

Technical information

Hesse HYDRO Metallic lacquer HB 65445-(colour tone)

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.

Area of application

- Internal fit-out
- Furniture
- Special applications

Substrate material

- suitably pre-primed

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		120 - 400
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Application

Application	Spray nozzle size	Spray pressure	Atomizing pressure
Airmix	 0,23 - 0,38 mm	60 - 100 bar	1,5 - 2,5 bar
Compressed air spraying	 1,5 - 2 mm		

Times

Drying		8 h / 20 °C
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Stackable after		16 h / 20 °C
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Resilient after		7 d / 20 °C
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Complete drying		1 d / 20 °C
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Finishing

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If absolute metal marking resistance and colour abrasion resistance or another gloss level is required, we recommend top coating with COOL-TOP HE 6509x(gloss level), PERFECT-TOP HDE 5400x(gloss level) or HYDRO-PUR Brillantlack 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!

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: COOL-FILL HP 6645-9343, PERFECT-FILL HDP 5650-9343, FANTASTIC-FILL DP 4755-9343.

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.

Technical data

Flow time (+/- 15%)	 0 s / NA
Yield per coat	 9 - 11 m ² /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 material	 0 %
Non-volatile proportion	 22 - 38.1 %
VOC FR	C
conditions of transport	 10 - 30 °C
Shelf life in weeks	 26
Storage temperature	 10 - 30 °C
Working Temperature Range	 18 - 22 °C
Number of coats (max)	 2
Amount per layer (minimum)	 100 g/m ²
Amount per layer (max)	 120 g/m ²
Total application volume	 MAX 300 g/m ²

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Particular properties / testing standards

Sign Product standard / basis



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 ("Deco-paint Directive").



Green Building - Applicable Standard Specification: Standard Specification: 2023 Al Sa'fat - Dubai Green Building System 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.

Sample process

Sideboard, MDF carcass, light brass

MDF sanding with dust removal.

Base coat: 2 x 150 - 200 g/m² COOL-FILL 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.

Accessories

	Order number	Product description
Equipment cleaner	Water	

General instructions on workmanship

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!

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 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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