WARNEX

Optimal for standard materials. Simple and economic application. Enhancing textures.

Materials:

Wooden Surfaces

For the application on MDF, plywood, multiplex of birch or other similar wooden products. No special preparation or primer is needed.

Ferrous / Non-Ferrous Surfaces

WARNEX texture paint should be used in combination with our waterborne WARNEX primer (Product Series 72)
for optimum adhesion.

Plastic / Composite Surfaces

An adhesion test is required for plastic/composite materials and in some cases the WARNEX primer (Product series 72)may be required.

Applications:

Substrate: MDF – Birch-plywood - Multiplex And Other Wooden Surfaces

In order to ensure the adhesion of the coating, the substrates must be clean and dry.

Filler / Putty

It is not recommended to use a filler or putty on larger areas as these tend to chip off easily. Only the minimum quantity of filler or putty required for spot repairs should be applied and afterwards a careful sanding to level the surface is required.

Coating of Small Damages on the Surface

Being a time saving texture paint, the WARNEX System will cover small surface damages only when the second spattered coat is applied. A WARNEX base coat with excessive thickness will not give any advantage in this case.
Wood fibres or grains may stand up especially on the cut ends. This may require a pre-coating of these edges, subsequent sanding and only then applying the base coat.

Application

Excessive thickness of the layer of the basecoat on the substrate may be subject to cracks under too high temperatures, humidity and/or strong air movement. The application should be done continuously and fast to avoid overspray which may settle on the coated surface causing a rough sandpaper-like surface.

Cleaning the Nozzle

From time to time the built up overspray on the spray gun nozzle must be cleaned with solvent and a paint brush. Otherwise the result of the texture may not show the required standard.

Texture Forming:

The "spattered texture" is the result of the 2nd coating which is applied in a sequence of 15 – 20 minutes* after the base coating:

I. Conditions for the Base Coating:

Nozzle diameter:	0,078"	2,0 mm
Air pressure:	28–57psi	2–4 bar
Material pressure:	28–71 psi	2–5 bar
Spraying Distance:	1 ft	30 cm

II. Conditions for the Spattered Coating

Nozzle diameter:	0,078"	2,0 mm
Air pressure:	7–21 psi	0,5–1,5 bar
Material pressure:	28–71 psi	2–5 bar
Spraying Distance:	1,3 ft	40 cm

Variation of Texture Finish

parameter	texture finish
air pressure low/high	big dots / small dots
material pressure higher	smoother surface
spraying distance from wider range	rough & more pointed
more cross coats	closed texture

Drying / Forced Drying

At room temperature

dust free	=	15 – 20 minutes *
ready for handling	=	2 – 3 hours *
ready for packing	=	1 day *
through dry	=	4 days *

Oven drying

Coated substrates may be heated up to temperatures of appr. 60°C to speed up the drying process.

* Depending on film-thickness, temperature, humidity, air circulation, condition of the surface.

THE EASY WARNEX HANDLING

Stainless steel, pressurized equipment, clean with water, keep away from freezing – that's it.

Paint pails should be closed carefully immediately after opening.
Material should be stirred well before using.
The Paint does not need to be diluted.

Equipment – all spraying equipment must be made of stainless steel

The WARNEX texture paint has a high viscosity requiring the use of a paint pressure tank. Because of the fast initial drying, a closed system is required. The material hose should not be longer than approx. 5 meters and should have at least a 13 mm (1/2") internal diameter for optimized application speed. An industrial spray gun for paint pressure tank is recommended.

How to clean the spray equipment

Ordinary tap water can be used for cleaning the equipment as long as the paint is wet. The material hose has always to be cleaned with water only! (Material hose is only for the use for WARNEX).
The spray gun nozzle has to be cleaned with solvent because of built up overspray. Those parts of the spraying equipment which could not be cleaned
with water in the first step must be cleaned with solvent in a second phase.

How often should the spray equipment be cleaned?

It is recommended to clean the spray equipment regularly (e.g. twice per week if in continuous use) to assure that no paint build-up can be found inside the system. Using a closed system such as a pressure tank, the cleaning intervals may be extended. Please make sure, that only original fresh paint is used and that the pressure pot system will not run empty.

Coagulant:

Paint cabins fitted with a water wall need to have the correct coagulant for the application of WARNEX (risk of foaming). As the coagulant has to match the requirements of your specific painting environment, you need to contact your supplier, giving him samples of WARNEX in order to enable them to find the correct coagulant.

Shelf life

We guarantee a shelf life of 12 months (see production date on the pail) in originally sealed containers and frost-free storage.

Do not use the paint any more

- if infected with bacteria (change or loss of colour, foul odour)
- if there is an excessive loss of viscosity
- if there is a dry film (skin) on the top of the paint
- if the paint has been exposed to freezing temperatures (lumps in the paint)

1K WARNEX TEXTURE PAINT SERIES 74

Technical Data Sheet.

Product description : waterborne one component texture paint.

Binder type : water-acrylic
Gloss level : half matt
Solids : 52 – 55 % of weight
Recommended dry-film thickness : 70 µm (base coating)
120 µm (total, base + spattered coating)
Theoretical covering rate : 5,5 m²/kg (70 µm, base coating)
3,2 m²/kg (120 µm, total coating)
Practical average covering rate : 1,5 m²/kg for Loudspeaker cabinets
Average VOC-rate : 160 g/l
Specific gravity : 1,15 – 1,20 g/cm³

Viscosity : initial viscosity Rheolab 900 – 1500 mPas / D 70^{1}/s
application visc. ready for handling

Application parameters : high pressure spraying system with a paint pressure tank

- air pressure : 2 – 4 bar
- material pressure : 2 – 5 bar
- materialhose diameter : 13 mm internal-Ø
- nozzle size : 2,0 mm
- cross coats : 1 – 1 ½
- spray distance : 30 – 40 cm
- thinner : Not necessary, De-ionised / distilled water (only if needed)

Spraying equipment must be cleaned regular in interval.

Drying:

dust free	ready for handling	through dry	heat assisted drying	oven curing
15 – 20 min	2 – 3 hours	4 days	60 min / 60°C recirculated air	-

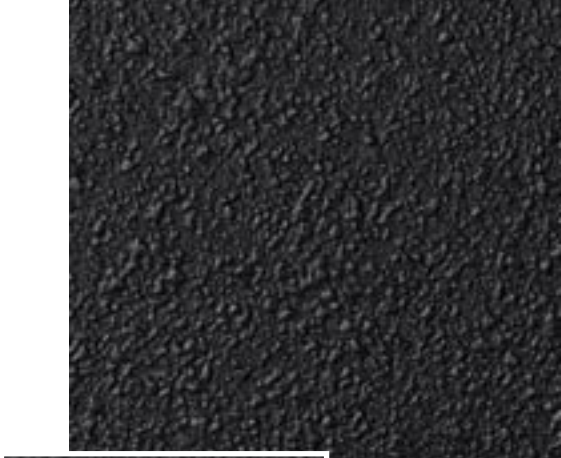
Depending on: air and object temperatures, film thickness, relative humidity and air movement.

Substrate: Adhesion on woods such as MDF, birch plywood und many types of plastics. In any case it is recommended to perform an adhesion test.

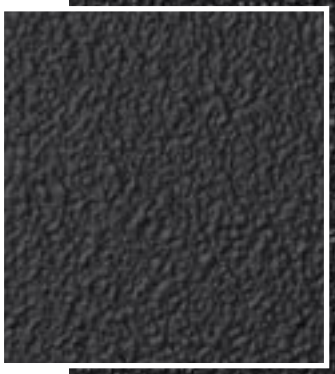
Extras WARNEX texture paint has a high viscosity demanding the use of a paint pressure tank. Because of the fast initial drying, a closed system is necessary.

Storage: Cool but frost free, protect against heat and solar irradiation, max. 9 months in original sealed containers.

WARNEX:
enhancing textures

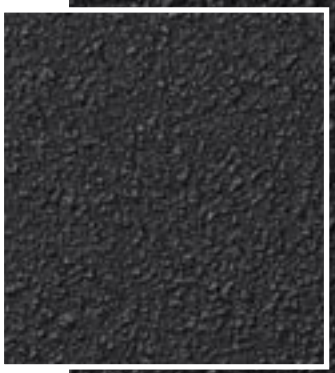


TEXTURE FORMING:
The “spattered texture” is the result of 2 coatings which are ap - plied in a sequence of 15 – 20 minutes* between the base and the spattered coating:



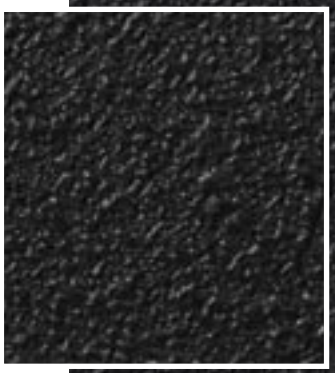
I. CONDITIONS FOR THE BASE COATING:

Nozzle diameter:	0,078 inch	2,0 mm
Airpressure:	28 – 57psi	2 – 4 bar
Materialpressure:	28 – 71 psi	2 – 5 bar
Spraying Distance:	1 ft	30 cm



II. CONDITIONS FOR THE SPATTERED COATING:

Nozzle diameter:	0,078 inch	2,0 mm
Airpressure:	7 – 21psi	0,5 – 1,5 bar
Materialpressure:	28 – 71 psi	2 – 5 bar
Spraying Distance:	1,3 ft	40 cm



VARIATION OF TEXTURE FINISH:

parameter	texture finish
air pressure low / high	big dots / small dots
material pressure higher	smoother surface
spraying distance with larger range	rough and more pointed
more cross coats	closer

DRYING / FORCED DRYING:
At room temperature:

dust free	=	15 – 20 minutes *
ready for handling	=	2 – 3 hours *
ready for packing	=	1 day *
through dry	=	4 days *

Oven drying:
Coated substrates may be heated at elevated temperatures of approx. 60°C to speed up drying process.

* Depending on film-thickness, temperature, humidity, air circulation, condition of the surface.

Technical Data Sheet

1 K	WARNEX texture paint	Series 74

Product description	waterborne single-component texture paint	
Binder type	water-acrylic	
Gloss level	half matt	
Solids	52 – 55 %-weight	
Recommended dry-film thickness	70 µm (base coating) 120 µm (total, base + spattered coating)	
Theoretical covering rate	5,5 m^2/kg (70 µm, base coating) 3,2 m^2/kg (120 µm, total coating)	
Practical average covering rate	1,5 m^2/kg for Loudspeaker cabinets	
VOC-rate Ø	160 g/l	
Specific gravity	1,15 – 1,20 g/cm^3	
Viscosity	initial viscosity	Rheolab 1400-1800 mPas / D701/s
	application visc.	ready for handling
Application parameters	high pressure spraying system with a paint pressure tank	
air pressure	2 – 4 bar	
material pressure	2 – 5 bar	
materialhose diameter	13 mm internal-Ø	
noozle size	2,0 mm	
cross coats	1 – 1 ½	
spray distance	30 – 40 cm	
thinner	De-ionised / distilled water (if needed)	

Spraying equipment must be thoroughly cleaned with water directly after use.

Drying

dust free	ready for handling	through dry	thermal forced drying	oven curing
15 – 20 min	2 – 3 hours	4 days	60 min / 60° Crecirculated air	-

Depending on: air and object temperatures, film-thickness, relative humidity and air movement.

Substrate

Adhesion on woods such as MDF, birch plywood und many types of plastics. In any case it is recommended to do an adhesion test.

Extras

WARNEX texture paint has a high viscosity demanding the use of a paint pressure tank. Because of the fast initial drying, a closed system is required.

Storage

Frost free, max. 12 months in original unopened containers.

Technisches Merkblatt

1 K WARNEX Strukturlack Reihe 74

Produktbeschreibung	:	Schnell trocknender 1K-Dispersionslack mit sehr guter Oberflächenhärte.
Bindemittelbasis	:	Wässrige Acrylatdispersion
Glanzgrad	:	Halbmatt
Festkörper	:	52 – 55 Gew.-%
Empfohlene Trockenschichtdicke	:	70 µm Einschicht-Narbenstruktur 120 µm Zweischicht-Tüpfelstruktur
Theoretische Ergiebigkeit	:	5,5 m²/kg (70 µm) 3,2 m²/kg (120 µm)
Durchschnittliche praktische Ergiebigkeit	:	1,5 m²/kg für Boxenbeschichtung
VOC-Wert Ø	:	160 g/l
Dichte	:	1,15 – 1,20 g/cm³
Viskosität	:	Liefervisk.: Rheolab 1400 - 1800 mPas / D 70 ^{1}/s Verarbeitungsvisk.: spritzfertig

Verarbeitungsparameter : Hochdruckspritzen mit Druckkessel oder Druckbecherpistole

- Luftdruck : 2 – 4 bar
- Materialdruck : 2 – 5 bar
- Materialschlauchdicke : 13 mm innen-Ø
- Düsengröße : 2,0 mm
- Kreuzgänge : 1 – 1 ½
- Spritzabstand : 30 – 40 cm
- Verdünnung : VE-Wasser

Arbeitsgeräte unmittelbar nach Gebrauch mit Wasser reinigen!

Trocknung:

Staubtrocken	Montagefest	Durchgetrocknet	Wärmebeschleunigt	Einbrennen
15 – 20 min	2 – 3 Std	4 Tage blockfest nach ca. 2 Tagen	60 min / 60°C Umluft ablüften: 15 min	-

Abhängig von Parametern wie Luft- und Objekttemperatur, Schichtdicke, relative Luftfeuchtigkeit und Luftbewegung.

Untergrund: Als Einschichtlack auf Holz und PS-Kunststoff. Aufgrund der Vielzahl von Kunststoffblends sind Haftungsvorversuche im Einzelfall durchzuführen. Bei Metallen ist eine Grundierung notwendig.

Sonstiges: Wegen der sehr schnellen Antrocknung und um eine hohe Lackiergeschwindigkeit zu erreichen, sollte aus einem geschlossenen System appliziert werden, z.B. Druckkessel oder Doppelmembranpumpe mit Deckelaufsatz. Bei mehr als 5 m Materialschlauchlänge, ist ein höherer Materialdruck notwendig.
Durch die schwermetallfreie Pigmentierung führt es bei bestimmten Farbtönen (besonders im Gelb-, Orange- und Rot-Bereich) zu vermindertem Deckvermögen. Wir empfehlen für diesen Fall ein geeignetes weisses Vormaterial zu verwenden.

Lagerung: Frostfrei, max. 9 Monate in originalverschlossenen Gebinden.

Technische Beratung:

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