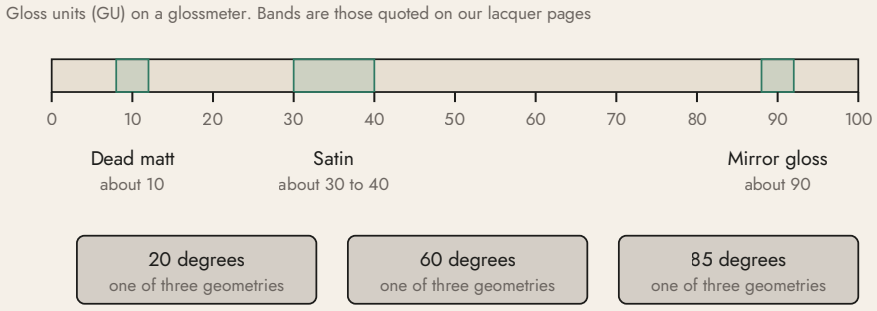
Lacquer *sheen* levels and spray finish specification

A gloss-unit scale from dead matt to mirror, the three ISO 2813 angles, and a sample you can sign and keep. No tolerance for decorative lacquer was found: that is for the spray shop to propose.

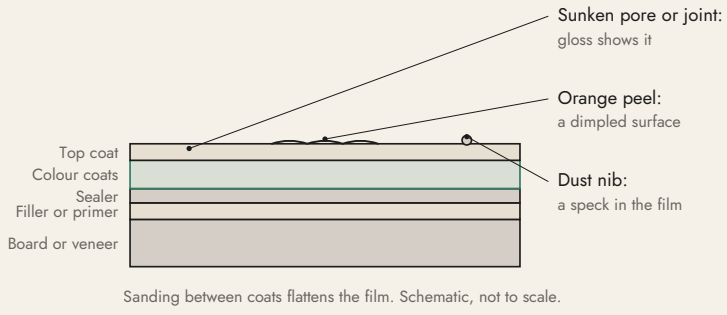
AT A GLANCE

Sheen	Gloss figure	How it looks and behaves	Build	Repair
Dead matt	About 10 (our lacquer pages)	Soft, fingerprint-forgiving, almost chalky (our pages)	One to two coats after sealing (our pages)	Forgiving: easier to blend a repair
Satin	About 30 to 40 (our pages)	The working choice for cabinet joinery (our pages)	Three to four coats for satin or semi-gloss (our pages)	Forgiving: easier to blend a repair
High gloss	Up to about 90 (our pages)	Shows every flaw and every joint (Wood Handbook)	Three to five coats, flat-sanded, machine polished (our pages)	A local repair shows; a panel is often re-sprayed
Matt inside, gloss outside	Your own pairing	Same colour in a calmer sheen inside a cabinet (our journal)	As each finish	Match the matt to the gloss on a sample

Bands, coats and repair notes are what our own lacquer pages say; no standard defines the words. Gloss figures are working bands, not tolerances.



A gloss-unit scale with the working bands our lacquer pages quote, and the three geometries named in ISO 2813. Original drawing by Make Bespoke Studio.



Layers of a sprayed lacquer finish and where three faults show. Schematic, not to scale. Original drawing by Make Bespoke Studio.

SPECIFICATION WORDING

SHEEN

[Two-pack polyurethane] lacquer to [element], colour [RAL / NCS ref] to approved sample [ref], gloss [30 to 40] GU (+/- [ ] GU) measured with a glossmeter at [60] degrees to BS EN ISO 2813 [confirm current edition] on a flat area away from edges, mean of [3] readings recorded on the sample. Sheen to the interior of [units]: [ ] GU, colour as exterior.

SURFACE QUALITY

Surface to be free of sunken pores or joints, orange peel, runs, dust nibs and telegraphed sanding marks when viewed in [normal light] at [1] m and in raking light at [ ] m. Substrate [MDF / veneered board / solid timber] to be sealed and filled so that pores and joints are not visible. Edges to [radius ref].

CONTROL SAMPLE

One sample per colour and sheen, [305 x 305] mm on the production substrate, sprayed by the production spray shop, to be submitted and approved under project lighting before production. The approved sample, with its colour reference and GU reading, is retained as the control for production and for repairs, and is recorded in the O&M manual.

TERMS USED

Gloss unit (GU)

The unit a glossmeter reads for specular reflection at a stated angle; a specification should give the figure, the angle and the standard.

Geometry (gloss angle)

The angle of the glossmeter's light: ISO 2813 defines 20, 60 and 85 degrees (BSI listing).

Control sample

The approved sample against which production, and any later repair, is judged for colour, texture and sheen (Architectural Woodwork Standards 1.2.12.2.2).

Telegraphing

Marks in a lower coat, such as sanding scratches, that show through the top coat (AWS 1.2.7).

STANDARDS AND SOURCES

- BS EN ISO 2813:2014 Paints and varnishes. Determination of gloss value at 20 degrees, 60 degrees and 85 degrees: BSI Knowledge listing: current, 31 Oct 2014. Standard text not read. The 2000 edition was withdrawn 31 Oct 2014.
- BS EN 13722:2004 Furniture. Assessment of the surface gloss: shop listing only: shown as current, scope not seen. Confirm before citing.
- Architectural Woodwork Standards, 1st edition (2009), Section 5: 1.2.7, 1.2.12.2.2, 4.1.1.3, 4.1.2. US; free section PDFs; grade rules excluded.
- USDA Forest Products Laboratory, Wood Handbook FPL-GTR-282 (2021): pp. 10-16, 16-2, 16-29, 16-30.

Full guide: https://makebespoke.com/trade/technical/lacquer-sheen-levels-and-spray-finish-specification. Make Bespoke Studio coordinates manufacture through its partner workshops. Figures are guidance only and your specification governs; some may be superseded, so contact the studio to verify.