

BEHIND THE FINISH: STAIN FINISH



Every stain finish begins with raw red oak veneer, chosen for its natural grain and strength. Through a controlled process of brushing, sanding, layering, and sealing, we achieve a semi-transparent look that highlights the beauty of the wood while adding lasting protection.

Color Board: Semi-Transparent Red Oak

Base Material: Red Oak Veneer

Coating System: PU (Open Pore)

Drying Room Conditions: 30°C / 70% RH



THE PROCESS

The 10 Step Stain Finishing Process

1. GUIDE BRUSHING

- Material: Copper Brush
- Method: Machine / Hand Brush
- Note: Brush along the wood grain to open the texture

2. SANDING

- Material: Sandpaper #320 / #400
- Method: Machine / Hand Sanding
- Note: Smooth sanding, no fibers raised.

3. BASE WIPING STAIN

- Material: Semi-Transparent Color (Self-Tinted)
- Method: Manual Wiping
- Note: Match to color board.

4. PU PRIMER COAT

- Material: ZP41102 : ZPH7006 : ZPX2039
(Mixing Ratio 1 : 0.25 : 1.2)
- Method: Manual Spraying
- Viscosity: T2 = 10s
- Application: 60–80 g/m²
- Drying: 4 Hours
- Note: Spray evenly in a cross pattern.

5. SANDING

- Material: Sandpaper #400 / #600
- Method: Machine / Hand Sanding
- Note: Sand smooth along wood grain.

6. PU PRIMER COAT

- Material: ZP41102 : ZPH7006 : ZPX2039
(Mixing Ratio 1 : 0.25 : 1.2)
- Method: Manual Spraying
- Viscosity: T2 = 10s
- Application: 60–80 g/m²
- Drying: 4 Hours
- Note: Spray evenly in a half-cross pattern.

7. SANDING

- Material: Sandpaper #400 / #600
- Method: Machine / Hand Sanding
- Note: Sand smooth along wood grain.

8. COLOR TOUCH-UP

- Material: Semi-Transparent Color (Self-Tinted)
- Method: Manual Wiping
- Drying: 2 Hours
- Note: Match to color board.

9. LIGHT SANDING

- Material: Sandpaper #800 – #1000
- Method: Manual Hand Sanding
- Note: Remove surface particles.

10. TOPCOAT (FINISH)

- Material: ZP5111A : ZPH7006 : ZPX2039
(Mixing Ratio 1 : 0.25 : 1.3)
- Method: Manual Spraying
- Viscosity: T2 = 9s
- Application: 40–60 g/m²
- Drying: 48 Hours
- Note: Spray evenly in a cross pattern.

After 10 carefully controlled steps, the surface reveals a semi-transparent depth that highlights wood grain while protecting it for long-lasting use.

From raw veneer to refined cabinetry, our stain finishes combine beauty, craftsmanship, and protection in one seamless process.

Crafted for beauty. Designed to last.