# Technical data sheet

Paint runs through our veins.

## Pigmolux DC G40 3404

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

## PRODUCT DESCRIPTION

### General

Water-based pigment paint for wooden surfaces in the furniture sector. The coating material is hardened using two different crosslinking mechanisms (through radiation curing and 2C polyurethane crosslinking). The use of this special hardening system (Dualcure) means that even areas of the workpiece that are insufficiently lit – shaded areas – will be completely crosslinked. Hardener crosslinking means that even three dimensional parts can be coated with Pigmolux DC G40 3404 and hardened without the use of UV lamps. Good mechanical and chemical resistance, excellent resistance to the effects of light, good filling performance, very good stackability.

### Special properties and standards

- **ÖNORM A 1605-12 (furniture surfaces)**
  Resistance to chemical reactions: 1-B1 (except for pure white and pastel shades)
  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 (except for pure white and pastel shades)
  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 hardly inflammable surface, e.g. materials of fire class A1 or A2: classification as B-s2,d0. The complete coating system (carrier board / glue / veneer or foil) is always used to classify the reaction to fire.
- **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+



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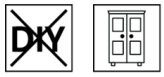
## Application area



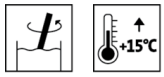

For coating heavily used surfaces in furniture and interior fittings, including kitchen and sanitary areas. Application areas II - IV according to ÖNORM A 1610-12.

The application area depends on the colour shade. Pure white and pastel shades meet the requirements except for a few colouring test materials.

For hardly inflammable or flame-retardant coating systems.

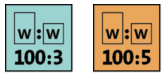
# PROCESSING

## 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.
- 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).
- 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




**8450** 3% **8451** 5%

100 Part(s) by weight Pigmolux DC G40 (3404)
3 Part(s) by weight Aqua-Hardener 8450 (8450000210)

If Pigmolux DC G40 (3404) 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 G40 (3404)
5 weight part(s) Aqua-Hardener 8451 (8451000210)

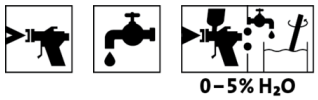
Aqua-Hardener 8450 (8450000210) or Aqua-Hardener 8451 (8451000210) must be carefully worked into the coating components by stirring before processing. We recommend waiting approx. 10 minutes before starting work.

## 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




| | 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 | | 2 -3 |
| **Vaporizer Air (bar)** | - | 1 - 2 | - |
| **Diluent** | Wasser | | |
| **Diluent amount added (%)** | - | | 0 - 5 |

| | | |
|---|---|---|
| **Viscosity 6-mm-cup (s)** | 38 | 20 |
| **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

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

## UV curing


Feed rate 2 - 3 m/min when using 1 Ga-radiator and 1 Hg-radiator (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).

# 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

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**

Chipboard panels coated with primer film (film sanding, grit size 240), perhaps primed 1 x with Aqualux Spritzfüller Weiß (3319050000), intermediate sanding using grit size 320 – 360

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

2 x Aqualux Spritzfüller Weiß (3319050000)

Intermediate sanding Grit size 280 – 320

**MDF panels:**

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

Intermediate sanding Grit size 280 – 320

**For open-pore coating surfaces**

Pre-insulation with 150 - 200 g/m² Aqualux Spritzfüller Weiß (3319050000) 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 150 – 200 g/m² Pigmolux DC G40 3404).

**Intermediate sanding**

Grit size 280 – 360

Remove sanding dust.

Avoid sanding straight through!

**Topcoat**

1 x Pigmolux DC G40 (3404) 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 DC G40 Gebrochen Weiß (3404078961)

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

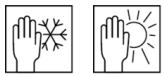
**Supplementary products**

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)

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 second – 38 second 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.**