



Hesse Lignal
inspiring you

High Gloss Pigmented

Methodology	Weight g/m ²	Mix (Volumetric)	Thinner	Drying (20°C)
1. Substrate sanding 240/320 grit				
2. 1 x DP 4755-9343	150 - 200	10:1 DR 4071	10 - 15% DV 4935	30min Intermediate Drying
3. 1 x DP 4755-9343	150 - 200	10:1 DR 4071	10 - 15% DV 4935	6 -7 hrs (better overnight)
4. Repeat steps 2 - 3				6 -7 hrs (better overnight)
5. Sanding 600/800 grit				
6. 1 x DB 44099-colour	80 - 120	2:1 DR 4080	15 - 20% DV 4935	45min Intermediate Drying
7. 1 x DB 44099-colour	80 - 120	2:1 DR 4080	15 - 20% DV 4935	Polishable after three days

Processing Tips

- **Pre-Coating:** Make sure the substrate is clean and free from contaminants such as grease, oil and glue.
- **Sanding:** Intermediate sanding should reflect the needs of the surface. If the surface is flat and free of inclusions only a light sand is required to provide a key for subsequent coats.
- **Post Sanding:** dust removal is best achieved using compressed air in combination with a lint free cloth. Tak Rags may be used, but are not encouraged due to their nature of leaving residue on the surface when used heavy handedly.

General Information

- **Temperature and Humidity:** PU lacquers should not be used and dried at product and room temperatures below 18 °C and below 40 % RH, ideal values: 20 -25 °C, 50 - 65 % RH. Deviations lead to problems with drying or, as may apply, hardening.
- **Adhesion:** In order to avoid adhesion problems, please sand the PU lacquered surfaces before applying fresh lacquer and apply lacquer to the sanded surfaces as soon as possible. If left sitting for a significant amount of time the surface will begin to oxidize and harden beyond the level required for proper adhesion.
- **Mix Flexibility:** Mixed residues may be refreshed at the limit of the products pot life to extend use. A mix that has passed significantly beyond this point must only be used as a 10 - 20 % aggregate in a fresh lacquer/hardener mixture. Old lacquer/hardener mixtures impair the surface quality (adhesion/stability).
- **Final Hardening:** If stored correctly at room temperature complete hardening of the coating is achieved after seven days. Please apply a test coat under real conditions!