



Induline UV-DW-680/50

Water-based, opaque, UV-curing intermediate and final coat for spray application



Colour	Availability		
	Quantity per pallet	22	4
	Size / Quantity	20 l	120 l
	Type of container	Tin bucket	Plastic drum
	Container code	20	68
	Art. no.		
Induline UV-DW 680/50 silk gloss			
special colours	3971	■	■
Base A (pre-filling: 98%)	015060	■	
Base C (pre-filling: 92%)	015062	■	

Application rate

150 - 175 ml/m² per coat (plus spraying loss)
(equivalent to a wet film thickness of 150 - 175 µm and a dry film thickness of approx. 60 µm)



Range of use



- For use on interior and exterior wood
- Soft and hard woods
- Dimensionally stable wood building elements: e.g. windows and doors
- Intermediate and finishing coats
- Single coat and multi-coat procedure
- For use by professionals

Property profile



- Good flow properties
- Good hiding power
- UV-curing: very quick handling
- Good resistance to yellowing and chalking
- Special combination of binding agents creates an extremely hard-wearing surface
- Very good hail resistance: elasticity at low temperatures
- Highly resistant to temporary water stains

Characteristic data of the product

Binder	Special UV-curing PU/acrylate copolymers
Density (20 °C)	Approx. 1.18 g/cm ³
Viscosity (20 °C)	Approx. 2500 mPas
Odour	Characteristic
Degree of gloss	Silk gloss

The values stated represent typical characteristic data of the product and are not to be understood as binding product specifications.

Possible system products

- Induline GW-201 (2491)
- Induline GW-209 (2498)
- Induline GW-306* (3488)
- Induline UV-GW-385 (3889)
- Induline ZW-400 (3900)
- Induline ZW-425 (7918)
- Induline UV-LW-781/20 (3438)

*Use biocidal products carefully.
Always read the label and product information before use.



Preparation

- **Substrate requirements**
The substrate must be clean, dry, free of dust, grease and loose substances, and prepared in the correct manner.
Dimensionally stable wood building elements: wood moisture content 11-15%
- **Substrate preparation**
If necessary, impregnate non-resistant woods with a wood preservative* (*Use biocides safely. Always read the label and product information before use).
Pre-treat using a suitable primer & intermediate coat and carry out intermediate sanding if necessary.
If necessary, protect parapet joints with Induline V-Joint Protection or Induline AF-920.

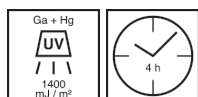
Directions



- **Conditions for use**
Temperature of the material, air and substrate: from min. +15 °C to max. +30 °C.

The values given are based on undiluted material. The best spraying pattern is achieved if the material has a temperature of 15-20 °C.
Stir well.
Airless spraying: nozzle size: 0.28-0.33 mm; material pressure: 70-90 bar.
Air-mix spraying: nozzle size: 0.28-0.33 mm; material pressure: 70-90 bar, atomiser air pressure 1-2 bar.
Apply further coatings after drying and UV curing
Seal opened containers well and use contents as soon as possible.

Tips on use



- Check colour, adhesion and compatibility with the substrate by setting up a trial area.
Before coating technically modified woods and wood-based materials, apply the coating to a trial surface and conduct a suitability test on the desired area of use.
Do not use in direct sunlight or at temperatures below +15 °C or above +30 °C.
Ensure good ventilation.
The product is not self-crosslinking and must be cured using a suitable UV lamp
With water based coating systems, there is always a residual risk that substances contained in the wood will cause discoloration.
Sealing compounds must be compatible with the coating and may only be applied once the coating has dried thoroughly.
Only use sealing profiles that are free of plasticisers.
The specifications of VFF Code of Practice HO.03 must be observed with regard to the permitted dry layer thicknesses.
- **Drying**
Physical drying:
UV crosslinking: after approx. 4 hours (at 23 °C and 50% RH)
UV crosslinking after forced drying: after approx. 20 minutes flash-off zone (at approx. 20 °C and 65 - 75% RH) / 45 minutes drying phase (approx. 45 °C; 1 m/s air circulation)

UV crosslinking:
Lamp type: Ga+Hg
Lamp power: 80 - 120 watts/cm²
Crosslinking energy values:
White and coloured:
1000 - 1400 mJ/cm²

Distance between object & lamp: 20-30 cm
These parameters are guide values. Precise parameters must be determined on a customer-specific basis.

Ready for sanding and overcoating: after 10 minutes cooling phase
- **Thinning**
Ready to use

Notes

Care and maintenance:
Wood is subjected to great climatic and environmental stresses when outdoors. The coat is susceptible to the processes of natural ageing, wear and decomposition. Decomposition takes place at different speeds, depending on the stress (weak, average, strong) placed on the wood building element. Weathering stages may vary according to the part or element affected. To give wood the longest and best possible protection it is advisable to examine surfaces every year. Any damage found should be addressed immediately after cleaning.
For cleaning and care, we recommend the care set for windows (2745) and doors (2746).
Top-up coating of Aqua DL-65-Opaque PU.
Observe current standards and guidelines for coating wood building elements outdoors (Codes of Practice issued by the German Association of Window and Facade Manufacturers (VFF), Code of Practice No. 18 issued by the German Federal Committee for Paint and the Protection of Material Assets (BFS), guidelines issued by the German Lacquer and Printing Ink Association (VdL) and ift guidelines issued by the Institut für Fenstertechnik).



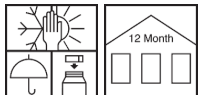
Tools / Cleaning

Manual spray gun, automatic spraying equipment



Clean tools with water or Aqua RK-898 Cleaning Concentrate immediately after use.
Ensure that any residue from cleaning is disposed of correctly.

Storage / Shelf life



If stored unopened in its original container in a cool, dry place and protected against frost, the product will keep for at least 12 months.

Always close the container and protect the contents from sunlight.

Safety data / Regulations

For further information on the safety aspects of transporting, storing and handling the product and on disposal and environmental matters, please see the current Safety Data Sheet.

Personal protective equipment

Respiratory protection with a particle filter P2 must be worn during spraying, together with protective goggles. Wear suitable protective gloves and clothing.

Disposal

Larger quantities of leftover product should be disposed of in the original containers in accordance with the applicable regulations. Completely empty, clean containers should be recycled. Do not dispose of together with household waste. Do not allow to enter the sewage system. Do not empty into drains.

VOC content as per the "Decopaint" Directive (2004/42/EC)

EU limit value for the product (cat A/d): max. 130 g/l (2010).
This product contains < 130 g/l VOC.

VOC	
Kat.	A/d
2010:	130g/l
max.:	130g/l

Please note that the data and information given above have been calculated as guidelines in the laboratory and from real-life experience and are therefore not binding as a basic principle.

This information is therefore of a general nature only and describes our products and how they are used and worked with. In this respect, it must be borne in mind that the varied and diverse nature of the

prevailing working conditions, materials used and construction sites encountered means that not every individual case can be covered. In this respect, we therefore recommend either conducting tests or liaising with us in the event of any doubt. Unless we have provided express written assurance of the products' specific suitability or characteristics in respect of a contractually stipulated intended use, any technical application-related advice or instruction will never

be binding, even though it is provided to the best of our knowledge. In all other respects, our general terms and conditions of sale and delivery shall apply.

When a new version of this Technical Data Sheet is published, it shall replace the previous version.