Technical data sheet

Paint runs through our veins.

Pigmolux HQ ST50 3365

Water-based, **radiation-curing 2-component pigmented coating with textured effect** for **furniture and interior finishing** for **industrial use**

PRODUCT DESCRIPTION

General

Water-based pigmented coating with textured effect and stain-blocking properties for wood surfaces in the furniture sector. The product is characterised by high reactivity, very good stackability, very good chemical resistance, rapid drying and very high 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)
  Flammability: 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.

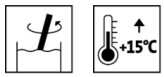
For hardly inflammable or flame-retardant coating systems.

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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 ST50 (3365).
- 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 coatings and 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 ST50 (3365)
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

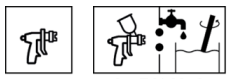


4 hour(s)

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.

Please only prepare as much material as can be used within the pot life.

Application technique



0 – 5% H_2O

	Airless	Airless air-supported (Airmix®, Aircoat, etc.)	Cup gun
Applying device	-		Obertopfpistole
Spraying nozzle Ø (mm)	0,28 - 0,33		1,8
Spraying pressure (bar)	100 - 120		3 - 4
Diluent	-		Water
Diluent amount added (%)	-		0 - 5
Viscosity 6-mm-cup (s)	82 - 87		
Applied quantity per application (g/m²)	100 - 200*		
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

Flash-off of water:

35 - 45 minutes	Conveyor belt pallet dryer (increasing temperature up to max. + 50 °C, air speed approx. 2 m/s)
or	
15 - 20 minutes	Flat channel dryer (increasing 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.

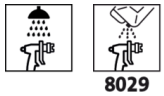
UV curing



Feed rate 6 m/min when using 1 Ga-doped emitter (power: 80 W/cm) and 2 Hg emitters (power: 80 W/cm)

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 Clean 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

Wood sanding:

Grit size 150 – 180

Carrier plates coated with priming film:

Grit size 180 - 240

COATING SYSTEM

Primer coat

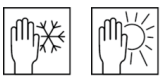
For closed-pore coating surfaces

Carrier plates coated with priming film: Film sanding Grit size 240

depending on quality requirements (fullness, uniformity of the surface) without primer or 1 x primed with 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 primed with Aqualux Spritzfüller (3319) (two-component) Intermediate sanding Grit size 280 – 320 **MDF panels:** 2 - 3 x primed with Aqualux Spritzfüller (3319) (two-component) Intermediate sanding Grit size 280 – 320 **For open-pore coating surfaces** Pre-priming with 150 - 200 g/m² Aqualux Spritzfüller (3319) (two-component) for wood species with water-soluble, colouring wood extractives (e.g. ash) or for build-ups in the colour shade RAL 9010 "Reinweiß" (pure white) as well as in pastel shades. Regarding coating systems for solid colours it is sufficient to apply one primer coat using 130 – 150 g/m² Pigmolux HQ ST50 (3365).
Intermediate sanding 	Grit size 280 – 360 Avoid sanding straight through! Remove sanding dust.
Topcoat	1 x Pigmolux HQ ST50 (3365) 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 ST50 (3365) & colour number RAL-shades, NCS-shades, etc. are available as special productions.
Supplementary products	ABS Kantenaktivator (8315) Clean Aqua-Cleaner 8029 (8029) Aqualux Spritzfüller (3319) Bluefin Multilux Top (3853) Clean-Möbelpflege Plus (7222) Clean-Möbelreiniger (7202) Clean Smart 2K (8075) Clean Smart B&P (8015) Clean Smart-Gel (8060) 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). Close opened containers well and use up the content as soon as possible.
Technical specifications	Delivery viscosity: 82 – 87 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.**