

## ADLER Pigmolux DC ST

29225 ff

Water-based, radiation-curing structural-effect pigment paint for furniture and interior finishing for industrial use

### PRODUCT DESCRIPTION

#### General

Water-based, radiation-curing structural-effect pigment paint for wooden surfaces in the furniture segment. 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. It provides good mechanical and chemical resistance, excellent resistance against exposure to light, good filling power and outstanding stackability.

#### Special properties and standards

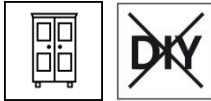
- **ÖNORM A 1605-12** (furniture surfaces)  
Resistance to chemical reactions: 1-B1 (with the exception of pure white)  
Response to abrasion: 2-D ( $\geq 50$  U)  
Response to scratches: 4-D ( $\geq 1.0$  N)  
Flame treatment: 5-B (highly non-flammable furniture surfaces)
- **ÖNORM A 3800-1** (fire behaviour) in conjunction with a flame-retardant substrate:  
highly non-combustible or flame-retardant (formerly B 1 in accordance with B 3800 -1), Q1, Tr 1
- **DIN 68861** (furniture surfaces)  
Part 1: Response to chemical stress: 1-B (with the exception of pure white)  
Part 2: Response to abrasion: 2 D (over 50 to 150)  
Part 4: Response to scratches: 4 E ( $> 0.5$  to  $\leq 1.0$  N)
- **ÖNORM S 1555** or **DIN 53160** 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+



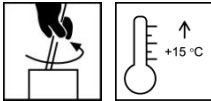
07-14 (supersedes 03-14) ZKL 3303

ADLER-Werk Lackfabrik, A-6130 Schwaz  
Fon: 0043/5242/6922-301, Fax: 0043/5242/6922-309, Mail: technical-support@adler-lacke.com

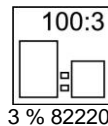
Our instructions for use are based on knowledge available currently and shall guide the purchaser / user to the best of one's knowledge, but, however, must be clarified for the areas of application and processing conditions on a case-to-case basis. The purchaser / user decides about the acceptance and use of the delivered product at his / her own risk, which is why we recommend that a sample piece be prepared to check the acceptability of the product. Our general terms and conditions of sale are otherwise applicable. All previous data sheets are rendered invalid with the issue of this one. Rights reserved for the modification of the container sizes, colour shades and degrees of gloss available.

**Application area**

- Open-pore and closed-pore coated pigment paint surfaces for large-scale industrial coating of furniture surfaces exposed to high levels of stress including kitchen furniture and sanitary facilities: Application areas II to IV according to ÖNORM A 1610-12.
- Highly non-flammable or flame-retardant structures

**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.
- When coating interior doors, it must be ensured that only sealing profiles compatible with acrylic paints and lacquers are used.
- Please follow our **"Working guidelines for water-based furniture paints / lacquers"**

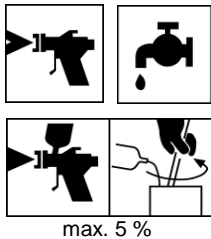
**Blending ratio**

100 parts by weight of ADLER Pigmolux DC ST 29225 ff  
3 parts by weight of ADLER Aqua-PUR-Härter 82220

ADLER Aqua-PUR-Härter 82220 must be carefully mixed with the painting component by stirring before use. We recommend waiting for about 10 min. before use.

**Pot life**

4 hours; the mixed material must necessarily be mixed after 4 hours with 1:1 freshly hardened material; it is not possible to extend the pot life beyond this.

**Application technique**

Application method	Airless	Airless air supported (Airmix, Aircoat, etc.)	Cup gun
Spraying nozzle (ø mm)	0.28 – 0.33	0.28 – 0.33	1.8
Spraying pressure (bar)	100 - 120	100 - 120	3 - 4
Spraying air (bar)	-	1 - 2	-
Dilution (thinning)	water		
Thinner amount added in %	-	-	0 - 5
Viscosity (s) 4-mm-cup, 20°C	approx. 155	approx. 155	approx. 120
Application quantity (g/m <sup>2</sup> )	approx. 100 - 150 per application; Total application quantity max. 450 - Closed-pore surfaces: approx. 120 - Open-pore surfaces: approx. 130 - 180		

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

**Drying conditions**

- Evaporation of the water
- 45 - 60 min. belt-type pallet dryer or 30 - 40 min. flat surface dryer, temperature rising up to max. 50 °C
- The system parameters mentioned are reference values that need to be adjusted to the respective system. The drying depends, for example, on the type of wood, coat thickness, temperature, air exchange and relative atmospheric humidity.

**UV curing**

Feed of 2 - 3 m/min. when using 1 Ga-doped beam and 1 Hg beam (Power: 80 W/cm<sup>2</sup>)

Pay attention to a sufficient hardening of the edges!

**SUBSTRATE****Type of substrate**

For opaque coating, suitable solid wood or plywood or wood fibre materials, veneered or laminated with priming film.

**Substrate property (or condition)**

The substrate must be dry, clean and capable of holding the paint free of grease, wax and wood dust.

**Preparation of the substrate**

Sanding grain size 150 - 180

**Film-coated particle boards:**

Sanding grain size 180 - 220

**COATING SYSTEM****Primer coat****For closed-pore dull-finish paint surfaces**

- Particle board coated with primer film (film sanding grain size 240), possibly primer-coated with 1 coat of ADLER Aqualux-Spritzfüller Weiß 29211 (2-component), intermediate sanding with grain size 320 – 360
- Solid wood or particle board veneered with cross veneer (beech), with 2 primer coats of ADLER ADLER Aqualux-Spritzfüller Weiß 29211 (2-component), intermediate sanding with grain size 280 – 320
- MDF boards, with 2 to 3 primer coats of ADLER Aqualux-Spritzfüller Weiß 29211 (2-component), intermediate sanding with grain size 280 - 320

**For open-pore dull-finish paint surfaces**

Apply a saturate primer coat with 150 - 200 g/m<sup>2</sup> of ADLER Aqualux-Spritzfüller Weiß 29211 (2-component)

Please observe the relative technical data sheets of the products.

**Intermediate sanding**

Grain size 280 - 360

Avoid through sanding!

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

**Topcoat**

Apply 1 coat of ADLER Pigmolux DC ST 29225 ff in the desired colour shade

## MAINTENANCE

For cleaning use ADLER Clean-Möbelreiniger 96490 (furniture cleaner).

Do not use preservation products on structured surfaces!

Please observe the relative technical data sheets of the products.

## ORDERING INFORMATION

### Size of trading unit

25 kg

### Colour shades / degree of gloss

ADLER Pigmolux DC ST10 Weiß (white) 29225

RAL colour shades, NCS colour shades etc. can be delivered as specially manufactured lots.

The following structures are available:

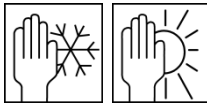
Designation	Structure
ST10	Very coarsely
ST30	Coarse
ST50	Medium
ST70	Fine
ST90	Very fine

### Supplementary products

ADLER Aqua-PUR-Härter	82220
ADLER Aqualux-Spritzfüller Weiß	29211
ADLER Aqua-Cleaner	80080
ADLER Clean-Möbelreiniger	96490

## FURTHER DETAILS

### Durability / storage



At least 12 months in the original sealed containers.

Store it such that it is protected against moisture, direct sunlight, frost and high temperatures.

### Technical specifications

Delivery viscosity	155 - 160 s in accordance with DIN 53211 (4 mm-cup, 20°C)
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### Safety-relevant information



Please follow the associated safety data sheet! The latest version can be retrieved from the Internet at [www.adler-lacke.com](http://www.adler-lacke.com).

In general, you must avoid inhaling paint aerosols. This is ensured by proper use of a breathing mask (combination filter A2/P2 – EN 141/EN 143).