Pigmolux DC G20 3402

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

PRODUCT DESCRIPTION

General

Water-based pigment coating for wooden surfaces in the furniture sector. The coating material is cured with the help of two different cross-linking mechanisms (curing by radiation and 2-component polyurethane cross-linking). With the help of this special curing system (Dual cure), even those areas of the work-piece that are inadequately illuminated by the beams – opaque spots – are cross-linked completely. Three-dimensional parts can also be coated with ADLER Pigmolux DC G 30 3402 through hardener cross-linking and cured without the use of UV radiators. Good mechanical and chemical resistance, excellent light resistance, good filling power, 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 (over 50 to 150 U)
  Part 4: Response to scratches: 4 E (> 0.5 until ≤ 1.0 N)
- In combination with a hardly inflammable surface, e.g. materials of fire class A1 or A2, coatings based on ADLER Pigmolux DC G20 3402 are to be classified as **B-s2,d0** in accordance with **DIN EN 13501-1.** 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** regarding the marking of construction coating products for their emission of volatile pollutants: A+

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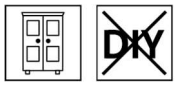
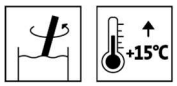
Application areas



- For large-scale industrial coating of furniture and interior finishing exposed to high levels of stress including surfaces in the kitchen- and sanitary areas: Application areas II – IV in accordance with ÖNORM A 1610-12. The application area depends on the colour tone. Pure white and pastel shades meet the requirements except for a few colouring test materials.
- For hardly inflammable or flame-retardant coating systems.

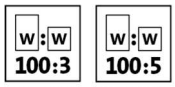
PROCESSING

Instructions for use



- Please stir the product before use.
- The temperature of the product and object, and the room temperature must be at least +15 °C.
- In order to achieve the maximum chemical resistance and surfaces resistant to ring indentation, we recommend applying a topcoat of Bluefin Multilux-Top 3853 in the desired degree of gloss.
- When coating interior doors, it must be ensured that only sealing profiles compatible with acrylic paints are used.
- If plastic edges are used, an adhesion test must always be carried out with the planned coating system. When using ADLER ABS-Kantenaktivator 8315000210 an adhesion improvement can be achieved on ABS edges.
- Please follow our **ARL 150 - Working guidelines for water-based furniture coatings**.

Blending ratio



3% 82220 5% 82221

100 parts by weight ADLER Pigmolux DC G20 3402
3 parts by weight ADLER Aqua-PUR-Härter 82220

If ADLER Pigmolux DC G20 is processed without UV curing (e.g. for three-dimensional parts), the following varnish-hardener mixture must be used:

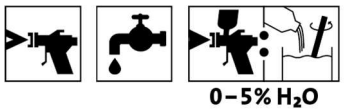
100 parts by weight ADLER Pigmolux DC G20 3402
5 parts by weight ADLER Aqua-PUR-Härter 82221

ADLER Aqua-PUR-Härter 82220 or 82221 must be carefully worked into the paint components by stirring before processing. We recommend observing a waiting time of approx. 10 min. before processing.

Pot life

4 hours; after 4 hours mixed material 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



Application method	Airless	Airless air-supported (Airmix, Aircoat, etc.)	Cup gun Top-pot spraying gun
Spray nozzle (ø mm)	0.28 - 0.33	0.28 – 0.33	1.8
Spraying pressure (bar)	100 – 120	100 – 120	2 - 3
Atomized air (bar)	-	1 – 2	-
Dilution (thinning)	water		
Thinner amount added in %	-	-	0 - 5
Viscosity (s) 6-mm-cup, 20 °C	38	38	20
Application quantity per application (g/m²)	approx. 100 - 150 per application total application amount max 450 - closed pore surfaces: approx. 120 - open pore surfaces: approx. 150 - 200		

The shape and properties of the substrate affect the consumption/yield. Accurate values for consumption must be obtained by applying trial coats in advance.

Drying conditions

- Flashing off the water:
- 35 - 45 min. belt-type pallet dryer or 15 - 20 min. flat surface dryer, temperature rising up to max. 50 °C
- The figures given above are reference values, which must be coordinated with the respective facility. The drying time depends e.g. on the type of wood, coat thickness, temperature, air exchange and relative humidity.

UV curing

Feed rate 2 - 3 m/min when using 1 Ga-doped 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 or ADLER Aqua-Cleaner 80080 (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.

Preparation of the substrate

Sanding with grit size 150 - 180

Film-coated chip boards: sanding with grit size 180 - 220

COATING SYSTEM

Primer

For closed-pore surfaces

a) Film-coated particle boards (film sanding grit size 240) possibly one coat using ADLER Aqualux Spritzfüller Weiß 29211 (two component), intermediate sanding grit size 320 - 360

b) Solid wood or chipboard veneered with blind veneer (e.g. beech), 2 x primed with ADLER Aqualux Spritzfüller Weiß 29211 (two component), intermediate sanding grit size 280 - 320

c) MDF boards, 2 - 3 x primed with ADLER Aqualux Spritzfüller Weiß 29211 (two component), intermediate sanding grit size 280 - 320

For open-pore surfaces

Pre-insulated with 150 - 200 g/m² ADLER Aqualux Spritzfüller Weiß 29211 (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 -
150 - 200 g/m² ADLER Pigmolux DC ISO 3402 ff

Please observe the relative technical data sheets of the products.

Intermediate sanding

Grit size 280 - 360

Avoid sanding straight through!

Please use only grit size 280 for pastel shades and RAL 9010.

During sanding use P2 dust filter.

Topcoat

1 x ADLER Pigmolux DC G20 3402 in the desired colour shade

CLEANING AND MAINTENANCE

Cleaning and maintenance

Cleaning with ADLER Clean-Möbelreiniger 96490. Preservation with ADLER Clean-Möbelpflege Plus 7222000210.

Please observe the relative technical data sheets of the products.

ORDERING INFORMATION

Size of trading unit

25 kg

Colour shades / degrees of gloss

ADLER Pigmolux DC G20 RAL9010 29447

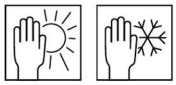
RALshades, NCS shades, etc. are available as special productions.

Supplementary products

ADLER Aqua-PUR-Härter	82220
ADLER Aqua-PUR-Härter	82221
ADLER Aqualux-Spritzfüller Weiß	29211
Bluefin Multilux Top	3853
ADLER Aqua-Cleaner	80080
ADLER Clean-Möbelreiniger	96490
ADLER Clean-Möbelpflege Plus	7222000210

FURTHER DETAILS

Durability / storage



At least 12 months in the original sealed containers.

Make sure the product is protected against moisture, direct sunlight, frost and high temperatures.

Technical specifications

Delivery viscosity	35 - 38 s in accordance with DIN 53211 (6-mm-cup, 20°C)

Safety-related information

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.**

The product is only suitable for industrial use.

In general, inhaling paint aerosols must be avoided. This is ensured by correctly using a breathing mask (combination filter A2/P2).