

## Pigmolux DC G30

3403

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 using two different cross-linking mechanisms (radiation curing and 2K polyurethane cross-linking). This special curing system (Dualcure) means that even areas of the workpiece that are insufficiently illuminated by the spotlights - shadows - are fully cross-linked. Three-dimensional parts can also be coated with ADLER Pigmolux DC G30 3403 via hardener crosslinking and cured without the use of UV lamps. Good mechanical and chemical resistance, excellent resistance to the effects of light, good filling power, very good stackability.

#### Special properties and standards



- EN 13501-1 (fire behaviour)**  
**Confirmed by an external test certificate.**  
 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.
- ÖNORM A 1605-12 (furniture surfaces)**  
 Resistance to chemical reactions: 1-B1 (except for pure white and pastel shades)  
 Response to abrasion: 2-D ( $\geq 50$  U)  
 Response to scratches: 4-D ( $\geq 1.0$  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  $\leq 150$  U)  
 Part 4: Response to scratches: 4 E ( $> 0.5$  to  $\leq 1.0$  N)
- ÖNORM EN 71-3**  
 Safety of toys; migration of certain elements (free of heavy metals)
- DIN 53160-1 and DIN 53160-2**  
 Perspiration and saliva-proof properties
- 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. 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.

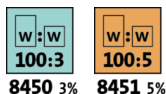
## PROCESSING

### 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



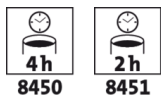
100 Part(s) by weight Pigmolux DC G30 (3403)  
3 Part(s) by weight Aqua-Hardener 8450 (8450000210)

If Pigmolux DC G30 (3403) 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 G30 (3403)  
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



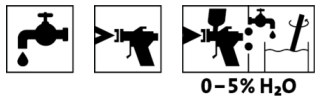
**With Aqua-Hardener 8450 (8450000210):** 4 hour(s)

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.

**With Aqua-Hardener 8451 (8451000210):** 2 hour(s)

Mixed material can be processed for a further 2 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/m <sup>2</sup> )		ca. 100 - 150*	
Total quantity applied (g/m <sup>2</sup> )		max. 450	

\* closed-pored surfaces: approx. 120 g/m<sup>2</sup>

\* open-pored surfaces: approx. 150 - 200 g/m<sup>2</sup>

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**

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.

Lower temperatures and/or high level of atmospheric humidity can increase the drying time.

**UV curing**



Feed rate 2 - 3 m/min when using 1 Ga-radiator and 1 Hg-radiator (power: 80 W/cm<sup>2</sup>)

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)

<b>SUBSTRATE</b>	
<b>Type of substrate</b>	Solid wood, chipboard or wood fibre materials suitable for opaque varnishing, veneered or coated with priming film.
<b>Substrate property</b>	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.
<b>Substrate preparation</b>	<b>Wood and wood-based materials:</b> Wood sanding Grit size 150 – 180 <b>Carrier plates coated with priming film:</b> Film sanding Grit size 180 – 220
<b>COATING SYSTEM</b>	
<b>Primer coat</b>	<p><b>For closed-pore coating surfaces</b>  <b>Carrier plates coated with priming film:</b> Film sanding Grit size 240            1 x Aqualux Spritzfüller (3319) (two-component)            Intermediate sanding Grit size 320 – 360</p> <p><b>Solid wood or chipboard panels veneered with blind veneer (e. g. beech):</b>            2 x Aqualux Spritzfüller (3319) (two-component)            Intermediate sanding Grit size 280 – 320</p> <p><b>MDF panels:</b>            2 - 3 x Aqualux Spritzfüller (3319) (two-component)            Intermediate sanding Grit size 280 – 320</p> <p><b>For open-pore coating surfaces</b>            Pre-insulated with 150 - 200 g/m<sup>2</sup> Aqualux Spritzfüller (3319) (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-tone-colours it is sufficient to apply one primer coat using 150 – 200 g/m<sup>2</sup> Pigmolux DC G30 3403).            Drying overnight at room temperature.</p>
<b>Intermediate sanding</b>	Grit size 280 – 360 Avoid sanding straight through!
<b>Topcoat</b>	1 x Pigmolux DC G30 (3403) in the desired colour
<b>CLEANING AND MAINTENANCE</b>	
<b>Cleaning and Maintenance</b>	Cleaning with Clean-Möbelreiniger (7202) and care with Clean-Möbelpflege Plus (7222).
<b>ORDERING INFORMATION</b>	
<b>Size of trading unit</b>	25 kg
<b>Colour shades / Glosslevels</b>	Pigmolux DC G30# RAL9010 (29428) RAL-shades, NCS-shades, etc. are available as special productions.
<b>Supplementary products</b>	Aqualux Spritzfüller (3319) Bluefin Multilux Top (3853) Clean-Möbelpflege Plus (7222)

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. 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 – 38 seconds according to DIN 53211  
(6 mm measuring cup, 20 °C)

### Safety information



The product is only suitable for the industrial and professional 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](http://www.adler-lacke.com).