat which provides a clean and consistent finish. The sealer is a high solids material that is applied and then sanded with a fine grit sandpaper after drying. The final coat is a high solids conversion varnish. Conversion varnishes provide a superior kitchen cabinet finish with exceptional clarity, resistance to moisture and overall durability. The final process involves the application of a 20° sheen topcoat. The result is a beautiful finish that is durable, long lasting and resistant to most household chemicals.
- After curing, doors are inspected before being packaged for delivery to our customers.

Finishing Tolerances

- Sunriver's finishing tolerances are designed for solid wood applications. Application of finish on veneers and decorative accent items may result in color variations. Similarly, stains applied by the customer may vary slightly from those products stained by Sunriver. To ensure a close match, customers should contact their Sales or Customer Service Representative and ask about purchasing Sunriver finishing materials. Instructions for application are published in this booklet and enclosed with every can of stain sold.
- Sunriver cannot predict how a door, or portions of a door, will accept stain. Therefore, if a door meets our material specification standards in its unfinished state, it will be considered acceptable after finishing as well.

Finishing Warranties

- Sunriver's finishes carry a one year limited warranty against peeling, blistering or cracking, but no warranty against discoloration. Sunriver assumes no responsibility for damages or poor color match when finish is applied by the customer.
- Most wood species will naturally darken with age. Although Sunriver uses a topcoat that contains a UV inhibitor, which will minimize the effects of color change, we will not be held liable for the change in appearance of any product, finished or unfinished, due to this natural aging process. When adding pieces to existing jobs, that may have aged, please send a sample from the original kitchen to be matched.
- Sunriver recommends that a finished sample door be ordered prior to ordering any finished job. We do not recommend ordering large or complex finished jobs based on a single small sample swatch.

Stains

- All Sunriver finishes are applied using various techniques including a hand rubbed and a spray stain application. The process provides superior grain penetration of the finish material and a greater degree of depth in the finished product.
- Although steps are taken to minimize dark end grain, Sunriver uses wiping stains which penetrate the wood. The end grain will stain and glaze darker than other areas of the piece; this will not be considered defective.

Glazing

- All Sunriver glazes are applied using a hand rubbed application process to the entire surface of both the face and back of each door.
- Glazing is a very subjective treatment. Each door becomes “one-of-a-kind” and unique in its appearance. Even though Sunriver matches every glazed door to a control sample, each door will take glaze differently. Color consistency is more difficult to control on glazed products. Some of the factors influencing color consistency are door style, design options, grain patterns, wood density, stain color, thickness of the sealer coat, sealer sanding and overall size of the piece.
- Glazed products will vary in appearance. Sunriver considers these slight variations acceptable and will not warrant variations of glazes.
- We recommend that our customers develop a document that would be read and signed by the end user indicating their understanding of the potential color issues with stain/glaze combinations. Such a document will help protect all parties in the event of a color-based issue.
- We strongly recommend that a sample door be ordered prior to ordering a full kitchen, regardless of the finish and specie combination.
- Sunriver maintains strict standards for its glazing process. With this in mind, Sunriver will not “custom” glaze a job. Therefore, we offer only our standard glazing options.
- Glazes significantly alter the appearance of a stain/specie combination. An attractive combination may look quite different once glazed.
- Sunriver's standard glaze offering is available in combination with custom finish matches. Customers will be sent a sample which must be approved prior to beginning production.

Custom Stain Matching

- A representative sample of the color match to be achieved must be provided. Once a finish is matched, the customer will be sent two hard samples and asked to sign both an approval document and the back of one sample and return them to us for our records. At that point, a custom color mix number will be assigned, which must be used every time an order is placed for that finish.
- There is a \$200 net charge for the initial custom match, and an upcharge for every subsequent use of an existing custom mix. Allow five days for completion of color matches. Call Customer Service for a quote on packaged quarts or gallons of custom finishes.
- Our in-house matching capability assures our customers a prompt response of all matching requests. Custom mixes are kept on record as long as the finish continues to be used. If no orders are placed using the stain for one year, the mix will be voided. This process guarantees our customers a truly unique stain since it is matched to their exact specifications.
- Sunriver offers one topcoat gloss, a 20°, with no option to custom match other glosses.

Cross Grain Removal

- This sanding step is automatically included at no charge on prefinished doors and drawer fronts.

Customer Responsibilities

- All sample doors and swatches should be properly labeled with species, stain color, date and sales order number.
- Sample doors and swatches should be stored in such a manner that they are not exposed to light or extreme heat for an extended period of time. Exposure to sunlight, indoor lighting or extreme heat will cause samples to discolor and they will no longer be an accurate representation of color. Sample swatches should be discarded when their expiration date is reached.
- Sample doors and swatches should be replaced every 12 months or when they become discolored. Cherry will need to be replaced more frequently than other species. Sunriver cannot guarantee that a current order will match a sample more than 12 months old. Jobs sold from a sample older than one year will not be warranted for color match.
- We strongly recommend that a full kitchen **not be sold from a color swatch**. Order a sample door to show a greater array of possible character effects on a particular design, stain, glaze and specie combination.
- For displays that are older than one year or that may be discolored, we recommend that customers obtain a current sample door in that species, stain and glaze combination. Remember, display kitchens do change color due to their exposure to natural light, indoor lighting, heat and other conditions. The change that takes place is very gradual and may be difficult to detect, especially if viewed daily.
- If a job is ordered based on the color of a sample door or display, make sure the sample is less than one year old and the color is accurate. Customers asking for replacements because the job does not match their sample will be asked to provide the original sample sales order number, so that the age of the sample may be determined. Sunriver will not provide a no charge replacement if the sample is more than 12 months old or is discolored due to excessive exposure.

Finishing Pricing

Charges for Finishing		
Finish Category	Charge (per square foot)	
	Door Charge (no min.)	Drawer Front (1 sq. ft. min.)
Natural Finish	\$5.00	\$6.50
Spray Stain	5.50	7.15
Wiping stain, Low Complexity	6.00	7.80
Wiping stain, High Complexity	6.75	8.75
Glazes	4.75	6.15
Custom Stains (\$200 net initial matching fee)		Available @30% upcharge over appropriate finish category
Finish Complexity/Color Selection		
Natural Finish	Clear sealer and topcoat	
Stains	<i>Spray Stains</i>	Butterscotch, Frost, Wheat
	<i>Low Complexity</i>	Cider, Mocha, Sangria, Spice, Tawny, Toffee
	<i>High Complexity</i>	Blackberry, Clove, Merlot
Glazes	Caramel, Chocolate	

Ancillary Product Pricing

Ancillary Products Finishing Pricing	
Product	Square footage rules
8 foot lineal mouldings (face only)	2 sq. ft.
8 foot lineal mouldings (face and back)	5 sq. ft.
Random length moulding (face only)	2 sq. ft. per 8 ft. length
Random length moulding (face and back)	5 sq. ft. per 8 ft. length
48" x 96" Paper-backed veneers	14 sq. ft.
Wainscot panels finished one side and edges, back surface sealed but not stained	actual sq. footage
finished both sides and edges	actual sq. footage x 2.25
Valances (face and back)	actual sq. footage/2 sq. ft. min.
Fillers, fluted fillers (face and sides only)	actual sq. footage/1 sq. ft. min.
48" x 96" Plywood panels - 1/4" (5.2 mm)	actual sq. footage ÷ 2
Radius doors	actual sq. footage x 1.5

Stain/Glaze Sample Kits

Alder	Cherry	Maple, Hard	Oak, Red
<i>Stain/Glaze</i> Blackberry Butterscotch Butterscotch/Caramel Butterscotch/Chocolate Cider Cider/Caramel Cider/Chocolate Merlot Mocha Natural Sangria Spice Tawny Toffee	<i>Stain/Glaze</i> Blackberry Butterscotch Butterscotch/Caramel Butterscotch/Chocolate Cider Cider/Caramel Cider/Chocolate Clove Merlot Mocha Natural Sangria Spice Tawny Toffee	<i>Stain/Glaze</i> Butterscotch Butterscotch/Caramel Butterscotch/Chocolate Cider Cider/Caramel Cider/Chocolate Frost Mocha Natural Spice Tawny Toffee Wheat	<i>Stain/Glaze</i> Blackberry Butterscotch Butterscotch/Caramel Butterscotch/Chocolate Cider Cider/Caramel Cider/Chocolate Clove Merlot Mocha Natural Sangria Spice Tawny Toffee

Pricing per set: \$35.00 net

Specifications: Swatch size 3" x 6"
Each swatch individually labeled and dated

Sets are packed in a labeled file box, reducing the need to remove individual swatches for identification; this limits the exposure to light that accelerates color change.

Finishing Materials Overview

- The Sunriver loose finishing material program is designed to make it easy to match our products.
- This program provides raw finishing materials, step by step instructions, access to our in-house finishing professionals and support products such as touch up kits.

Program Features

- Access to all spray stains, low complexity and high complexity materials.
- Step-by-step instructions mailed with every quart and gallon of finishing material detailing how to mix raw materials, sand the wood and apply the finish.
- Access to our Finishing Department at (253)395-2704 every working day, from 8:00 a.m. to 4:00 p.m. (PST). We are dedicated to answering any finishing questions our customers may have.

Disclaimers

- Sunriver's finishes are industrial in nature, unlike finishes purchased at a retail store. Although they are of higher quality than most stains, Sunriver's finishes are also more combustible, more volatile and require a greater level of expertise to apply.
- Due to the complexities involved with any finishing process, Sunriver will not be liable for any damages or injuries resulting from the use of this product, even if every precaution is taken by the customer. Sunriver's liability is limited to the original purchase price of the finishing material.
- In order to best match any stain color, it is important to follow the processes outlined in our instruction documents. These instructions are found on the following pages. If the proper steps are not followed, the finished product may not match the finished products that were purchased from Sunriver. However, please bear in mind that following these procedures will not always guarantee an exact match.
- Due to the many variables involved in any finishing process, Sunriver assumes no responsibility if products stained by the customer using our finishes do not produce an exact match to prefinished products purchased from Sunriver.

Finish Pricing

Finish Pricing		
Product	Quart	Gallon
Butterscotch Spray Stain	\$14.00	\$33.00
Frost Spray Stain	14.00	33.00
Wheat Spray Stain	14.00	33.00
Cider Wiping Stain	27.00	63.00
Mocha Wiping Stain	27.00	63.00
Sangria Wiping Stain	27.00	63.00
Spice Wiping Stain	27.00	63.00
Tawny Wiping Stain	27.00	63.00
Toffee Wiping Stain	27.00	63.00
Blackberry Wiping Stain	29.00	68.00
Clove Wiping Stain	29.00	68.00
Merlot Wiping Stain	29.00	68.00
Caramel Glaze	21.00	49.00
Chocolate Glaze	21.00	49.00

Custom stain match materials are mixed on a per-order basis and cannot be expedited.

Finishing Instructions

Spray Stains

Sunriver spray stains are available on all standard wood species and utilize a 20° sheen topcoat.

Use this process to match Sunriver Industries' Butterscotch, Frost and Wheat finishes only.

- White wood sand with an oscillating palm sander using 180 grit sandpaper.
- Stir spray stain thoroughly before use.
- An air assisted airless pump is recommended for spray stain application. For best results the fluid pressure should be set at 300 pounds and the air pressure to the gun should be set at 10-15 pounds. Other spray equipment such as a diaphragm pump or a cup gun can be used if an air assisted airless pump is not available. The diaphragm pump air pressure should be set at 5 pounds of fluid pressure and 15 pounds of air pressure.
- It is recommended that the operator test the process on scrap wood before spraying actual products to refine application technique.
- Apply spray stain evenly to the wood surface. Proper color can be achieved in one coat, one pass.
- Allow 15 minutes to dry.
- Your color coat is complete; you are ready to now apply your sealer per manufacturer's recommendations.
- If applying a glaze, see glaze instructions found on the following pages.
- You are ready to now apply your topcoat per manufacturer's recommendations.
- We recommend the use of Sherwin-Williams® sealer and topcoat materials over our stains. Contact your local Sherwin-Williams Sales Representative.

Wiping Stains/ Low Complexity

All Sunriver low complexity wiping stains are available on many standard wood species and utilize a 20° sheen topcoat.

Use this process to match Sunriver Industries' Cider, Mocha, Sangria, Spice, Tawny and Toffee finishes only.

- Whitewood sand with an oscillating palm sander using 180 grit sandpaper.
- Stir wiping stain thoroughly before use.
- Check color on scrap wood before applying to production products.
- Apply wiping stain evenly to surface of wood. Wipe all surfaces with a clean lint free rag.
- Allow wiping stain to dry for a minimum of one hour.
- Your color coat is complete; you are ready to now apply your sealer per manufacturer's recommendations.
- If applying a glaze, see glaze instructions found on the following pages.
- You are ready to now apply your topcoat per manufacturer's recommendations.
- We recommend the use of Sherwin-Williams sealer and topcoat materials over our stains. Contact your local Sherwin-Williams Sales Representative.

Finishing Instructions (continued)

Dye-stain/High complexity

All Sunriver high complexity stains are available on many standard wood species and utilize a 20° sheen topcoat.

Use this process to match Sunriver Industries' Blackberry, Clove and Merlot finishes only.

- Whitewood sand with an oscillating palm sander using 180 grit sandpaper.
- Stir dye-stain thoroughly before use.
- The dye-stain application can be applied using a diaphragm pump or a cup gun if an air assisted airless pump is not available. The diaphragm pump air pressure should be set at 5 pounds of fluid pressure and 15 pounds of air pressure.
- It is recommended that the operator test the process on scrap wood before spraying actual products. Test dye and stain combination to ensure desired results. The sanding and color of the wood may vary, but the amount of dye, more or less, may need to be adjusted to achieve desired color.
- Spray an even coat of dye across the entire surface of the product.
- Allow 15 minutes to dry before applying wiping stain.
- Stir wiping stain thoroughly before use.
- Apply wiping stain evenly to surface of wood. Wipe all surfaces with a clean lint free rag.
- Allow wiping stain to dry for a minimum of one hour.
- Your color coat is complete; you are ready to now apply your sealer per manufacturer's recommendations.
- If applying a glaze, see glaze instructions found on the following pages.
- You are ready to now apply your topcoat per manufacturer's recommendations.
- We recommend the use of Sherwin-Williams sealer and topcoat materials over our stains. Contact your local Sherwin-Williams Sales Representative.

Glaze over Spray Stains and Wiping Stains

Use this process to apply glazes over all Sunriver Industries' spray stains and wiping stains.

- When sealer is completely dry, hand sand all surfaces using a 320 grit sandpaper. Make sure to sand the same direction as the wood grain.
- Stir glaze thoroughly before use.
- Apply the glaze to the entire surface and wipe the excess glaze off with a lint free rag, leaving the desired amount of glaze in profiled areas. When matching existing products, make sure the same amount of glaze is left on the surface of the product being glazed as is on the product to be matched. Allow glaze to dry for a minimum of 6 hours.
- You are ready to now apply your topcoat per manufacturer's recommendations.
- We recommend the use of Sherwin-Williams topcoat materials over our stains. Contact your local Sherwin-Williams Sales Representative.



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