

Pigmolux DC S G05

3481

Water-based, radiation-curing pigment coating for the industrial coating in furniture and interior finishing

PRODUCT DESCRIPTION

General

Water-based pigment coating for wooden surfaces in the furniture and interior finishing sector. The coating material is cured using two different cross-linking mechanisms (radiation curing and two-component polyurethane cross-linking). This special curing system (Dualcure) ensures that even areas of the workpiece that are insufficiently illuminated by the emitters – shadowed areas – are fully cross-linked. Three-dimensional parts can also be coated with Pigmolux DC S G05 3481 via hardener cross-linking and cured without the use of UV lamps. Good mechanical and chemical resistance, excellent resistance to light exposure, good filling power, very good stackability.

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 E (> 0.5 to ≤ 1.0 N)
- **EN 13501-1 (fire behaviour)**
In combination with a non-combustible substrate, e.g. materials of fire class A1 or A2: classification as B-s2, d0. For the classification of the reaction to fire, the complete build-up (carrier board / glue / veneer or foil) is always taken into account.
- **DIN 53160-1 and DIN 53160-2**
Perspiration and saliva-proof properties
- **ÖNORM EN 71-3**
Safety of toys; migration of certain elements (free of heavy metals)
- **French ordinance DEVL1104875A**
Marking of construction coating products for their emission of volatile pollutants: A+

1-0 IMC 3481 | 05/26 | replaces 0-1

ADLER-Werk Lackfabrik, A-6130 Schwaz

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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.

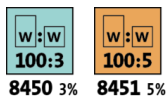
Application area

For coating heavily used surfaces in furniture and interior fittings, including kitchen and sanitary areas. Application areas II - 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 achieve the highest chemical resistance and "ring test"-resistant surfaces, we recommend coating with Bluefin Multilux Top (3853) in the desired gloss level.
- When coating interior doors, it must be ensured that only sealing profiles compatible with acrylic paints are used.
- Where plastic edges are used, however, an adhesion test with the intended coating system should always be done! Improved adhesion on ABS edges can be achieved through the use of ABS Kantenaktivator (8315).
- 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**.

Blending ratio

100 Part(s) by weight Pigmolux DC S G05 (3481)
3 Part(s) by weight Aqua-Hardener 8450 (8450000210)

If Pigmolux DC S G05 (3481) is processed without UV curing (e.g. for three-dimensional parts), the following paint-hardener mixture must be used:

100 weight part(s) Pigmolux DC S G05 (3481)
5 weight part(s) Aqua-Hardener 8451 (8451000210)

Aqua-Hardener 8450 (8450000210) or Aqua-Hardener 8451 (8451000210) must be carefully worked into the coating components by stirring before processing. We recommend waiting approx. 10 minutes before starting work.

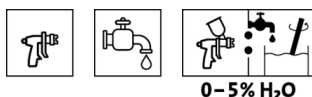
Pot life

4 hour(s)

Mixed material can be processed for a further 4 hour(s), but must be mixed 1:1 with freshly hardened material.

A further extension of the pot life is not possible.

Increased temperatures reduce the pot life.

Application technique

0-5% H₂O

	Airless	Airless air-supported (Airmix®, Aircoat, etc.)	Cup gun
Applying device		-	Obertopf pistole
Spraying nozzle Ø (mm)		0,28 - 0,33	1,8
Spraying pressure (bar)		100 - 120	2 - 3
Vaporizer Air (bar)	-	1 - 2	-
Diluent	Water		
Diluent amount added (%)		-	0 - 5

Viscosity 6-mm-cup (s)	38	20
Applied quantity per application (g/m ²)	100 - 150*	
Total quantity applied (g/m ²)	max. 450	

* closed-pored surfaces: approx. 120 g/m²

* open-pored surfaces: approx. 150 - 200 g/m²

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 times

(at 23 °C and 50 % rel. humidity)

Evaporation of the water

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

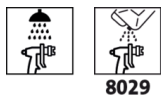
UV curing



Feed rate 2 - 3 m/min when using 1 Ga emitter and 1 Hg emitter (power: 80 W/cm²)

Attention must be paid to adequate curing at the edges!

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)

Hardener-carrying elements of 2-component systems: Clean-Smart 2K (8075000210).

SUBSTRATE

Type of substrate

Solid wood, chipboard or wood fibre materials suitable for opaque coating, 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.

Substrate preparation

Sanding Grit size 150 – 180

Carrier plates coated with priming film: Sanding Grit size 180 – 220

COATING SYSTEM

Primer coat

For closed-pore coating surfaces

Carrier plates coated with priming film:

Chipboard coated with primer foil (foil sanding grain 240), depending on quality requirements (fullness, uniformity of the surface) without primer or primed 1 x with Aqualux Spritzfüller Weiß (3319050000), intermediate sanding grain 320 - 360.

Solid wood or chipboard panels veneered with blind veneer (e. g. beech):

2 x primed with Aqualux Spritzfüller Weiß (3319050000) (two-component)
Intermediate sanding Grit size 280 – 320

MDF panels:

2 - 3 x primed with Aqualux Spritzfüller Weiß (3319050000) (two-component)

Intermediate sanding Grit size 280 – 320

For open-pore coating surfaces

Pre-priming with 150 - 200 g/m² Aqualux Spritzfüller Weiß (3319050000) in the case of:

Wood species .

Build-ups in the colour shade RAL 9010 "Reinweiß" (pure white) as well as in pastel shades.

Regarding coating systems for full-tone-colours it is sufficient to apply one primer coat using 150 – 200 g/m² Pigmolux DC S G05 3481).

Intermediate sanding



Grit size 280 – 360

Remove sanding dust.

Avoid sanding straight through!

Topcoat

1 x Pigmolux DC S G05 (3481) in the 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

Colour shades / Glosslevels

Pigmolux DC S G05 Weiß (3481102985)

RAL-shades, NCS-shades, etc. are available as special productions.

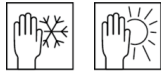
Supplementary products

ABS Kantenaktivator (8315)
Aqua-Cleaner 8029 (8029)
Aqua-Hardener 8450 (8450)
Aqua-Hardener 8451 (8451)
Aqualux Spritzfüller Weiß (3319050000)
Bluefin Multilux Top (3853)
Clean-Möbelpflege Plus (7222)
Clean-Möbelreiniger (7202)
Clean-Smart 2K (8075000210)
Clean-Smart B&P (8015000210)
Clean-Smart Gel (8060000210)

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

FURTHER DETAILS

Durability / storage



Min. 1 year(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: 35 – 38 seconds according to DIN 53211
(6 mm measuring cup, 20 °C)

Safety information



The product is only suitable for industrial 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.