

#### >Product description

Hesse Compact PU Basecoat DG 468-1 is a two-component PU polyester resin basecoat. The lacquer sands well, is extremely elastic and has good body. DG 468-1 is particularly suitable beneath Hesse PU multicoat and finishing lacquers for building up a closed-pore finish. It also fulfills the requirements of the IMO EC Type Examination test certificate (flame retardant coating material for seagoing vessels).

#### >Areas of application

This basecoat has great filling power and is used primarily in the high quality fit-out of ships, the interior design sector and shopfitting.

#### >Surface Preparation

Surface preparation	Clean, dry wood, dependent upon wood type and method of application.
Substrate sanding grits from-to	150 - 180
Lacquer sanding (grit) from - to	320 - 400

#### >Finishing

Finishing	Can be coated with matching Hesse top coats after adequate drying and careful sanding. (e.g. DE 55x(gloss level), DE 56x(gloss level), DU 520)
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#### >Times

Usage time	2 - 3 h / 20 °C
Drying	6 h / 20 °C
Stackable after	> 16 h / 20 °C
Complete drying	7 d / 20 °C

#### >Application

Application	Nozzle size in mm	Spray pressure in bar	Atomising pressure in bar
Spraying			
2C line			
Airless	0,23 - 0,28	100 - 150	
Airless low pressure			
Air mix	0,23 - 0,28	60 - 100	2,0 - 2,5
Compressed air spraying	1,8 - 2,0	1,8 - 2,0	
High-performance automatic spraying unit			
Automatic spray gun			
Spraying robot			

#### >Processing instructions

The maximum application amount in wet film when used as a flame-retardant coating material for seagoing vessels totals 150 g/m<sup>2</sup>

## Technical information

### Hesse Compact PU Primer DG 468-1

Mixing ratio (by volume): 2 : 1 PUR Hardener DR 435

#### >Technical data

Flow time (+/- 15 %)	36 s / DIN EN ISO 2431 - 4 mm
Appearance	colourless
Density series kg/l	0.968
Yield per coat	5 - 10 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.
Form of delivery	fluid
Non-volatile content series %	40
VOC EU %	61 %
VOC FR	C
Storage temperature	16 - 25 °C
Shelf life in weeks	52
Working temperature	20 °C
Number of coats (max)	12
Amount per layer (minimum)	100 g/m <sup>2</sup>
Amount per layer (max)	200 g/m <sup>2</sup>
Total application volume	2400 g/m <sup>2</sup>
Mixing ratio (by volume)	2 : 1 PUR Hardener DR 435
Mixing ratio (gravimetric)	100 : 50 PUR Hardener DR 435

#### >Ordering information

Order number	Gloss level 60° (Gloss)	Container Size
DG 468-1	-	5 l, 25 l

#### >Hardeners

Order number	Product description	Container Size
DR 435	PUR Hardener	2.5 l, 12.5 l, 15 l

#### >Thinners

Order number	Product description	Container Size
DV 490	PU Thinner	1 l, 5 l, 15 l, 25 l

#### >Retarder

Order number	Product description	Container Size
DV 499	Universal retarder	1 l, 5 l, 10 l, 15 l, 25 l

#### >Equipment cleaner

Order number	Product description	Container Size
NV 395	Cleaning thinner	5 l, 15 l, 25 l
RV 1	Cleaning thinner	5 l, 15 l, 25 l

#### >Particular instructions

To improve the stability and bonding on critical woods, such as tropical wood and cherry wood, we recommend pre-priming with Hesse PU Insulating Primer DG 572-1. This product is not suitable for use on bleached surfaces! When used as a flame retardant coating for ships in accordance with SOLAS 74/88 Reg. II-2/3, II-2/5 and II-2/6, latest version, IMO Resolution MSC.36(63)-(1994 HSC-Code) 7, and IMO Resolution MSC.97(73)-(2000 HSC-Code) 7, this product may only be combined with other approved and technically suitable products. After sufficient drying and correct sanding, can be coated over with, for example, DE 55x(gloss level), DE 56x(gloss level), DU 520. **"A risk assessment was undertaken according to Directive 2014/90/EU, Annex II, Section 3. This coating does not pose a physical risk to health nor a risk to the environment when cured and dried."**

#### >Sample process

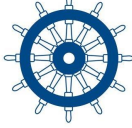

The coating process and the precise treatment parameters are adapted in each case to the respective application and drying conditions and can be found in the customer-specific process descriptions (surface techniques).

#### >General information

PU lacquers should not be applied and dried at material and room-temperatures below 18 °C and 40 % RH. Ideal values are: 20 - 25 °C, 50 - 65 % RH. Deviations will result in drying or hardening errors. 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. Old lacquer and hardener mixtures affect the surface quality (adhesion/resistance). Freshly bleached substrates must undergo intermediate drying for at least 48 h at 20 °C before coating with suitable PU lacquers. If stored correctly (at least 20 °C room temperature), the final hardness of the coating is achieved after a week.

Please apply a test coat under real conditions!

#### >Particular properties and/or testing standards

Test standard / basis	Testing laboratory	Mark	Report	No.
EC type examination certificate (module B); coating agent for seagoing vessels according to IMO Resolution MSC.307(88)-(FTP-Code 2010).	Trade association transport and traffic; Ship Safety Division, Hamburg		Approval No. U.S. Coast Guard Approval No.	116244-03 164.112/ EC0736/116244-03
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.	HESSE			

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. Safety data sheet is provided in accordance with EC regulation no. 1907/2006.