

# N-Hance Process Sheets

## Custom Colour Change

**\*ONCE APPLIED, ALL N-HANCE PRODUCTS HAVE A 4-HOUR WINDOW TO CHEMICALLY BOND TO ONE ANOTHER -- IF THE PRODUCT APPLIED HAS DRIED FOR MORE THAN 4 HOURS, THE CHEMICAL WINDOW HAS CLOSED AND A MECHANICAL BOND IS REQUIRED FOR BEST ADHESION\*** (See pg. 16 in NBT Manual)

### 1. Test For Moisture

- Use a Moisture Meter to measure the amount of moisture that could be trapped in the wood

### 2. Clean

- Use a 3M Maroon Hand Pad (1/2 pad per door)
- Use a Surface Prep Pro solution made up of 12-16 parts water to 1 part Surface Prep Pro
- ALWAYS clean WITH the wood grain
- Wipe surface clean (Repeat steps if surface is still sticky or greasy)

### 3. Repair damaged areas with Trowel Filler or Fast Patch, allow to dry

### 4. Lightly Sand entire surface with 220 grit sandpaper

### 5. Dry Tack

- Use microfiber cloth to remove all dust and debris. Lightly spray denatured alcohol on cloth to clean off surface-prep pro residue, if necessary.
- Use moisture meter to make sure water has not increased more than 1% higher than first reading.

### 6. Apply Primer

- Thoroughly mix then apply 1-2 coats (Between 3-6 wet MILS ea.) of XB White or Deep Primer to ensure grain is filled. (For vertical surfaces: Between 3-5 wet MilS. More than 5 wet MilS will cause runs.)
- Allow appropriate time for drying between coats. (Dry to the touch and room temperature)
- If bleed through is a concern add XB Hardener to primer (see XB Hardener Process sheet for mixing instructions)
- If there are rough or uneven areas hit with 220 grit or higher sandpaper

### 7. Apply Colour

- Allow primer to dry before applying N-Hance Tint Base
- Thoroughly mix then apply N-Hance Tint Base (Between 2-3 wet MILs for flat surfaces, ~2 wet MILs for vertical surfaces)
- Spray 2-3 coats OR until full coverage is achieved
- Allow appropriate time for drying between coats. (Dry to touch and room temperature)

### 8. Apply Finish

- If Medium or Deep Tint base was used, apply a test coat of Lightspeed to an inconspicuous area. Let sit for 5 min and watch for issues (Examples: back of a drawer front, unseen end panel, inside of fridge panel, etc.)
- Apply finish to all pieces (2-3 wet MILs for flat surfaces, ~1 wet MIL for vertical surfaces)
- Apply 2<sup>nd</sup> coat of finish, if desired
- If Lightspeed Nano was used, UV cure the finish coat(s)
- If Ultra Clear was used, inform the customer the cabinet doors and drawers should be left open for 24 hours and the cabinets treated gently for a few days while the finish is curing (Do NOT use Hydro Oil on White Tint Base jobs)