

# Eggers Finishing Systems

Information Bulletin 454



Eggers Industries

Date: July 2011

Eggers provides the widest selection of finishing systems in the industry. Our wide range of finish systems are anchored by Gardall, consisting of water based stains and 100% solid clear coats which contain no VOC's. Gardall is an environmentally friendly finish system.

Eggers' Gardall finish system meets or exceeds the performance standards set by WDMA and AWI System TR-6 Catalyzed Polyurethane. Eggers' broad selection of finishing systems provides a cost effective alternative to field finishing. With factory finishing, you can expect superior color consistency and uniformity.

### ***Neenah Division Finishing Process:***

Our Neenah division utilizes a precision roll coating finishing process that results in six coats of finish with a final dry coating thickness of 1.5 mils. Multiple thin coats of material offer a high-quality smooth appearance with the durability that is essential in the commercial door industry.

### ***Two Rivers Division Finishing Process:***

Our Two Rivers Division utilizes a top-of-the-line spray finishing system with automatic spray guns all in an enclosed chamber. Eggers has implemented strict manufacturing procedures and processes to address and avoid the common finishing issues and we take great pride in the superior quality our finishing system provides.

## **OTHER SYSTEMS AVAILABLE**

### **Gardall Plus**

This is the same Gardall finish system but it has additional sealer and/or topcoats applied. This is used for specifications that call out filled effect finish or semi-filled. Ask for clarification whenever filled effect is listed in a specification.

### **Gardall Supreme**

This is a paste filled finish system. This is used when specifications call out for a full filled finish and is available through our Two Rivers facility only.



**Stile & Rail Doors, Door Frames,  
Plywood, Veneered Components**

**Two Rivers Division**  
One Eggers Drive  
Two Rivers, WI 54241  
Phone: 920.793.1351  
Fax: 920.793.2958

[www.eggersindustries.com](http://www.eggersindustries.com)

**Flush Doors**

**Neenah Division**  
164 North Lake Street  
Neenah, WI 54956  
Phone: 920.722.6444  
Fax: 920.722.0357

email: [sales@eggersindustries.com](mailto:sales@eggersindustries.com)



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### **Opaque Finish**

Our opaque finish is offered as an OP-4 or OP-6 and we can match any color. This finish is often referred to as a “painted finish”. AWI does not recognize “paint” as a finish system, only opaque varnishes, as “paint” is too generic of a term to be used as a designated architectural grade finish.

### **Ebonized Finish**

This finish blackens the veneer and is done in one of two methods depending upon the look that is desired. We will either utilize stain or diluted opaque varnishes to obtain the desired color.

### **Cerused Finish**

A cerused finish which is also known as a limed finish, is when the product is finished completely and then a white pigmented varnish is wiped over the door and then wiped off. The white pigment remains in the grain, therefore, highlighting the grain. This finish is available through our Two Rivers facility.

### **Whitewash Finish**

A white stain is used to achieve this specialty look.

### **Toned / NGR Finishes**

These systems are available by special request. These non-wiping stain application (NGR) finishes have the colorants incorporated into the transparent finish coats.

### **Exterior Finish**

Exterior finish is different than any other finish system we offer. All exterior doors are finished with an exterior grade spar urethane, a water and UV resistant finish. This is a specially formulated finish designed to withstand extreme environmental conditions. It contains special oils to help the finish expand and contract with wood as the humidity and temperature change.

These are not permanent finishes and will require yearly maintenance to preserve the integrity of the finish. Our exterior finish includes the preservative treatment which is a fungicide and mildew-resistant treatment that is sprayed on the doors prior to stain and topcoats. It contains water repellants to aid in control of checking and grain raising.

Due to the preservative treatment and the general characteristics of spar varnish, the overall appearance of an exterior finish is different than our interior finishes. Sample approval for both interior and exterior finishes will be required for all projects.



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**Factory Finish Specifications**

Section 08200, Part II, Prefinish:

Doors to be factory finished to meet or exceed WDMA I.S. 1A-04 specifications for a TR-6 catalyzed polyurethane finish system or AWI Section 1500 specifications for a UV curable polyester urethane finish system.

Specify Eggers' Gardall UV – a water-based stain and UV curable polyester urethane finish system which complies with all applicable Federal and State regulations for Volatile Organic Compounds (VOC) and Hazardous Air Pollutants (HAP) emission limitations per the EPA Clean Air Act.

**Additional Specification Information:**

Industry standards allow doors with a full range of color and grain that exist naturally in species. Veneer color and characteristic may vary between species, within the same specie, and potentially within a flitch. Selection of veneer for a more uniform color and grain is available from Eggers. Projects requiring doors to match exactly or match uniformly in color or grain must be specified at the time of quotation.



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