

## Bluefin Pigmolux Filler

## 3320

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

### PRODUCT DESCRIPTION

#### General

Water-based, UV-curing one-component spray filler with very good body and sanding properties as well as rapid curing development. Directly applicable to MDF panels (refer substrate condition).

#### Special properties and standards



- **DIN EN 13501-1** (fire-behavior): in combination with a hardly inflammable surface, such as materials of fire class A1 or A2.
- The complete coating system (carrier board / glue / veneer or foil, coating system) is always used to classify the reaction to fire.
- **French ordinance DEVL1104875A** regarding the marking of construction coating products for their emission of volatile pollutants: A+

#### Application area



- Full-bodied primer for opaque pigmented coating systems for furniture and interior finishing
- Bluefin Pigmolux Filler 3320 can be used as a primer for water-based pigmented coatings such as ADLER Pigmolux (various qualities).
- Not suitable for wood species with water-soluble colouring wood extractives, such as oak or ash.

### PROCESSING

#### Instructions for use



- Please stir the product before use.
- The temperature of the product and object, and the room temperature must be at least +15 °C.
- Perform adhesion test before painting plastic edges such as ABS edges.
- If plastic edges are used, an adhesion test must always be carried out with the planned coating system. When using ADLER ABS-Kantenaktivator 8315000210 an adhesion improvement can be achieved on ABS edges.
- Please follow our **ARL 150 - Working guidelines for water-based furniture coatings**.

10-20 (supersedes 09-19) ZKL 3320

ADLER-Werk Lackfabrik, A-6130 Schwaz

Phone: 0043/5242/6922-190, Fax: 0043/5242/6922-309, Mail: [technical-support@adler-lacke.com](mailto:technical-support@adler-lacke.com)

Our instructions for use are based on knowledge available currently and shall guide the buyer/user to the best of one's knowledge, but, however, must be clarified for the areas of application and processing conditions on a case-to-case basis. The buyer/user is responsible for deciding on the suitability and use of the delivered product, which is why it is recommended to produce a sample to check the suitability of the product. Our general terms and conditions of sale are otherwise applicable. All previous data sheets are rendered invalid with the issue of this one. Rights reserved for the modification of the container sizes, colour shades and degrees of gloss available.

**Application technique**

Application method	Airless	Airmix, air-supported (Airmix, Aircoat, etc.)	Cup gun
Spray nozzle (ø mm)	0.28 - 0.33	0.28 - 0.33	2.0 – 2.2
Spraying pressure (bar)	100 - 120	70 - 100	approx. 2 - 3
Atomized air (bar)	-	1 - 2	-
Viscosity (sec.): 6-mm-cup, 20 °C	65	65	65
Application-quantity per application (g/m <sup>2</sup> )	approx. 150 - 200; total quantity applied (primer and top coat) max. 500		

The shape and properties of the substrate affect the consumption/yield. Accurate values for consumption must be obtained by applying trial coats in advance.

**Drying conditions****Flashing off the water:**

35 - 45 min belt-type pallet drier (maximum temperature 50 °C)  
or  
15 - 20 min flat channel drier (maximum temperature 50 °C, air-speed approx. 2 m/s)

The figures given above are reference values, which must be coordinated with the respective facility. The drying time depends e.g. on the type of wood, coat thickness, temperature, air exchange and relative humidity.

**UV curing**

Feed rate 2 - 3 m/min when using 1 Ga-doped radiator and 1 Hg radiator 80 - 120 W/cm


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

**Cleaning equipment****the working**

With water immediately after use.

To remove dried paint residues we recommend using ADLER Aqua-Cleaner 80080 (diluted 1:1 with water).

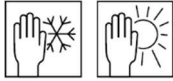
Belt cleaning with ADLER Bandreinigungslösung 80066

SUBSTRATE		
Type of substrate	Solid wood, chipboard or wood fibre materials suitable for opaque varnishing, veneered or coated with primer film; MDF panels	
Substrate property	<p>The substrate must be dry, clean, capable of holding the paint, and it must be free of grease and wax and free from wood dust.</p> <p>ADLER Bluefin Pigmolux Filler 3320 can be used directly on MDF boards of good quality and with a high moulded density (e.g. on 19-mm boards greater than 700 kg/m³) without pre-insulation. Panels of lower qualities must be pre-insulated before the first layer of filler (e.g. with Bluefin Unistar 2965).</p> <p>For sanitary applications, we generally recommend the use of moisture-resistant MDF panels of type V100. It is not recommended for use on horizontal surfaces that are frequently exposed to water, such as washstands.</p> <p>Please refer to the corresponding technical data sheets of the products.</p>	
Preparation of the substrate	<ul style="list-style-type: none"><li>• <b>Hardwoods:</b> wood sanding with grit size 150 - 180</li><li>• <b>Softwoods:</b> wood sanding with grit size 100 - 150</li><li>• <b>Carrier plates coated with priming film:</b> film sanding with grit size 180 - 220</li><li>• <b>MDF panels:</b> cleaning / smooth sanding with grit size 180 - 220</li></ul>	
COATING SYSTEM		
Primer	1 - 2 x Bluefin Pigmolux Filler	
Intermediate sanding	Grit size 240 - 360 Avoid sanding straight through!	
		
Topcoat	ADLER Pigmolux DC or ADLER Pigmolux HQ (various qualities) in the required colour.  Please refer to the corresponding technical data sheets of the products.	
ORDERING INFORMATION		
Size of trading unit	25 kg More sizes on request.	
Colour shades / degrees of gloss	Wei [White]	3320
Supplementary products	Bluefin Unistar ADLER Pigmolux DC ADLER Pigmolux HQ ADLER Aqua-Cleaner ADLER Bandreinigungslsung ADLER Clean Mbelreiniger ADLER Clean Mbelpflege Plus	2965 3401 ff 3350 ff 80080 80066 96490 7222000210

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**OTHER INSTRUCTIONS**

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**Durability / storage**

At least 6 months in the original sealed containers.

Make sure the product is protected against moisture, direct sunlight, frost and high temperatures.

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**Technical specifications**

Delivery viscosity  $65 \pm 3$  s in accordance with DIN 53211 (6-mm-cup, 20 °C)

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**Safety-related information**

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](http://www.adler-lacke.com)**.

The product is only suitable for industrial and professional use.

In general, inhaling paint aerosols must be avoided. This is ensured by correctly using a breathing mask (combination filter A2/P2).

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