# Technical data sheet

ADLER
Paint runs through our veins.

## Bluefin Multilux Gloss 3895

Water-based, **UV-curing spray-on varnish** for **furniture surfaces**

## PRODUCT DESCRIPTION

### General

Water-based UV high-gloss topcoat with very good chemical and mechanical resistance, a high degree of transparency and very good shine. The product gives good results with wiping and polishing.

### Special properties and standards

- **ÖNORM A 1605-12 (furniture surfaces)**
  Resistance to chemical reactions: 1-B1
  Response to abrasion: 2-D (≥ 50 U)
  Response to scratches: 4-D (≥ 1.0 N)
  Flame treatment: 5-B (hardly inflammable furniture surface)
- **DIN 68861 (furniture surfaces)**
  Part 1: Response to chemical stress: 1 B
  Part 2: Response to Abrasion: 2 D (> 50 to ≤150 U)
  Part 4: Response to scratches: 4 D (> 1,0 to ≤ 1,5 N)
- **ÖNORM A 3800-1 (fire behaviour)**
  In conjunction with a flame-retardant substrate:
  flame-retardant, Q1, Tr 1
- **French ordinance DEVL1104875A**
  Marking of construction coating products for their emission of volatile pollutants: A+

### Application area

For industrial high-gloss coating of closed-pore pigmented and colourless surfaces in furniture manufacturing.

For the coating of furniture and interior finishing exposed to normal levels of stress, bedroom suite and living room furniture: application areas III to IV according to ÖNORM A 1610-12.

For hardly inflammable or flame-retardant coating systems.

## 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.
- To improve adhesion, you can add 5 % Aqua-Hardener 8451 (8451) to the product. Pot life is 4 hours.
- 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.



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- 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)** | 0,23 - 0,33 | | 1,8 |
| **Spraying pressure (bar)** | 100 - 130 | 70 - 90 | 2,5 - 3,5 |
| **Vaporizer Air (bar)** | - | 1 - 2 | - |
| **Diluent** | Water | | |
| **Applied quantity per application (g/m²)** | 100 - 120 | | |
| **Total quantity applied (g/m²)** | max. 450* | | |

*(Primer and topcoat)

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:**

| | |
|---|---|
| 30 - 45 minutes | belt-type pallet drier (Rising temperature up to max. + 50 °C, air speed approx. 2 m/s) |
| or | |
| 15 - 30 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.

Lower temperatures and/or high level of atmospheric humidity can increase the drying time.

## UV curing


Partial gelling (after the first and perhaps also the second coat, if the surface has not been sanded between coats):

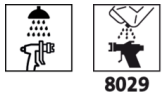
Feed rate 6 m/min / one high-performance UV mercury lamp ≤ 80 W/cm or < 700 mJ total UV-F output (e.g. VEN DRY UV Surround by Venjakob)

Curing:

Feed rate 4 - 6 m/min / two high-performance UV mercury lamps 80 - 120 W/cm

After UV curing and 12 hours of overnight drying at room temperature, the resulting surfaces are highly polishable and wipeable.

## 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).

## SUBSTRATE

**Type of substrate**

With surfaces coated with Pigmolux or Bluefin Multilux HF (3852).

## COATING SYSTEM

**Primer coat**

After the water has evaporated or the surface has dried, the surfaces coated with Pigmolux should only be partially gelled with a single gallium-doped lamp (80 W/cm², feed rate 6 m/min) in order to ensure sufficient adhesion for the high-gloss coating.

Surfaces coated with Bluefin Multilux HF (3852) should be cured as explained in the relevant technical data sheet and should be sanded using grit size 360 / 400 and all dust removed shortly before coating with Bluefin Multilux Gloss (3895).

**Topcoat**

2 – 3 x Bluefin Multilux Gloss (3895) for each 100 - 120 g/m² no intermediate sanding needed, always within 4 hours of the last application of coating material

## CLEANING AND MAINTENANCE

**Cleaning and Maintenance**

Cleaning with Clean-Möbelreiniger (7202).

## ORDERING INFORMATION

**Size of trading unit**

25 kg

**Colour shades / Glosslevels**

Bluefin Multilux Gloss G100 (3895000100)

**Supplementary products**

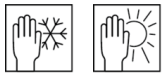
Aqua-Cleaner 8029 (8029)
Aqua-Hardener 8451 (8451)
Bluefin Multilux HF (3852)
Clean-Möbelreiniger (7202)

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: 75 second – 80 second according to DIN 53211
(6 mm measuring cup, 20 °C)

**Safety information**

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

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).

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.**