It takes a 160-foot “state of the art” finish line to achieve the industry leading **CAMGARD FINISH** on an architectural flush door. This environmentally friendly, Ultra Violet (U.V.) cured system applies water based, non-toxic 100% polyurethane solids with no off gassing of volatile organic compounds (VOC’s). To further enhance the doors coating, an anti-microbial additive that aids in deterring the spread of unwanted germs from person to person has been added. This additive has proven to be beneficial in projects such as nursing homes, hospitals, schools as well as offices. Offering five standard stain colours on any given specie, creates an array that can suite most projects. When that special project requires all trades to tie their finish colours together, custom matching is easily available if required.

Camgard Flush Door Finish System

Our **"Camgard Finish System"** is an environmentally friendly water based product with performance characteristics equivalent to or better than AWI TR-6 or OP-6 systems.

Standard Qualities

- Semi filled appearance (true filled finish available upon request).
- Satin sheen from 20 to 25 degrees.
- Two brushes and 4 roller coats for deep stain and top coat penetration.
- 100% polyurethane solids.
- No volatile organic compounds (VOC's)
- Water white formula ensuring lasting clarity.
- Both solvent and moisture resistant.
- Resistant to most common chemicals used.
- Impact resistant from a 1 lb steel ball at 17 inches.
- Impervious to either inks or common markers.

The Process

1. Door passes through 150 grit electronic finish sander.
2. Stain rolled on to face.
3. Stain pushed into pores with double headed brushing unit.
4. Stain applied and brushed into stiles.
5. Door passes through 1st U.V. drying oven.
6. Polyurethane sealer applied to face and edge.
7. Door passes through 2nd U.V. drying oven.
8. Door passes through 180 grit electronic finish sander.
9. Polyurethane finish coat applied to face and edge.
10. Door passes through 3rd U.V. drying oven.
11. Door is auto-flipped for processing the opposite side.

After the second side is completed doors are quality checked and wrapped with a plastic covering for protection. Certain species such as Cherry, White Oak, Walnut and Fir are wrapped with a dark opaque plastic due to light flashing.

Finally: U.V. cured polyurethanes are one of the most durable finishing technologies for wood products today, used in such places as flooring in both the commercial and residential markets with excellent results.

CAMBRIDGE DOOR

Policy on Field Finishing

Note: Cambridge Door Inc. is not responsible for the quality and appearance of field-finished doors. The following document is to help the field finisher with their tasks and/or responsibilities.

1. **Preparation**
   A. Before applying any finish, thoroughly block-sand both faces with 120 to 180 grit sandpaper in order to remove all scuffs, scratches, burnishes, raised grain, handling marks and effects of exposure to moisture. Thorough sanding cannot be done without using a sanding block, and the door must be in a horizontal position. Always sand with the grain of the wood. Do not use steel wool.
   B. Surface must be clean and dry.
   C. To help assure uniform color when applying any stains, it is highly recommended that a wash coat be applied, followed by a light sanding.
   D. Clean surface with tack rag or other suitable means.
   E. Apply finish as soon as possible after the doors have been properly prepared.
   F. If possible, test surface(s) for compatibility with finishing products. In some veneers, there will be a reaction with certain finishes.
   G. It is not recommended to apply dark stains to light coloured species especially, Hard Maple.

2. **Finishing (Interior)**
   A. Clean surface of all dust or dirt.
   B. Use only high-grade finishing products, and carefully follow the manufacturer's directions. Do not blend products from different suppliers.
   C. Apply seal coat to both faces and four edges; allow for thorough drying. Sand lightly with 120 to 180 grit sandpaper. This seal coat will allow uniform staining of the veneers when stained or when a filler stain is required. If veneers are not sealed prior to staining, the surface may appear more streaked or blotchy.
   D. Apply stain as required. Allow product(s) to dry thoroughly. It is essential to maintain the door in a horizontal position when applying any stains. This ensures easier handling of substances and prevents any solvents from evaporating too rapidly, which is a frequent origin of streaks caused by the stains "setting up" before clean-up can be completed. If problems arise in finishing do not continue with the finishing. Notify your finishing material supplier or door supplier immediately. Avoid extremely dark stains on light colored woods. The darker the stain the better the preparatory sanding must be.
   E. Apply two coats of topcoat for best results. Allow drying and sanding between coats.
   F. Apply finish to both faces and edges of doors.
   G. The above procedure, if followed carefully, should result with a gratifying finish to the doors.

3. **Finishing (Exterior)**
   A. Prepare doors as above in Steps A and B.
   B. If pigmented finishes are used, follow the manufacturer's instructions carefully and finish according to their specifications.
   C. Follow Step C as above, but be sure to apply at least two finish coats for good exterior durability. Annual recoating is necessary to protect the door and maintain warranty.
   D. Use high-grade exterior finishing materials and carefully follow the finishing manufacturer's instructions.

4. **Important Notes**
   A. If the customer cannot prove that the material supplied by Cambridge Doors Inc. was handled as outlined above, we cannot be held liable for problems that may be encountered.
   B. If these instructions are contrary to instructions supplied by the finish manufacturer, all work should stop until an understanding between finish supplier and door supplier is reached.
   C. Doors with paint grade veneers, as opposed to medium density overlay, may require additional field preparation before application of the final coats. Additional preparation may include puttying and/or sanding because of hidden surface blemishes or different absorption of finish coats. All doors must be inspected for color match, face grade or other visual defects prior to installation and finishing.
   D. FAILURE TO FOLLOW THE ABOVE FINISHING INSTRUCTIONS PUTS TOTAL RESPONSIBILITY FOR THE APPEARANCE OF FINISHED PRODUCTS IN THE HANDS OF THE JOBSITE FINISHER.