Technical data sheet

Paint runs through our veins.

Pigmolux HQ G50 3355

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

PRODUCT DESCRIPTION

General

Water-based pigment 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 (≥ 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)
- **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.

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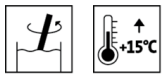
PROCESSING

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 G50 (3355).
- 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).
- 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

8456 5%

100 Part(s) by weight Pigmolux HQ G50 (3355)
5 Part(s) by weight Aqua-Hardener 8456 (8456000210)

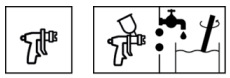
Aqua-Hardener 8456 (8456000210) must be carefully worked into the product by stirring before processing. We recommend waiting approx. 10 minutes before starting work. The product can only be processed in 2-component form.

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



0 – 5% H_2O

	Airless	Airless air-supported (Airmix®, Aircoat, etc.)	Cup gun
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)	35 - 40		
Applied quantity per application (g/m²)	100 - 150*		
Total quantity applied (g/m²)	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 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.

The drying time depends on the type of substrate, coat thickness, temperature, air exchange and relative atmospheric humidity.

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/cm²) and 1 Hg radiator (power: 60 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 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: Sanding Grit size 180 – 220

COATING SYSTEM

Primer coat

For closed-pore coating surfaces

Carrier plates coated with priming film:

Chipboard panels coated with primer film (film sanding, grit size 240), depending on quality requirements (filling performance, evenness of the surface) without priming or primed once with Aqualux Spritzfüller (3319), intermediate sanding using grit size 320 – 360.

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

2 x primed with Aqualux Spritzfüller (3319)

Intermediate sanding Grit size 280 – 320

Primer coat	**MDF panels:** 2 - 3 x primed with Aqualux Spritzfüller (3319) Intermediate sanding Grit size 280 – 320 **For open-pore coating surfaces** Pre-insulation with 150 - 200 g/m² Aqualux Spritzfüller (3319) in the case of: Wood species with water-soluble colouring wood constituents (e. g. ash). Coating systems in the colour RAL 9010 "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/m² Pigmolux HQ G50 3355).
Intermediate sanding 	Grit size 280 – 360 Avoid sanding straight through! Remove sanding dust.
Topcoat	1 x Pigmolux HQ G50 (3355) in the desired colour

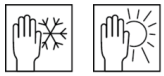
CLEANING AND MAINTENANCE

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

ORDERING INFORMATION

Size of trading unit	25 kg
Colour shades / Glosslevels	Pigmolux HQ G50 RAL9016 Verkehrsweiß (3355009016) 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 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. 9 month(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.**