

Bluefin Pigmolux Filler

3320

Water-based, UV-curing furniture primer for industrial use

PRODUCT DESCRIPTION

General

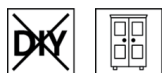
Water-based, UV-curing 1C spray filler with very good filling performance and sandability, as well as rapid development of hardness. Can be applied directly onto MDF boards (see Condition of the substrate).

Special properties and standards



- **EN 13501-1 (fire behaviour)**
In combination with a hardly inflammable surface, e.g. materials of fire class A1 or A2: classification as B-s2,d0. The complete coating system (carrier board / glue / veneer or foil) is always used to classify the reaction to fire.
- **French ordinance DEVL1104875A**
Marking of construction coating products for their emission of volatile pollutants: A+

Application area



UV-curing 1C primer with good filling performance for surfaces to be coated with pigmented paint in furniture and interior finishing.

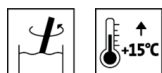
Application in combination with a suitable topcoat system.

Bluefin Pigmolux Filler (3320) can be used as a primer for water-based pigmented coatings such as Pigmolux and Bluefin Pigmocryl NG in various qualities.

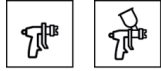
Not suitable for wood species with water-soluble colouring wood extractives, such as oak or ash.

PROCESSING

Processing instructions



- Please stir the product before use.
- The temperature of the product and object, and the room temperature must be at least + 15 °C.
- When using plastic edgebands, an adhesion test must always be carried out with the planned structure. Adhesion can be improved on ABS edgebands by using ABS Kantenaktivator (8315000210).
- Any change in the processing sequence, environmental conditions, non-observance of instructions or the use of products not listed may have an unfavourable effect on the result.
- Please follow our **ARL 150 - Working guidelines for water-based furniture coatings**.

Application technique

	Airless	Airless air-supported (Airmix®, Aircoat, etc.)	Cup gun
Spraying nozzle Ø (mm)	0,28 - 0,33		2,0 - 2,2
Spraying pressure (bar)	100 - 120	70 - 100	ca. 2 - 3
Vaporizer Air (bar)	-	1 - 2	-
Viscosity 6-mm-cup (s)	65		
Applied quantity per application (g/m²)	ca. 150 - 200		
Total quantity applied (g/m²)	max. 500		

The product is ready to use.

The shape and surface condition of the workpiece as well as the type of application influence the actual consumption. Accurate values for consumption must be obtained by applying trial coats in advance.

Drying conditions**Flashing off the water:**

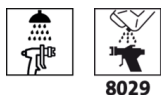
35 - 45 Minuten	belt-type pallet drier (Rising temperature up to max. + 50 °C, air speed approx. 2 m/s)
or	
15 - 20 Minuten	Flat channel dryer (Rising temperature up to max. + 50 °C, air speed approx. 2 m/s)

The mentioned system parameters are reference values, which must be coordinated with the respective plant. Drying depends, for example, on the type of wood, workpiece shape, layer thickness, temperature, air exchange, relative humidity, stacking pressure and stacking conditions.

UV curing

Feed rate 2 - 3 m/min when using one gallium lamp and 1 mercury lamp (output: 80 - 120 W/cm²)

The feed can be increased in direct proportion to the number of radiators.

Cleaning the working equipment

With water immediately after use.

To remove dried paint residues we recommend using Aqua-Cleaner (8029) (diluted 1:1 with water).

Conveyor belts and material lines: Clean-Smart B&P (8015000210)

Heavily soiled material lines: Clean-Smart Gel (8060000210)

SUBSTRATE**Type of substrate**

Solid wood, chipboard or wood fibre materials suitable for opaque varnishing, veneered or coated with priming film.

Substrate property

The substrate must be dry, clean, capable of holding the paint, free from separating substances such as grease, wax, silicone, resin etc. and free from wood dust, as well as tested for suitability for coating.

On MDF boards of good quality and a high bulk density (e.g. with 19 mm boards greater than 700 kg/m³), Bluefin Pigmolux Filler (3320) can be used

directly without pre-insulation. Panels of lower qualities must be pre-insulated before the first filler layer, e.g. with Bluefin Unistar (2965)

For sanitary applications, we generally recommend the use of moisture-resistant MDF boards of type V100. It is not recommended for use on horizontal surfaces that are frequently exposed to water, such as washstands.

Substrate preparation

Wood sanding

Hardwoods: Grit size 150 - 180

Softwoods: Grit size 100 - 150

Carrier plates coated with priming film:

Grit size 180 - 240

MDF panels:

Cleaning/smoothing sanding grit size 180 - 220

COATING SYSTEM

Primer coat

1 – 2 x Bluefin Pigmolux Filler (3320)

Intermediate sanding



Grit size 240 – 360

Avoid sanding straight through!

Remove sanding dust.

Topcoat

Pigmolux DC or Pigmolux HQ in a range of qualities and in your desired colour.

CLEANING AND MAINTENANCE

Cleaning and Maintenance

Cleaning with Clean-Möbelreiniger (7202) and care with Clean-Möbelpflege Plus (7222).

ORDERING INFORMATION

Size of trading unit

25 kg

More sizes on request.

Colour shades / Glosslevels

Bluefin Pigmolux Filler Weiß (3320050000)

Supplementary products

ABS Kantenaktivator (8315)

Aqua-Cleaner 8029 (8029)

Bluefin Unistar (2965)

Clean-Möbelpflege Plus (7222)

Clean-Möbelreiniger (7202)

Clean-Smart B&P (8015)

Clean-Smart Gel (8060)

Pigmolux various qualities

Please refer to the corresponding technical data sheets of the products.

FURTHER DETAILS

Durability / storage



Min. 6 month(s) in the original sealed containers.

Make sure the product is protected against moisture, direct sunlight, frost and high temperatures (above 30 °C).

Technical specifications

Delivery viscosity: 65 second – 70 second according to DIN 53211
(6 mm measuring cup, 20 °C)

Safety information

The product is only suitable for the industrial and professional use.

Further information on the subject of safety during transport, storage and handling as well as disposal can be found in the relevant safety data sheet. The current version can be accessed on the Internet at **www.adler-lacke.com**.

The inhalation of paint aerosols during spray application must generally be avoided. This is ensured by the proper use of a respirator (combination filter A2/P2).
