

Finishing Program Overview

- Conestoga'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.
- Conestoga's finishing program for bamboo products consists of traditional wiping stains, glazes, and topcoats.
- Conestoga has two topcoats available: 15° (low sheen) and 40° (medium sheen). Topcoat glosses will not be custom matched.

Finishing Process

- Prior to finishing, Conestoga's doors are sanded on the automated sanding line to deliver a smooth, "finish-ready" product.
- To apply stains and glazes, Conestoga uses a time-proven, hand-wiped technique which delivers more color consistency and depth than simple spray stain applications.
- Most Conestoga framing beads are designed with a slight back bevel, which allows the stain to penetrate beyond the juncture of the framing bead and panel raise. During the staining process an air nozzle is used to blow stain under the framing bead, minimizing the possibility of "white lines" appearing on the panel raise during expansion and contraction. All doors are matched to a control sample for color consistency during the staining process.
- After staining, doors are loaded onto our state-of-the-art flat line finishing system to receive sealer and topcoat. The equipment 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 their exceptional clarity, resistance to moisture and overall durability. The final process involves the application of a 15° or 40° sheen topcoat on wiping stains and a 15° sheen topcoat on products with a glaze finish. The 15° sheen topcoat is standard on some wiping stains, but usually must be specified, check with Bamboo Advantage for availability. 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

- Conestoga's finishing tolerance are designed for solid wood applications. Similarly, stains applied by the customer may vary slightly from those products stained by Conestoga.
- Conestoga can not 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.

Wiping Stains

- All Conestoga wiping stains are applied using a hand rubbed application. The process provides superior grain penetration of the finish material and a greater degree of depth in the finished product.
- Conestoga does not recommend darker finishes such as Colonial, Cordovan or Washington Cherry for bamboo. Therefore, these combinations are Not Recommended (NR), but can still be produced with an upcharge and no warranty on color consistency.
- Because Conestoga uses wiping stains, and wiping stains penetrate the wood, end grain will stain and glaze darker than other areas of the piece. This will not be considered defective.

Glazing

- All Conestoga glazes are applied using a hand rubbed application process to the entire surface of both the face and back of every door.
- Glazing is a very subjective treatment. Each door becomes "one-of-a-kind" and unique in its appearance. Even though Conestoga 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. Conestoga considers these slight variations acceptable and will not warrant variations of glazes.
- We strongly recommend that a sample door be ordered prior to ordering a full kitchen, regardless of the finish and specie combination.
- Conestoga maintains strict standards for its glazing process. With this in mind, Conestoga 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. With this in mind, we do not recommend certain glaze combinations, and some combinations are not available. See the Offering and Availability charts in this section for details.

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 with their expiration date is reached.
- Sample doors and swatches should be replaced every 12 months or when they become discolored. Conestoga cannot guarantee that a current order will match a sample ore than 12 months old. Jobs sold from a sample swatch 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.
- If a job is ordered based on the color of a sample door or display, make sure that the sample is less than one year old and the color is accurate.

Using the Offering and Availability Chart

The offering and availability chart below should be reference prior to placing an order.

- Locate the desired finish in the top row.
- The box where the finish, specie and glaze combination intersects, will contain one of the following references:
 - **R – Recommended:** These finish combinations refer only to the consistency of the finish application and not the aesthetic beauty of the combination.
 - **NR – Not Recommended:** These finish combinations are problematic and do not meet Conestoga’s standards for color consistency. They also highlight various other characteristics such as machine marks and open end grain that will not be considered defective. NR combinations will receive a 20% up charge to the design charge compensating for additional labor required for difficult combinations. Even if a sample door is purchased, we cannot guarantee that the next order will be an exact match to the sample door. Conestoga will not guarantee color consistency on NR combinations.
 - **NA – Not Available:** Such combinations present application challenges which result in finish appearances Conestoga cannot consistently reproduce, and are not available.

	Alpine	Autumn	Bordeaux	Chestnut	Colonial	Cordovan	Espresso	Ginger	Harvest Gold	Honey	Mesa	Natural	Nutmeg	Washington Cherry
No Glaze	R	R	NR	NR	NR	NR	NR	R	R	NR	R	R	R	NR
Brown	NA	R	NA	NR	NR	NR	NA	R	R	NR	NR	R	R	NR
Caramel	NA	R	NA	NR	NR	NR	NA	R	R	NR	NR	R	R	NR
Pewter	NR	R	NA	NR	NR	NR	NA	R	R	NR	NR	R	NR	NR
Sable	NA	NR	NR	NR	NR	NR	NR	R	R	NR	NA	NA	NA	NR
White	R	R	NA	NA	NA	NA	NA	R	R	NA	R	R	R	NA

Finish chip kits contain the following combinations:

Bordeaux	Chestnut	Chestnut w/ Sable glaze	Colonial	Cordovan	Cordovan w/ Sable glaze	Espresso
Ginger	Ginger w/ Brown glaze	Honey	Honey w/ Sable glaze	Natural	Natural w/ Caramel	Washington Cherry

Individual Recommended and Not Recommended swatches are also available, call Bamboo Advantage for details.