

## Pigmolux MX ST70

3627

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

### PRODUCT DESCRIPTION

#### General

Water-based pigmented coating with textured effect for wood surfaces in the furniture sector. The coating material is cured by two different cross-linking mechanisms (radiation curing and two-component polyurethane cross-linking). This special curing system (Dualcure) ensures that even areas of the workpiece that are insufficiently exposed to the emitters – shadowed areas – are fully cross-linked. Through hardener cross-linking, three-dimensional parts can also be coated with Pigmolux MX ST70 3627 and cured without the use of UV emitters. The product is characterised by good mechanical and chemical resistance, excellent resistance to light exposure, good filling power and very good stackability.

#### Special properties and standards



- **ÖNORM A 1605-12 (furniture surfaces)**  
Resistance to chemical reactions: 1-B1  
Response to abrasion: 2-D ( $\geq 50$  U)  
Response to scratches: 4-D ( $\geq 1.0$  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  $\leq 150$  U)  
Part 4: Response to scratches: 4 E ( $> 0.5$  to  $\leq 1.0$  N)
- **EN 13501-1 (fire behaviour)**  
In combination with a non-combustible substrate, e.g. materials of fire class A1 or A2: classification as B-s2, d0. For the classification of the reaction to fire, the complete build-up (carrier board / glue / veneer or foil) is always taken into account.
- **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. 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 coatings and 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



8451 5%

100 Part(s) by weight Pigmolux MX ST70 (3627)  
5 Part(s) by weight Aqua-Hardener 8451 (8451000210)

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

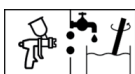
## Pot life



**With Aqua-Hardener 8451 (8451000210): 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



0 - 5% H<sub>2</sub>O

|                                                      | Airless     | Airless air-supported (Airmix®, Aircoat, etc.) | Cup gun |
|------------------------------------------------------|-------------|------------------------------------------------|---------|
| Spraying nozzle Ø (mm)                               | 0,28 - 0,33 |                                                | 1,8     |
| Spraying pressure (bar)                              | 100 - 120   |                                                | 2 - 3   |
| Vaporizer Air (bar)                                  | -           | 1 - 2                                          | -       |
| Diluent                                              | Water       |                                                |         |
| Applied quantity per application (g/m <sup>2</sup> ) | 100 - 200*  |                                                |         |
| 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****Flash-off of water:**

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

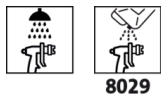
The mentioned system parameters are reference values, which must be coordinated with the respective plant. Drying depends on the substrate, layer thickness, temperature, air exchange, relative humidity, stacking pressure and stacking conditions.

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

**UV curing**

Feed rate 2 - 3 m/min when using 1 Ga emitter and 1 Hg emitter (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 Clean Aqua-Cleaner (8029) (diluted 1:1 with water).

**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 (optional) 1 x 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 Aqualux Spritzfüller (3319) (two-component)

Intermediate sanding Grit size 280 – 320

**MDF panels:**

2 - 3 x Aqualux Spritzfüller (3319) (two-component)

Intermediate sanding Grit size 280 – 320

**For open-pore coating surfaces**

Pre-priming with 150 - 200 g/m<sup>2</sup> 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 150 – 200 g/m<sup>2</sup> Pigmolux MX ST70 (3627).

Drying overnight at room temperature.

### Intermediate sanding



Grit size 280 – 360

Avoid sanding straight through!

Remove sanding dust.

### Topcoat

1 x Pigmolux MX ST70 (3627) 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



#### Base paint(s):

Pigmolux MX ST70 W10 Weiß, tönbar (3627000010)

Pigmolux MX ST70 Basis W20 (3627000020)

Pigmolux MX ST70 Basis W30 (3627000030)

Other colour shades can be obtained using the **ADLER colour mixing system ADLERMix**.

### Supplementary products

ABS Kantenaktivator (8315)  
Clean Aqua-Cleaner 8029 (8029)  
Aqua-Hardener 8451 (8451)  
Aqualux Spritzfüller (3319)  
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).

Close opened containers well and use up the content as soon as possible.

### Technical specifications

Delivery viscosity: 55 – 60 seconds in accordance with 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](http://www.adler-lacke.com).