

## Pigmolux HQ G40

3354

Water-based, radiation-curing 2C pigmented paint for furniture and interior finishing, for industrial use

### PRODUCT DESCRIPTION

#### General

Water-based pigmented paint with insulating properties for wooden surfaces in the furniture sector. Stand-out features of this product include a high degree of reactivity, very good stackability, very good chemical resistance, fast drying and extremely good mechanical resistance.

#### Special properties and standards



- **ÖNORM A 1605-12 (furniture surfaces)**  
Resistance to chemical reactions: 1-B1  
Response to abrasion: 2-D ( $\geq 50$  U)  
Response to scratches: 4-D ( $\geq 1.0$  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  $\leq 150$  U)  
Part 4: Response to scratches: 4 E ( $> 0.5$  to  $\leq 1.0$  N)



- **ÖNORM A 3800-1 (fire behaviour)**  
In conjunction with a flame-retardant substrate:  
flame-retardant, Q1, Tr 1



- **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+

#### 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.

1-1 IMC 3354 | 10/25 | replaces 1-0

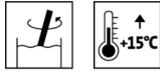
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Fon: +43/5242/6922-190, Fax: +43/5242/6922-309, Mail: [technical-support@adler-lacke.com](mailto:technical-support@adler-lacke.com)

Our instructions are based on the current state of knowledge and are intended to advise the buyer/user to the best of our knowledge, but must be individually adapted to the areas of application and processing conditions. The buyer/user is responsible for deciding on the suitability and use of the supplied product, which is why we recommend that a sample be produced to check the suitability of the product. In all other respects, our General Terms and Conditions of Sale apply. All previous data sheets lose their validity with this edition. We reserve the right to make changes to container sizes, color shades and available gloss levels.

## 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.
- The coating must be cured absolutely by UV radiation!
- An addition of Bluefin Multilux Top (3853) to varnish for the last finishing coat increases the ring test resistance and scratch resistance of Pigmolux HQ G40 (3354).
- 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).
- When coating interior doors, it must be ensured that only sealing profiles compatible with acrylic paints are used.
- 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 HQ G40 (3354)  
5 Part(s) by weight Aqua-Hardener 8456 (8456000210)

Aqua-Hardener 8456 (8456000210) must be carefully worked into the product by stirring before processing. We recommend waiting approx. 10 minutes before starting work. The product can only be processed in 2-component form.

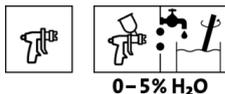
### Pot life



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



	Airless	Airless air-supported (Airmix®, Aircoat, etc.)	Cup gun
Spraying nozzle Ø (mm)		0,28 - 0,33	1,8
Spraying pressure (bar)		100 - 120	3 - 4
Vaporizer Air (bar)	-	1 - 2	-
Diluent	Wasser		
Diluent amount added (%)		-	0 - 5
Viscosity 6-mm-cup (s)	35 - 40		
Applied quantity per application (g/m <sup>2</sup> )	100 - 200*		
Total quantity applied (g/m <sup>2</sup> )	max. 450		

\* closed-pored surfaces: approx. 120 g/m<sup>2</sup>

\* open-pored surfaces: approx. 150 - 200 g/m<sup>2</sup>

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)

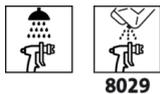
The mentioned system parameters are reference values, which must be coordinated with the respective plant. Drying depends on the substrate, layer thickness, temperature, air exchange, relative humidity, stacking pressure and stacking conditions.

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

**UV curing**

Feed rate 6 m/min when using 1 Ga-doped radiator (power: 80 W/cm<sup>2</sup>) and 1 Hg radiator (power: 60 W/cm<sup>2</sup>)

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 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.

**Substrate preparation****Wood sanding:**

Grit size 150 – 180

**Carrier plates coated with priming film:**

Grit size 180 - 240

**COATING SYSTEM****Primer coat****For closed-pore coating surfaces**

**Carrier plates coated with priming film:** Film sanding Grit size 240 (optional) 1 x Aqualux Spritzfüller (3319) (two-component)

Intermediate sanding Grit size 320 – 360

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

2 x Aqualux Spritzfüller (3319) (two-component)

Intermediate sanding Grit size 280 – 320

**MDF panels:**

2 - 3 x Aqualux Spritzfüller (3319) (two-component)

Intermediate sanding Grit size 280 – 320

**For open-pore coating surfaces**

Pre-insulated with 150 - 200 g/m<sup>2</sup> Aqualux Spritzfüller (3319) (two component) in case of wood species with water-soluble colouring wood components (e. g. ash) coating systems in RAL 9010 "Reinweiß" (pure white) and in pastel shades.

Regarding coating systems for full-tone-colours it is sufficient to apply one primer coat using 130 – 150 g/m<sup>2</sup> Pigmolux HQ G40 3354).

### Intermediate sanding



Grit size 280 – 360

Avoid sanding straight through!

Remove sanding dust.

### Topcoat

1 x Pigmolux HQ G40 (3354) 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 HQ G40 (3354) & colour number

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

### Supplementary products

ABS Kantenaktivator (8315)  
 Aqua-Cleaner 8029 (8029)  
 Aqua-Hardener 8456 (8456)  
 Aqualux Spritzfüller (3319)  
 Bluefin Multilux Top (3853)  
 Clean-Möbelpflege Plus (7222)  
 Clean-Möbelreiniger (7202)  
 Clean-Smart B&P (8015)  
 Clean-Smart Gel (8060)  
 Clean-Smart 2K (8075)

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).

Close opened containers well and use up the content as soon as possible.

### Technical specifications

Delivery viscosity: 35 – 40 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](http://www.adler-lacke.com).