

## Technical information

# Hesse PU Cellulose lacquer DE 4500x(gloss level)-0016

Mixing ratio (by volume): 10 : 1 PU DECORATIVE METAL Hardener DR 4008

## Product description

Two-component PU acrylic resin lacquer, clear and light-fast. A high-quality protective indoor lacquer for metal. The lacquer material is free from phthalate softeners and is therefore also suitable for coating children's toys.

## Areas of application

For all interior fixtures and fittings and top-coating degreased metal or metallic surfaces such as PU DECORATIVE-METAL.

## Area of application

- Internal fit-out
- Kitchen and bathroom
- Furniture
- Special applications

## Substrate material

- Dark, fine pored hardwood
- dark deciduous woods with coarse pores
- light deciduous woods with fine pores
- light deciduous woods with coarse pores
- Engineered veneer/fineline
- Conifers

## Surface Preparation



### Surface preparation

Substrate preparation is decisive to the bond of the glass coating. The glass surface to be coated must be clean and grease-free. Carefully clean the glass surface prior to application, e.g. using Glass cleaner HS 6601.

Substrate sanding grits  150 - 180

Lacquer sanding grit  280 - 320

## Application

Application	Spray nozzle size	Spray pressure	Atomizing pressure
<b>2C line</b>			
Airless	 0,23 - 0,28 mm	100 - 150 bar	
<b>Airless low pressure</b>			
Airmix	 0,23 - 0,28 mm	60 - 100 bar	2 - 2,5 bar
Compressed air spraying	1,8 - 2 mm	1,8 - 2 bar	
<b>High-performance automatic spraying unit</b>			
<b>Automatic spray gun</b>			
<b>Spraying robot</b>			

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## Times

Pot life		8 h / 20 °C
Drying		6 h / 20 °C
Stackable after		16 h / 20 °C
Complete drying		7 d / 20 °C














## Finishing

**Finishing** Coat with products from the same series after drying and lacquer sanding.

## Processing instructions

Single-coat application at 60 - 80 g/m<sup>2</sup> on properly prepared substrates. The addition of 20 - 30 % Thinner DV 4900 is recommended when spraying Hesse PU Cellulose lacquer DE 4500x(gloss level)-0016.

## Technical data

Flow time (+/- 15%)		60 s / ISO4
Yield per coat		6 - 9 m <sup>2</sup> /l The spreading rate is heavily dependent on the type of application. The specifications relate to a liter of ready-for-use product, if necessary including hardener and thinner.
Proportion of renewable raw materi-		0 %
Non-volatile proportion		17.2 - 23 %
VOC FR		A+
conditions of transport		frost-free - up to max. 35 °C
Shelf life in weeks		52
Storage temperature		16 - 40 °C
Number of coats (max)		3
Amount per layer (minimum)		100 g/m <sup>2</sup>
Amount per layer (max)		150 g/m <sup>2</sup>
Total application volume		450 g/m <sup>2</sup>
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Mixing information (gravimetric)		100 : 11 PU DECORATIVE METAL Hardener DR 4008

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## Particular properties / testing standards

Sign Product standard / basis



PVC-resistant



Formulation is free of: wood preservatives, toxic heavy metals, phthalate plasticizers, formaldehyde, CMR substances in Categories 1A + 1B and volatile aromatic and halogenated organic compounds.



Saliva and sweat resistance according to DIN 53160 Parts 1 and 2: no discolouration (Level 5)



DIN 68861-Part 1B (Furniture surfaces; Behaviour under chemical demands)

## Sample process

The coating process and the precise treatment parameters are adapted in each case to the respective application and drying conditions and can be found in the customer-specific process descriptions (surface techniques).

## Ordering information

Order number	Colour tone	Gloss level 60° (Gloss +/-5)	Gloss level
DE 45000-0016		2	dull matt
DE 45002-0016		10	matt
DE 45004-0016		20	silk matt
DE 45007-0016		40	satin gloss

## Accessories

	Order number	Product description
hardeners	DR 4008	PU DECORATIVE METAL Hardener
Thinners	DV 4900	PU Thinner
	DV 4994	PU Thinner
Retarder	DV 4909	PU Retarder
Equipment cleaner	RV 1	Cleaning thinner

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### General instructions on workmanship

PU lacquers should not be applied or dried at material and room temperatures below 18 °C and 40 % RH, ideal values: 20 - 25 °C and 50 - 65 % RH. Deviations lead to problems with drying and/or curing. To avoid adhesion problems, please gently sand back the PU lacquered surfaces before applying fresh lacquer and apply lacquer to the sanded surfaces as soon as possible. Mixed residues from the previous day 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). Freshly bleached wood must be allowed at least 48 h intermediate drying / 20 °C before recoating with PU lacquers. The final hardness of the coating is achieved after one week in correct storage conditions (at least 20 °C room temperature). Please conduct a sample coating under real conditions!

Our technical information is continually adapted to keep up to date with the latest technology and statutory regulations. The indicated values are no specification, but typical product data. The latest version is always available online at [www.hesse-lignal.de](http://www.hesse-lignal.de) or talk to your local account manager. This information is for advice and is based on the best knowledge available and careful research in line with the current state of the art. This information cannot be held as legally binding. We also refer you to our terms and conditions of business. Material safety data sheet is provided in accordance with EC regulation no. 1907/2006.

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