WOOD LINE

LIMITLESS BEAUTY AND PROTECTION

YACHTING Veneziani™

WOOD LINE

Let's take care of your boat together

Your boat is your greatest passion, and ours too. If we want it to keep taking you on trips out to sea as long as possible and let you enjoy constant contact with nature, we must give it all the attention it deserves. And if it is a boat made from wood, a material as noble as it is delicate, it needs special care.

Wood is an alive material, with a variety of types and peculiarities that can only nature can produce. Protection and seasonal maintenance are essential to ensure a long life and to bring out its natural beauty.

For all these reasons, we created **WOOD Line**, the comprehensive range of products to care for and protect all wood surfaces on boats.
Varnishes, stains, resins, and specific products for teak that deliver superior performance in terms of protection, durability, and adaptability.
For interiors and exteriors, each product is developed specifically to enhance the appearance of all the various types of wood. The line also includes products that are water-based, odourless and high-performance, ideal for interiors and low ventilation areas.

Find out about all maintenance and finishing operations, product features and the steps to take to look after the wood on your boat with our **WOOD Line** products.

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Getting off on the right foot

Keep safe too

Carefully read the instructions printed on the pack before starting work. Specifically:

- Check the **safety label** for any special precautions that must be taken.
- If the necessary documentation is not available, please consult the website **www.venezianiyachting.com** where you will find all the technical information about the product you are about to use.

If you have chosen solvent-based products, remember that they may contain flammable substances that can evaporate during drying:

- **Don't smoke during application and do not use compressed air** to remove dust from clothing.
- Ensure good ventilation and be careful **not to inhale the vapours, especially in a closed environment**.
- Use an appropriate mask and PPE.

Regardless of the type of product, it is always recommended to use **gloves, mask, and protective glasses.**

The difference between one-pack, two-pack and water-based products

ONE-PACK PRODUCTS

One-pack products are easier to prepare (or ready to use), consist of only one component, and film formation is by oxidation or evaporation of the solvent.
These products are easy to apply, while ensuring good quality and durability.

TWO-PACK PRODUCTS

Two-pack products consist of two components mixed in a specific ratio (mixing ratio). Filming occurs by means of chemical cross-linking of the two components. This process results in longer durability and better protection, also against UV rays.

WATER-BASED PRODUCTS

Water-based products are odourless, formulated with raw materials that are not harmful to the environment or humans, and have the same characteristics as solvent-based products. They are ideal for interiors and poorly ventilated areas.

Application tips

Where paint products are concerned, the quality of the result is proportional to the time and care taken when **preparing the surfaces** to paint.

When you are planning to paint, always remember the following guidelines, which will ensure precision and prevent you from making mistakes.

Mask the edges of the area to paint using **adhesive tape**. Always remember to remove the tape immediately after the application of each coat, especially when using two-pack paints.

Wet the area around the boat to prevent dust from settling on the wet paint.

Dilute the product only if indicated in the instructions and with the specified thinner.

Stir carefully, to obtain a uniform consistency and colour, especially if the pigment (at the bottom) has separated from the binders (at the top).

Comply with the recommended drying times even if the paint appears to be dry.

Apply at a temperature of between 15 and 25°C and with a humidity of less than 75%. It is possible to work at higher or lower temperatures than these, but you must expect the drying characteristics to change.

Never apply in the rain, when the temperature is below 5°C on two-pack (refer on TDS), or when the relative humidity is over 75%, as this could slow down drying and cause problems of dripping or surface glazing.

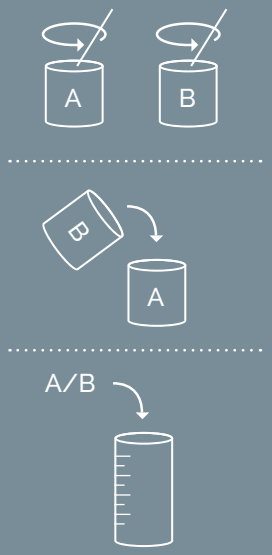
Remember to consider the temperature throughout the entire cross-linking period, especially overnight.

Never apply in full sunlight, strong winds or misty conditions. It is recommended cover the boat with tend to avoid temperature increase on the surface.

If you are unsure of the paint previously used, it may or may not be compatible with the **WOOD Line** product.
We therefore recommend painting a small test area first.
Should any problems arise (cracking, bubbles, "bleeding" or softening of the previous paint), please contact one of our experts.

To check the evenness of the product, use a WFT (wet film thickness) gauge at various points to measure the thickness of the wet paint "coat by coat" before the solvent evaporates. If the dry paint volume is 100%, the dry and wet thickness will be equal; if it is 50%, the dry thickness will be half as much.

Additional tips on the application of two-pack products



If you are using a two-pack paint, it is **important to mix the two components separately before** added **component B** (hardener) into **component A** (base) and then mixing until the colour is uniform. When you are preparing a two-pack product, consider how much you will be able to apply before it becomes unusable. Always check the pot life (for more information, see the glossary and TDS).

If you are not applying all the product, use a **graduated container (tall and narrow if possible)** for **maximum precision when measuring** the two components according to the mixing ratio.

Do not change the ratio between the base and the hardener in two-pack paints because this will alter the chemical characteristics of the product, please remember that is a stochiometric ratio.

After measuring the two components, mixing slowly (to minimise the formation of air bubbles) into **a wide, shallow container.** This helps disperse the heat that may be produced by the exothermic reaction and makes it easier to dip rollers and brushes into the product.

Substrate preparation

A good result depends not only on the characteristics of the products employed, but above all on their correct use and suitable preparation of the surfaces involved.

Don't try to save time during preparation because it is always well spent.

If the boat is not new, the operations indicated below must be completed (unless specifically indicated otherwise) before performing all the operations described in the following pages.

1. Clean the areas to treat by **washing with fresh water** (under pressure if possible).

2. **Degrease areas contaminated** with oil, grease, wax, diesel or other fuel and **rinse**. An effective way to reveal traces of contamination is to place a drop of water on the surface: if it is absorbed the surface is clean, if it remains intact degreasing is necessary.

3. If the wood is stained by water penetration, **remove all the paint** in the damaged area and **dab the wood** with hydrogen peroxide (80 volume strength) or **T-BLEACHING** until it is a light colour again.

4. **Check that the old layer of paint is firmly attached.** If it is not, remove with P180 - P240 grit sandpaper to ensure good adhesion of the product to the areas to treat. **In areas that will be bonded together, we recommend sanding in both directions** for maximum surface roughness.

5. **Make sure the wood is perfectly dry** to prevent moisture from causing rot under the plastic film and for better adhesion.

For routine maintenance

1 STAINING

1.

1.1 STAINS

Stains have a protective function. They penetrate the wood without forming a surface film or clogging the pores, and for this reason they do not flake.

If the wood on your boat is new or in good condition, with the primer still firmly attached to the substrate, and it is necessary only to apply or refresh the topcoat, we recommend **coat of stain** to **protect the surface** and ensure the adhesion of subsequent coats.

WOOD Line has developed three different types of stain to meet all specific needs.

S-PROTECT, and its odourless version **S-PROTECT AQUA**, are the one-pack stains in the line.
They penetrate the wood fibres and protect against weathering, as well as against fungal growth and moulds thanks to the fungicide substances they contain.
They are ideal for both interior and exterior use. If you want a uniform appearance or the colour tones of the finest woods, such as mahogany, walnut and teak, the stains are available in various colours.

S-PROTECT AQUA is particularly suitable for use in enclosed spaces as it is odourless.

SB-PROTECT, the two-pack stain in the line, is ideal to bring out the natural beauty of wood: clear and sealing, with excellent adhesion and high saturation, it offers the perfect protection for fine woods, which deserve to be made the most of, not covered. May also be used without applying a finish.

1.

1.2 TECHNICAL DATA SHEETS

S-PROTECT

ONE-PACK

One-pack protective stain

Coloured and clear stain. It penetrates wood and, if coloured, changes its appearance to the desired shade. The formulation provides excellent protection against weathering, fungal growth, moulds, and insects. It is recommended for both exterior and interior use on boats and for all types of wood.

TYPES OF APPLICATION


COLOURS*	0.75 L
Clear	○
Mahogany	●
Walnut	●
Teak	●

TECHNICAL SPECIFICATIONS	
Theoretical coverage	30 m²L
Number of coats	2
Thinner	6470

SB-PROTECT

TWO-PACK

Two-pack protective stain

SB-Protect is a two-pack stain for fine wood, marine plywood and MDF panels. Its penetration and sealing characteristics produce surfaces that are easy to sand and can be overcoated with one- or two-pack products, for coloured and clear finishes. This product is recommended for use mainly on new or stripped wood.

TYPES OF APPLICATION


COLOURS	1 L
Clear	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	13.3 m²L
Number of coats	5
Mixing ratio	1:1
Thinner	6780

* The tints reproduced are merely indicative

S-PROTECT AQUA

ECO-FRIENDLY

One-pack water-based protective stain

Water-based stain. Developed for interiors and for decorating and protecting structures exposed to harsh environments, including marine atmospheric conditions. It protects wood deep down, enhancing the beauty of the grain without affecting its appearance and natural breathability. Quick drying and odourless.

TYPES OF APPLICATION

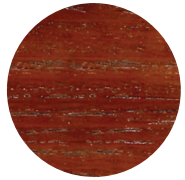

COLOURS*	0.75 L
Clear	○
Mahogany	●
Walnut	●
Teak	●

TECHNICAL SPECIFICATIONS	
Theoretical coverage	30 m²L
Number of coats	2
Thinner	Water

STAIN COLOURS*

Clear


Mahogany


Walnut


Teak

* The tints reproduced are merely indicative

1.

1.3 HOW TO APPLY THEM

Before starting work, check that the humidity of the wood is not over 18%.
If conditions permit, proceed as follows:

1. **Sand** the surface thoroughly with P120 - P180 grit sandpaper before application.

2. **Blow with clean, dehumidified, compressed air** to remove any sanding residue and dirt. The substrates must be in good condition, dry and without traces of dirt, grease, resin and old paint.

3. If the wood is already treated with stain, **de-dust and clean** the substrate.

4. **Apply** the first coat of clear or coloured stain by **brush**.

5. If the wood is very resinous, we recommend **diluting the product (15-20%)** and applying several coats, one to two hours apart, until the wood is saturated.

6. **After 24 hours, sand** with fine P320 - P400 grit sandpaper and blow with clean, dry air.

For routine maintenance

2 FINISHING

2.1 VARNISHES

2.2 TECHNICAL DATA SHEETS

2.3 HOW TO APPLY THEM

2.

2.1 VARNISHES

WOOD Line offers a wide range of clear varnishes to choose from to finish the wood on your boat, depending on your specific needs.

All **WOOD Line** varnishes form a hard, flexible film on the substrate to provide additional protection against weathering, impacts, and scratches. They seal the pores in the wood, leaving the natural grain visible and enhancing it with the gloss or matt finish.

V-SHINE and **V-MATT** are **clear alkyd varnishes** suitable for interior and exterior surfaces. The only difference is the gloss or matt finish.

These varnishes produce a film with excellent gloss, flow, flexibility, and resistance to marine environments. With their special UV additives and premium appearance, they are **recommended for varnishing all types of wood above the waterline, the surfaces of fine wood furnishings** or on aged one-pack varnish.

The water-based versions, **V-SHINE AQUA** and **V-MATT AQUA,** have the same properties as the solvent-based products described above but are odourless. These features make them ideal for interior decoration and poorly ventilated areas.

VB-SHINE is a clear, two-pack polyurethane varnish that has higher resistance to weathering than traditional flatting and is therefore **more durable**. With high resistance to marine environments, it **is non-yellowing and particularly suitable for treating wood bulkheads and surfaces that are not continuously immersed**. It is also excellent for wood decking and planking.

The water-based versions, **VB-SHINE AQUA** and **VB-MATT AQUA,** have the same properties as the solvent-based products described above, but are odourless and eco-friendly. These features mean they are particularly recommended for the treatment of furniture and all interior wood surfaces.

The two-pack High Performance varnishes (**VB-SHINE HP** and **VB-MATT HP**) are acrylic formulations designed to meet durability requirements in boat operating conditions. They protect the substrate from UV rays and weathering, producing an excellent aesthetic effect.
Excellent technical characteristics, including gloss, flow, and non-yellowing properties, combined with easy application, mean they can be used on any type of boat. **Their use is recommended when high performance is required.**

2.

2.2 TECHNICAL DATA SHEETS

V-SHINE

One-pack gloss varnish

ONE-PACK

Clear varnish with excellent resistance to weathering, high gloss, elasticity, and filling power. The new formula offers high resistance to UV rays. Easy to apply, it retains its elasticity and transparency over time. Acts as an outstanding finish for all types of both interior and exterior wood surface.

TYPES OF APPLICATION	COLOURS*	0.75 L	2.5 L
	Clear	○	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	18 m²L
Number of coats	5
Thinner	6470

V-MATT

One-pack matt varnish

ONE-PACK

This one-pack urethane varnish with special UV additives and premium appearance is widely used on all fine wood surfaces for interior and exterior boat furnishings.

TYPES OF APPLICATION	COLOURS*	0.75 L	2.5 L
	Clear	○	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	15 m²L
Number of coats	5
Thinner	6470

V-SHINE AQUA

Water-based one-pack gloss varnish

ECO-FRIENDLY

One-pack gloss alkyd varnish featuring high surface hardness and resistance in outdoor environments. Totally odourless and non-blocking, it has excellent hiding power and stands out for outstanding flexibility and flow.

TYPES OF APPLICATION	COLOURS	0.75 L	2.5 L
	Clear	○	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	10 m²L
Number of coats	5
Thinner	Water

V-MATT AQUA

Water-based one-pack matt varnish

ECO-FRIENDLY

Water-based one-pack varnish developed specifically for decorating and protecting bare wood structures exposed to aggressive conditions, including marine environments. Easy to apply and quick drying, with a matt finish and a velvety feel. Good workability, flow, flexibility and resistance to blocking and weathering. Also ideal in closed environments because odourless.

TYPES OF APPLICATION	COLOURS	0.75 L	2.5 L
	Clear	○	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	10 m²L
Number of coats	5
Thinner	Water

VB-SHINE

Two-pack gloss varnish

TWO-PACK

Two-pack clear varnish with excellent gloss retention, based on polyurethane resins. With excellent technical characteristics, including flexibility and mechanical resistance, it can be used both on wood and other suitably prepared substrates and in harsh operating conditions.
It is recommended for use in highly stressed areas like handrails and gunwales because of its excellent resistance to abrasion.

TYPES OF APPLICATION	COLOURS	0.75 L
	Clear	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	9 m²L
Number of coats	5
Mixing ratio	2:1
Thinner	6700

VB-SHINE HP

Two-pack HP gloss varnish

VB-Shine HP is a two-pack clear acrylic varnish developed to meet durability requirements in boat operating conditions. Protects the substrate from UV rays and weathering, producing an excellent aesthetic effect. Its excellent technical characteristics, including gloss, flow and non-yellowing properties, combined with easy application, mean it can be used on any wood surface. Its use is recommended when a clear finish with excellent properties is required. Its extremely clear appearance makes retouching easier by minimising the lens effect on shaded areas.

TYPES OF APPLICATION	COLOURS	1.5 L
	Clear	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	10 m²L
Number of coats	3
Mixing ratio	2:1
Thinner	6700

VB-MATT HP

Two-pack HP matt varnish

VB-Matt HP is a two-pack acrylic clear varnish with high opacity and resistance to scratching. Provides excellent protection from UV rays and weathering, producing an excellent aesthetic effect. Its use is recommended when a finish with excellent protection properties is required.

TYPES OF APPLICATION	COLOURS	1.5 L
	Clear	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	11 m²L
Number of coats	3
Mixing ratio	2:1
Thinner	6700

VB-SHINE AQUA

Water-based two-pack gloss varnish

This water-based two-pack polyurethane varnish is clear, glossy and non-yellowing.
Excellent flow and resistance to abrasion and chemicals, easy to apply. With high resistance to marine environments, it is particularly suitable for treating interior and exterior wood surfaces.
Also excellent for wood decking and planking.
Not suitable for continuously immersed surfaces.

TYPES OF APPLICATION	COLOURS	1 L
	Clear	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	12 m²L
Number of coats	5
Mixing ratio	5:1
Thinner	Water

VB-MATT AQUA

Water-based two-pack matt varnish

This water-based two-pack polyurethane varnish is clear, matt and non-yellowing. Excellent flow and resistance to abrasion, easy to apply. With high resistance to marine environments, it is particularly suitable for treating bulkheads, furniture and all interior wood surfaces. Also excellent for wood decking and planking. Not suitable for continuously immersed surfaces.

TYPES OF APPLICATION	COLOURS	1 L
	Clear	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	12 m²L
Number of coats	5
Mixing ratio	5:1
Thinner	Water

2.

2.3 HOW TO APPLY THEM

Before starting work, check that the wood to treat is dry and clean and that its humidity is not over 18%. If conditions permit, proceed as follows:

1. **Sand** the surface thoroughly with P220 – P320 grit sandpaper.

2. Before applying the varnish, use **clean, dehumidified, compressed air** to remove any traces of dirt or sanding residues. The substrate must be in good condition, dry and without traces of dirt, grease, resin and old paint.

3. **Apply** the first coats of varnish diluted by 15 - 20%.

4. If the wood is very resinous, we recommend **diluting the product (15 - 20%)** and applying several coats, one to two hours apart, until the wood is saturated.

5. **After 24 hours, sand** with fine P320 - P400 grit sandpaper and blow with clean, dry air.

EXPERT TIPS

- For the best results, we recommend **applying at least 6-8 coats**, with light sanding between each using P360 - P400 grit sandpaper, to obtain **a perfectly smooth mirror finish**.
- The number of coats of product to apply varies depending on the absorption of the wood.
  On premium hulls, we recommend **up to 16 coats** of varnish for maximum beauty and durability.
  In general, it is preferable to apply multiple thin coats rather than a few thick coats in order to obtain a flexible surface and ensure good adhesion. Use a **paint thickness gauge** to check the applied thickness of the wet varnish.
- For small surfaces, we recommend using a high-quality brush, while for large surfaces we suggest polyurethane foam rollers for speed and a clean job without dripping and trapped air. Use the roller with crisscross movements to create a uniform film.

For unscheduled maintenance

3 PROTECTION AND SPECIAL WORK

3.

3.1 RESIN AND ADDITIVES

Wooden boats are under constant attack from moisture, ultraviolet rays, and marine vegetation, which create the ideal situation to cause deterioration, helped at times by insufficient maintenance.

This leads to a deterioration in the original properties of the wood, which in some cases can affect the reliability of the boat.

When called for by the situation, it is therefore advisable to apply a protective coating with **RESINA 3+**.

RESINA 3+ is a solvent-free two-pack epoxy resin with excellent penetrating power. Its high flexibility, adhesion and surface hardness give it excellent resistance to fresh and salt water.

RESINA 3+ offers multiple benefits:

- it forms a barrier against moisture and oxygen, i.e., the agents that cause wood to deteriorate;
- it creates the ideal base for overcoating;
- it produces a particularly flexible and calibrated film that accompanies the natural movements of the wood.

RESINA 3+ contains no solvents so it can be used in both solvent- and water-based systems, as long as they are two-pack products.

RESINA 3+ can also be mixed with **R-FIBERS**, **R-SPHERES** and **R-SILICIES** **additives to form the ideal "Epoxy System" for special maintenance work.**

R-FIBERS are synthetic microfibers that when mixed with RESINA 3+ strengthen its structure **by creating a multidirectional internal structure.** Due to their low absorbency, **R-FIBERS** do not affect the penetrating power of RESINA 3+.

R-SPHERES are hollow glass microspheres with low moisture absorbency. They are used as an additive for RESINA 3+ to obtain a range of low specific weight fillers that are easy to sand, ideal for **repairing horizontal cracks and small surface defects, and as knifing fillers**.

R-SILICIES is a **thickening additive ideal for bonding, jointing and repairing major defects**. When mixed with other additives in the system (R-FIBERS and R-SPHERES), it improves knife application and the appearance of the product.

EXPERT TIPS

The consistency of the mixture obtained by combining **RESINA 3+** and its additives varies according to your requirements and the resulting mixing ratio by volume.

- For a fluid mixture use 2 parts **RESINA 3+** (with hardener) and 1 part additive;
- For a semi-fluid mixture use 1 part **RESINA 3+** (with hardener) and 1 part additive;
- For a structural mixture use 1 part **RESINA 3+** (with hardener) and 2-3 parts additive.

In this last case, the resulting mixture is easy to sand and sufficiently thick for vertical application without the risk of dripping.

3.

3.2 TECHNICAL DATA SHEETS

RESINA 3+

TWO-PACK

Protective barrier system for wood

This solvent-free structural epoxy system is designed for use in the construction, protection and restoration of wood, GRP and many other substrates. **RESINA 3+** is a technologically advanced system offering excellent penetration, flexibility and adhesion, making it essential for maintaining and treating wood. Wood treated with **RESINA 3+** is sealed and strengthened, while maintaining its characteristics of flexibility and resistance. With **RESINA 3+**, it is possible to obtain high strength wood-to-wood joints, protect surfaces and seal hulls. After adding the hardener, special additives can be mixed in to obtain fillers that are easy to apply and extremely strong.

TYPES OF APPLICATION	COLOURS	0.75 L	1.5 L	15 L
	Clear	○	○	○

TECHNICAL SPECIFICATIONS	
Theoretical coverage	10 m²L
Number of coats	2
Mixing ratio	2:1
Thinner	6610 only for cleaning

R-FIBERS

ONE-PACK

Synthetic microfibers for **RESINA 3+**

Synthetic microfibers in the range of additives to use with **RESINA 3+** to produce compounds with different properties. They have an average length of 500 microns and when mixed with **RESINA 3+** create a strong compound with a multidirectional internal structure. Due to their low absorbency, the penetrating power of **RESINA 3+** is not affected. They can be used for bonding T-joints, where a filler with high viscosity and mechanical resistance is required.

TYPES OF APPLICATION	COLOURS*	0.75 L
	White	○

TECHNICAL SPECIFICATIONS	
Thinner	6610 only for cleaning

* The tints reproduced are merely indicative

R-SPHERES

ONE-PACK

Hollow glass microspheres for **RESINA 3+**

Microspheres in the range of additives to use with **RESINA 3+** to produce compounds with different properties. They have low moisture absorbency and can therefore be used for applications both above and below the waterline. Ideal for repairing horizontal cracks, small surface defects and as knifing fillers. They are designed to produce a range of low specific weight fillers that are easy to sand and have a consistency that can be varied according to the needs of the operator.

TYPES OF APPLICATION	COLOURS*	0.75 L
	White	○

TECHNICAL SPECIFICATIONS	
Thinner	6610 only for cleaning

R-SILICIES

ONE-PACK

Colloidal microsilica for **RESINA 3+**

Thickening additive in the range for use with **RESINA 3+** to produce compounds with different properties. Ideal for bonding, jointing and repairing major defects. Can be used in applications both above and below the waterline. Can be mixed with other additives in the system to improve knife application and the appearance of the end product.

TYPES OF APPLICATION	COLOURS*	0.75 L
	White	○

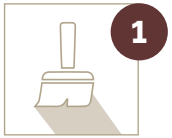
TECHNICAL SPECIFICATIONS	
Thinner	6610 only for cleaning

* The tints reproduced are merely indicative

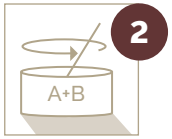
3.

3.3 HOW TO APPLY IT FOR PROTECTION

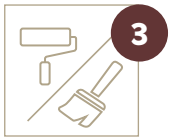
Immediately after surface preparation (see page 9), proceed as follows:



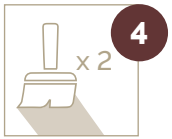
Apply a coat of **SB-PROTECT** stain which penetrates deep into the wood fibres and creates an excellent base for the application of **RESINA 3+**.
When crosslinking is complete, sand with P180 grit sandpaper and remove the residues.



Prepare **RESINA 3+ by mixing** the base and hardener.
It is essential to **mix component A and component B** in a volume ratio of exactly 2:1.



Apply RESINA 3+ by **brush** or **roller**, both of which are possible thanks to the product's fluidity and flow.

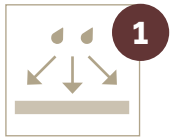


Apply at least **2 coats** of **RESINA 3+** for adequate protection. The theoretical coverage per coat is about 10 m^2/L and the applied thickness per coat about 100 microns.
3 coats obtain a thickness of 300 microns, which is the indispensable minimum for surfaces under the waterline.
The amount required for the first coat is usually more than for subsequent coats.

3.4 HOW TO APPLY IT FOR LAMINATION

Lamination is the construction of a structure or the covering of existing parts using reinforcement fabrics, such as GPR, carbon fiber or Kevlar® mats, impregnated with **RESINA 3+**.

Proceed as follows:



Evenly cover the area to treat with mixed **RESINA 3+** using a roller or brush.

Lay out the fabric, which will easily stick to the surfaces to cover. Use a mat that is slightly larger than the area to cover. On large surfaces, plan for overlaps of a few centimetres where the mats join.

Impregnate with more resin using rollers. The use of a **bubble buster roller** is often advised to eliminate folds and trapped air. Adhesion may not be optimal in areas with sharp corners, which must first be rounded off. An oval brush may be useful in points that are hard to reach. Use a spatula or roller to remove excess resin.

When the resin has hardened, use a **cutter to remove any overhang**.

3.

3.5 HOW TO APPLY IT FOR BONDING

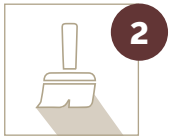
The **WOOD Line** epoxy system, consisting of **RESINA 3+** and its additives, ensures simple, fast, and strong bonding between different materials.

For bonding, **RESINA 3+** must be thickened with:

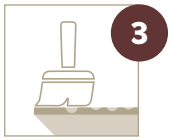
- **R-FIBERS** for constructions requiring greater strength;
- **R-SILICIES** where strength and sandability are needed.

Bonding must be performed as follows:

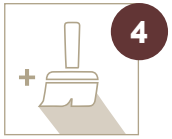
Clean and sand the parts to treat to roughen them.



Impregnate with **RESINA 3+** and hardener, but no additives, using a **brush**. This ensures that the resin penetrates deep into the fibres, guaranteeing better results. Otherwise, the wood tends to absorb the liquid part of the mix, removing resin from the bonding mixture and resulting in a more fragile bond.



Thicken the resin with the chosen additive (R-FIBERS or R-SILICIES) and **apply, filling any irregularities** in the joint.



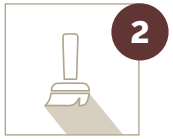
Apply another coat of RESINA 3+ to seal the bonding area and surrounding wood. Then apply the finish (see page 19).

3.6 HOW TO APPLY IT FOR PLASTERING

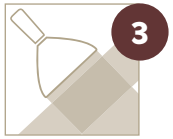
Plastering is required to **repair defects or damage** due to ageing or accidents. Using the **WOOD Line** epoxy system simplifies work. The filler consisting of **RESINA 3+** and its additives is solvent-free and does not shrink during crosslinking. The use of **R-SPHERES** to plaster large surfaces also creates a barrier against sound and heat.

Proceed as follows:

Clean the area to treat and eliminate any unevenness.



Impregnate the surface with RESINA 3+ and hardener, but no additives, using **short-bristle brushes** for small areas.



Add the appropriate quantity of **R-SPHERES** to the resin and hardener, depending on the desired thickness. **Apply the plaster in crisscross coats** using suitably sized **spatulas** or sticks.
The maximum recommended thickness per coat is 10 mm.
For greater thicknesses apply several coats of plaster.
We recommend crisscrossing the coats at 90 degrees.

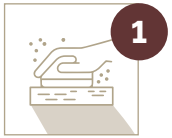
3.

3.7 HOW TO APPLY IT FOR CORNER JOINTS

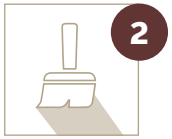
Corner joints are commonly called T-joints and are **often used to strengthen the bond between frame and planking or between topside and deck**, or simply to attach a shelf or fixture.

This type of work ensures strength and a **good aesthetic appearance**.
It involves the bonding of two perpendicular parts, guaranteeing strength and increasing the load-bearing contact surface.

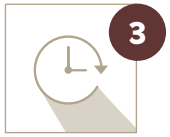
Proceed as follows:



Sand the parts to treat.



Impregnate with RESINA 3+ and hardener, without additives, using a brush.

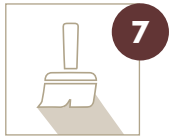


Wait for the resin to penetrate and become sticky and then **apply more RESINA 3+ to the joint area,** thickened with an appropriate quantity of **R-SILICIES** (resin/additive ratio of about 1:2 by volume).

Attach the parts to join and apply more material along the joint.
It is not usually necessary to exert a lot of pressure on the pieces to join.

Remove the excess mixture with a spatula to avoid sanding problems.

For a better aesthetic result, improved sandability and a smoother finish, apply a coat of resin thickened with **R-SPHERES. Shape** with a **round-tip spatula** or a template made with the same radius as the desired joint.



Re-coat if necessary, with a suitable finish (see pages 54-55).

3.

3.8 HOW TO APPLY IT TO REPAIR ACCESSORIES

The mixture of **RESINA 3+** with its additives can be used **to attach deck equipment,** which can either be bonded or securely attached to the substrate by bonding the screws.

To do this, impregnate the screw hole with the mixture of resin and hardener. This plasticises the material and the **RESINA 3+** provides increased strength for the threading.

The resin thickened with **R-FIBERS** can also be used to reconstruct deteriorated threads. For easier dismantling of equipment fixed with screws and **RESINA 3+**, lubricate the screws with wax, release spray or grease before use to prevent the resin from blocking them.

This procedure is frequently used to reconstruct torn stanchion mountings or to attach on-board equipment.

The use of resin also seals accessory mounting points against water infiltration.

EXPERT TIPS

- The recommended amounts of additive to mix with **RESINA 3+** are indicative and can be adjusted to obtain a mixture tailored to your needs. Do not exceed the maximum recommended value as this may lead to loss of adhesion or increased fragility.
- Never use additives in the first coat because they reduce the penetrating power of the resin.

3.9 HOW TO APPLY IT FOR FINISHING

RESINA 3+ is not a finish! As surfaces treated with **RESINA 3+** are particularly smooth and glossy, a final varnish may be thought unnecessary. However, ageing and weathering affect the epoxy resin film and deteriorate its appearance.

For a durable gloss, the final stage in the system needs to be a two-pack varnish in the WOOD Line range. For a complete description of finishing systems, see pages 54-55.

Making fine wood shine

4 TEAK CARE

4.

4.1 PRODUCTS

The teak parts of the boat need meticulous, regular care.
To maintain their natural beauty, which is put to the test by constant exposure to sunlight and salt water, regular care is recommended, once or twice a year and with products designed specifically for maintaining teak.
These beauty treatments must be performed with products that bring out all the natural properties of teak.

We therefore advise against using traditional varnishes on teak surfaces.
Exotic woods contain substances that if released later could cause problems such as peeling, staining or blistering, as well as creating a dangerous slippery surface in the presence of water. We therefore recommend choosing products designed specifically for this purpose, as you would for yourself.

For this reason, Veneziani has created three products designed for teak, but which can in any case be used on various fine woods such as mahogany, iroko or others of tropical origin.

T-PROTECTIVE is an oil for teak with excellent sealing and protective properties. It penetrates deep into the wood fibres, restoring the oil balance and enhancing the grain, impregnating the wood and making it more difficult for dirt to penetrate. **T-PROTECTIVE brings out the natural colouring of the teak** and gives the surface a silky appearance and a soft feel.

For routine maintenance, wash the surface with **T-DETERGENT**, which is formulated to remove all forms of contamination, from salt deposits to oils and grease. The PH of **T-DETERGENT** is only slightly alkaline, making it both effective and gentle on the teak, removing the dirt but leaving the "oily" content of the wood unharmed.

For a more radical intervention, use **T-BLEACHING**. This product has the power of a **bleaching agent capable of restoring the natural colour of teak** by eliminating the oxidation due to prolonged exposure to sunlight and salt spray.

4.

4.2 TECHNICAL DATA SHEETS

T-PROTECTIVE

Protective stain for teak

As well as impregnating the wood and so reducing dirt penetration, T-Protective restores its natural oil content. It also enhances the natural colour of wood and makes surfaces softer to touch.

TYPES OF APPLICATION	COLOURS	1 L	2.5 L
	Clear	○	○

TECHNICAL SPECIFICATIONS	
Thinner	6470 only for cleaning

T-DETERGENT

Detergent and stain remover for teak

T-Detergent removes all kinds of contaminations from wood. The pH of Teak 1 is only slightly alkaline, making it both effective and gentle on the teak, removing the dirt but leaving the “oily” content of the wood unharmed.

TYPES OF APPLICATION	COLOURS	1 L
	Clear	○

T-BLEACHING

Bleaching agent for teak

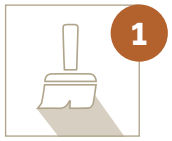
Sunlight, salt and pollution affect the original appearance of teak and its exotic appeal, resulting in a greyish colour. With T-Bleaching the wood regains its original colour.

TYPES OF APPLICATION	COLOURS	1 L
	Clear	○

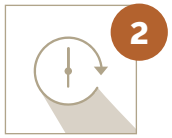
4.

4.3 HOW TO APPLY THEM FOR REGULAR CARE

Proceed as follows:



1. **Apply T-PROTECTIVE** on clean, dry teak with a **soft brush,** working with the grain.



2. If the wood is particularly dry, you may see that the first coat is absorbed immediately. In this case, **repeat the application** several times, **leaving at least 30 minutes** between applications.

3. **Remove** the excess material **with a soft cloth**.

4.4 HOW TO APPLY THEM FOR DEEP CLEANING

For deeper cleaning, proceed as follows:

1. **Clean, de-dust and wet** the teak with fresh water.

2. Use a cloth to evenly apply **T-DETERGENT** diluted with 3 or more parts of water.

3. Leave in place for a few seconds and then **scrub vigorously** in the direction of the grain using **a soft brush** or a **sponge** until a dark colour is obtained. Avoid the use of metal brushes, which may leave residues that stain or damage the wood due to oxidation.

4. **Rinse** thoroughly with fresh water.

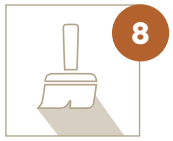
4.

4.4 HOW TO APPLY THEM FOR DEEP CLEANING

If the teak needs to be bleached after cleaning, or to eliminate the grey-blackish colour due to ageing, **apply T-BLEACHING evenly** across the entire surface with a **soft brush** or a **sponge** while the wood is still wet with fresh water.

Leave in place for a few minutes and then **scrub with a sorghum or nylon broom** to increase the product's detergent/bleaching action until a yellow-gold colour is obtained.

Rinse thoroughly with fresh water and let dry. If the stains are difficult to remove, repeat the process.



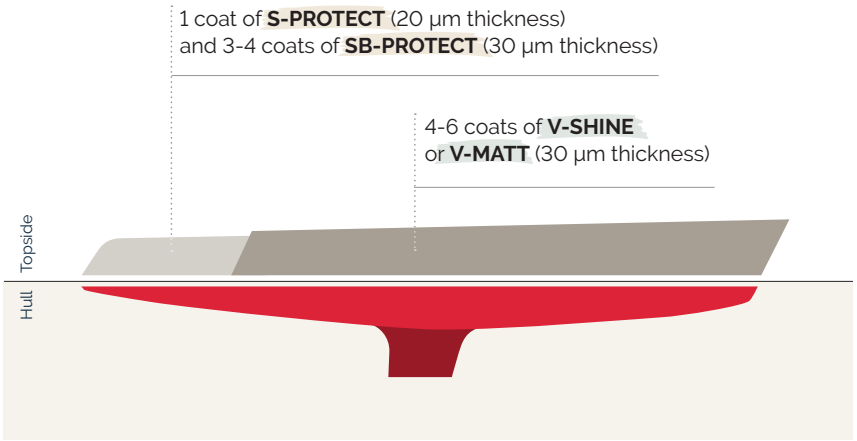
Apply T-PROTECTIVE as described above.

Do not apply in direct sunlight.

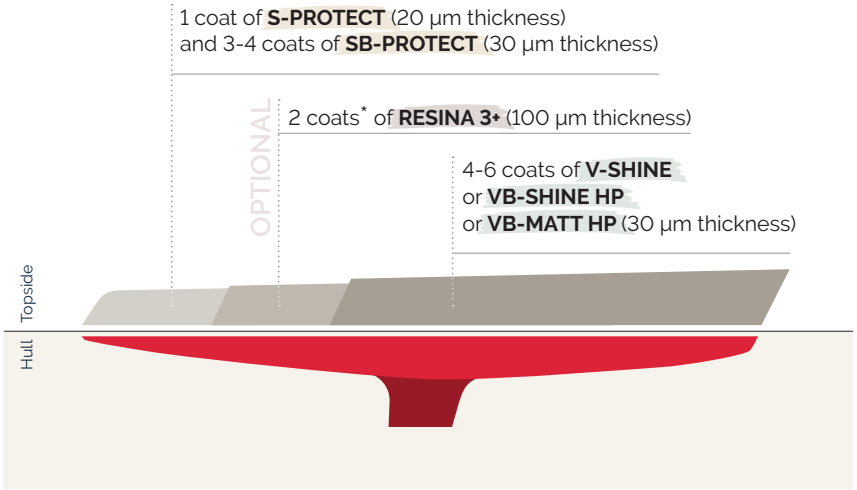
Paint systems

SOLVENT-BASED SYSTEM FOR EXPOSED WOOD

ONE-PACK SYSTEM



TWO-PACK SYSTEM

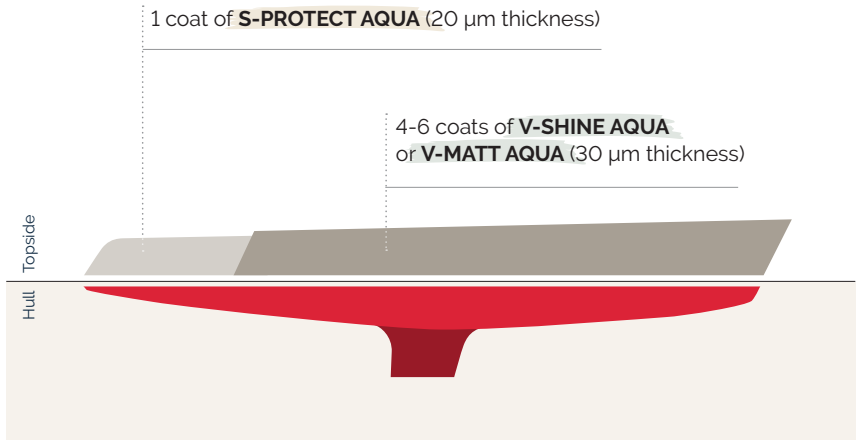


The thickness indicated refers to one coat.

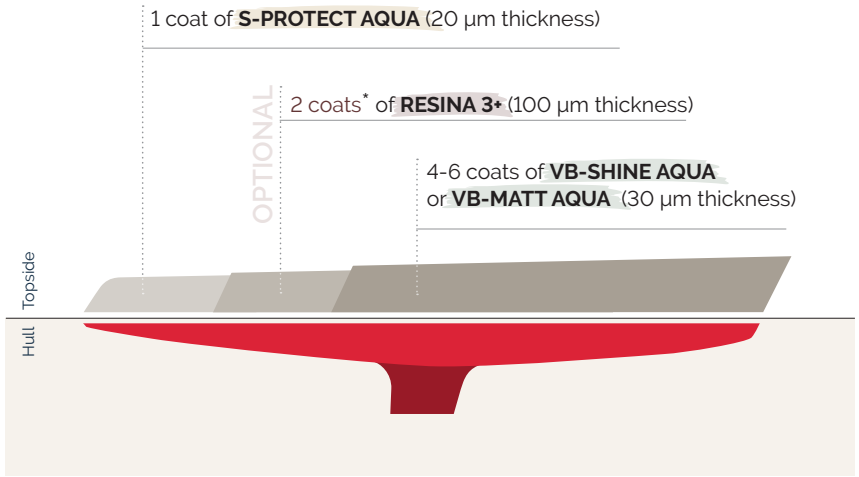
* **Optional step**, recommended for better sealing and protection.

WATER-BASED SYSTEM FOR EXPOSED WOOD

ONE-PACK SYSTEM



TWO-PACK SYSTEM



The thickness indicated refers to one coat.

* **Optional step**, recommended for better sealing and protection.

Glossary

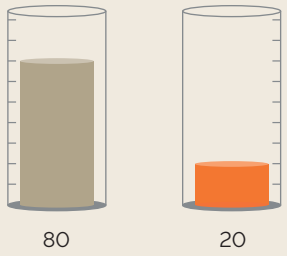
Drying

There are two stages in the paint drying process, based on solvent evaporation and/or the degree of cross-linking. These stages correspond to the "dust free" and "touch dry" values. A product is "dust-free" dry when airborne dust particles will not adhere to the surface of the film. A product is "touch" dry when it can be handled without leaving marks on the film. The paint only achieves its maximum performance when the drying time has completely elapsed (drying time before use). **Always comply with the recoat times given in the technical data sheets.**

Mixing ratio

This is the ratio of base (component A) **to hardener** (component B) **for two-pack products**. The mixing ratio is reported both by weight and volume in the technical datasheet for each product. **Pay careful attention to this information because the ratio is mandatory and must not be changed**. Remember that using more hardener not only doesn't make the paint dry faster, but also affects its properties and quality.

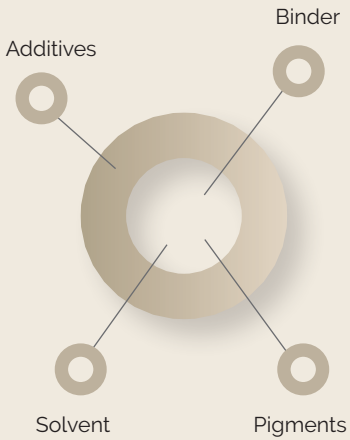
Mixing ratio



Specific weight

This can be defined simply as the weight of one litre of the product and is expressed in kg/L. Normally, the binder and solvents in a paint have a specific weight equal to or less than one (i.e. they weigh the same as water or slightly less). Pigments, however, are heavier and some (copper or zinc compounds, for example) have a specific weight of over five. For this reason, products that have a high pigment or metal content tend to separate out. That is why cans of antifouling are so heavy and why the pigments tend to settle on the bottom of the can, a problem that can be mitigated by using special additives.

Dry film

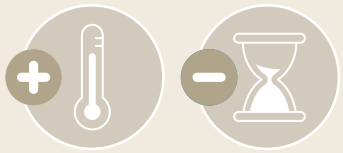


Pot Life

This is the time during which you can apply the A+B mixture (base+hardener) of a two-pack product after mixing. When this time has elapsed, the mixture sets and can no longer be applied. Any attempt to thin the product is pointless and dangerous, because it alters a chemical reaction already in progress. The pot life given in the technical instructions refers to 200 g of product measured at 20°C. Please bear in mind that pot life is inversely proportional to temperature, meaning that it increases at lower temperatures and decreases at higher temperatures. For example, if the pot life of a product is one hour at 25°C, at 30°C it may be only 30 minutes.

Pot life

Temperature is inversely proportional to time.



Theoretical and effective coverage

The coverage indicated in the technical data sheets refers to the theoretical value for the product, which can be calculated using a simple formula. When applying a paint, the surface actually covered is less than that indicated by the theoretical coverage, since there is always some loss of material. The amount of the loss depends on the condition of the surface, the type of products used, the atmospheric conditions and the method of application.

The percentage of product lost because of the first factors is impossible to estimate in advance, while the loss percentages relating to typical methods of applicationare as indicated in the table below.

Loss percentage

% Product loss	Loss factor
10%	0.9
15%	0.85
20%	0.8
25%	0.75
30%	0.7

In order to obtain the practical coverage, the theoretical coverage must be multiplied by the loss factor. When purchasing products, the surface area to paint (in square metres) is required to calculate the correct amount to order from the retailer based on the technical data sheets.

Theoretical coverage formula

$$\text{Theoretical coverage } (m^2/L) = \frac{\%\ SV \times 10}{\text{Thickness } (\mu m)}$$

WOOD LINE

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