# Technical information

# Hesse HYDRO Metallic lacquer HB 65445-(colour tone)

Hesse Lignal
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## >Product description

Strong thixotropic 1C HYDRO Metallic colour lacquer with good ability to stay on vertical surfaces and uniform effect formation. This light fast coloured lacquer is available in many colors and is particularly suitable for coating three-dimensional parts.

## >Areas of application

The material can be used universally as a metallic effect lacquer for closed-pore structures in living areas. Its thixotropic flow behaviour facilitates the coating of vertical surfaces. It can also be used for the direct coating of suitable, cleaned and sanded foils.

## >Surface Preparation

| | |
|---|---|
| Surface preparation | Clean, well-seasoned wood, or clean, suitable laminate base, free from oil, grease, wax and silicones. Sanded as prescribed and free from sanding dust. Matching pigment filler, sanded as prescribed and free from sanding dust. |
| Substrate sanding grits from-to | 120 - 400 |

## >Finishing

| | |
|---|---|
| Finishing | If absolute metal marking resistance and colour abrasion resistance or another gloss level is required, we recommend top coating with HE 6509x(gloss level), HDE 5400x(gloss level) or HDE 54799, for example. Recoating without intermediate sanding is only possible within 6 h (without forced drying). When top coating coloured lacquer surfaces there may be changes in the colour tone. Please apply a test coat! |

## >Times

| | |
|---|---|
| Working Temperature Range | 18 - 22 °C |
| conditions of transport | 10 - 30 °C |
| Drying | 8 h / 20 °C |
| Stackable after | > 16 h / 20 °C |
| Complete drying | 1 d / 20 °C |
| Load bearing after | 7 d / 20 °C |

## >Application

| Application | Nozzle size in mm | Spray pressure in bar | Atomising pressure in bar |
|---|---|---|---|
| Spraying | | | |
| Air mix | 0,23 - 0,38 | 60 - 100 | 1,5 - 2,5 |
| Compressed air spraying | 1,5 - 2,0 | 2,5 - 4 | |

## >Processing instructions

When directly coating cleaned or sanded foils, please apply a test coat to check the bonding!.
Clean tools with water. For removal of dried lacquer residues use Hesse HYDRO Cleaning agent HV 6917. In case of combined coatings (HYDRO- and solvent based lacquers) rinse application tools with Hesse HYDRO Reversing agent HV 6904. This product can be subjected to forced drying. Pre-priming is possible depending on the required finish and carrier material, for instance using: HP 6645-9343, HP 5640-9343, DP 4755-9343.

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## >Technical data

| | |
|---|---|
| Flow time (+/- 15 %) | not applicable keine Angabe |
| Appearance | opaque |
| Density series kg/l | 1.033 - 1.091 |
| Yield per coat | 9 - 11 m²/l<br>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 % | 22 - 32 |
| VOC EU % | 4 % |
| VOC FR | C |
| Working Temperature Range | 18 - 22 °C |
| Storage temperature | 10 - 30 °C |
| Shelf life in weeks | 26 |
| conditions of transport | 10 - 30 °C |
| Working temperature | 20 °C |
| Number of coats (max) | 2 |
| Amount per layer (minimum) | 100 g/m² |
| Amount per layer (max) | 120 g/m² |
| Total application volume | 300 g/m² |

## >Ordering information

| Order number | Colour tone | Gloss level 60° (Gloss) | Gloss level | Container Size |
|---|---|---|---|---|
| HB 65445-89239 | KUPFER HELL | 24 - 29 | silk matt | 1 l, 5 l, 15 l, 25 l |
| HB 65445-89240 | KUPFER DUNKEL | 24 - 29 | silk matt | 1 l, 5 l, 15 l, 25 l |
| HB 65445-9006 | 9006 | 24 - 29 | silk matt | 1 l, 5 l, 15 kg, 25 l |
| HB 65445-9007 | 9007 | 24 - 29 | silk matt | 1 l, 5 l, 15 l, 25 l |
| HB 65445-9022 | 9022 | 24 - 29 | silk matt | 1 l, 5 l, 15 kg, 25 l |
| HB 65445-M19770 | MESSING | 24 - 29 | silk matt | 1 l, 5 l, 15 l, 25 l |

## >Equipment cleaner

| Order number | Product description | Container Size |
|---|---|---|
| WASSER | water | 1 l |

## >Particular instructions

The material is supplied ready to use and only needs to be diluted in exceptional cases. If needed, add a maximum of 5 % water **or** a maximum of 3 % HZ Optimizer 70. This addition significantly reduces the thixotropy.

## >Sample process

Sideboard, MDF carcass, light brass
MDF sanding with dust removal.
Base coat: 2 x 150 - 200 g/m² Hesse HYDRO Isolation primer HP 6645-9343.
Intermediate drying and sanding.
Final sanding using 400 grit before finish coating.
1 x finish with 100 - 120 g/m² Hesse HYDRO Metallic lacquer HB 65445-M19770.
The metallic effect is self-forming.
Drying overnight at 20 °C room temperature and adequate air circulation.

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## >General information

When working with HYDRO materials, parts that come into contact with the material must be made from stainless steel. The moisture content should be between 8 - 12 %. Do not apply or dry HYDRO lacquers at material or room temperatures below 18 °C. The ideal humidity for application lies between 55 and 65 %. During the lacquering process, a humidity level that is too low leads to surface defects (such as shrink cracks, etc.). Excessive humidity during the drying phase may drastically lengthen the drying time! In order to avoid adhesion problems, please sand the lacquered surfaces freshly before coating and apply lacquer to the sanded surfaces as soon as possible. When applied to foils, etc., please use a sample coating on the respective substrate to check the adhesion! The ideal complete hardening of lacquered surfaces that have been flashed off is reached at temperatures over 20 °C up to no more than 40 °C. Adequate, draft-free air exchange must be assured. The complete hardening of the lacquer will be reached after one week of proper storage (at least 20 °C room temperature). Woods containing large amounts of natural oils, such as teak, can negatively influence adhesion under certain circumstances. Water-soluble wood ingredients such those in ash and tannins in woods such as oak may cause colour changes and discolourations in the coating. We recommend that you always conduct a sample lacquering to evaluate the colour effect, adhesion and drying process under real conditions!

## >Particular properties and/or testing standards

| Test standard / basis | Testing laboratory | Mark | Report | No. |
|---|---|---|---|---|
| Product meets the requirements of solvent based paints and coatings regulation - ChemVOCFarbV (German ordinance on solvent-based paints and varnishes) - according to the national implementation of 2004/42/EG ("Decopaint Directive "). | HESSE | ChemVoC FarbV Decopaint fähig | | |
| Green Building - Applicable Standard Specification: 2010 Dubai Green Building Regulations and Specifications (GBRS) Applicable Specific Rules: RD-DP21-2180-(IC) Specific Rules for Certification of Paints and Coating through Factory Assessment as per the 2010 Dubai Green Building Regulations and Specifications. | Dubai Central Laboratory | DCL PRODUCT CONFORMITY | Certificate No: | CL15020251 (HB 65445-9006) |