

Hesse HYDRO Filler HP 6645-9343

>Product description

Single-component HYDRO primer, water-dilutable pigmented, thixotropic formula, machine-sandable, very good filling properties. Filling primer for closed-pore lacquer applications with good hold on vertical surfaces. Free from methylpyrrolidon. HP 6645-9343, in conjunction with HB 65285-(colour tone), is categorised as flame-retardant per DIN 4102 B1.

>Areas of application

For all interior fittings in living areas, on an extremely wide range of wood types, priming foils and MDF, and MDF including edges. For furniture surfaces throughout all interiors; for stairs, doors, ledges, etc.

>Surface Preparation

Surface preparation	Clean, dry wood, free of oil, grease, wax and silicones. Sanded as prescribed and free from sanding dust.
Substrate sanding grits from-to	120 - 400
Intermediate lacquer sanding (grits) from-to	280 - 400
Finishing	Recoatibility: Can be coated over after sufficient drying time and intermediate sanding, e.g. with HB 65285-(colour tone), HDB 54705-(colour tone). Can also be coated with commonly used HYDRO, PU or CN coloured lacquers and with most standard paints. (Test coat required!)
Comments on sanding	Along with the MDF quality and the film quality, the quality and uniformity of the wood sanding, MDF sanding or foil sanding, as well as the lacquer sanding, are critical for the quality of the final surface. After sanding, remove dust as prescribed.

>Times

Drying	2 h
Stackable after	Depending on the application quantity, lacquer and ambient temperature, air humidity, application process and substrate material: at least 16 hours drying at 20 °C room temperature with adequate air circulation. Forced drying is possible.

>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.

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>Technical data

Flow time	25 s / DIN 53211 - 6 mm
Appearance	opaque
Decopaint basis	Wb
Decopaint category	i
Density series kg/l	1.368
Form of delivery	fluid
Non-volatile content series %	62
VOC EU %	6 %
VOC FR	A+
Storage temperature	10 - 30 °C
Shelf life in weeks	52
Working temperature	20 °C
Number of coats (max)	3
Amount per layer (minimum)	120 g/m ²
Amount per layer (most)	300 g/m ²
Total application volume	600 g/m ²

>Ordering information

Order number	Colour tone	Container Size
HP 6645-9343	WEISS	5 kg, 25 kg

>Equipment cleaner

Order number	Container Size	Product description
HV 6904	1 l, 5 l, 25 l	HYDRO Reversing agent
HV 6917	1 l, 5 l, 25 l	HYDRO Cleaning agent

>Particular instructions

Woods rich in active substances, such as ash, which tend to discolour when coated with pastel-coloured HYDRO colour systems should always be pre-treated with dual-component primers, such as: HDP 5640-9343. Pre-prime exotic woods such as Macassar ebony or extremely resinous knotty pine with PU Isolating primer DG 4720-0001.

>Sample process



Substrate sanding with e.g. 220 - 280 grit, and subsequent dust removal. Base coat 2 x 130 - 150 g/m² Hesse HYDRO Isolation primer HP 6645-9343. Intermediate drying: at least 4 h / 20 °C, preferably 16 h / 20 °C room temperature with adequate air circulation. Intermediate sanding: graduating from 240 - 320 grit with subsequent dust removal. Top coat 1 x 110 - 130 g/m² Hesse HYDRO-PRO-COLOR HB 65285-9010. Packable: after drying for at least 16 h / 20 °C room-temperature with 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 as 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! With MDF coatings, you can avoid painting faults and edge breaks if you observe the following: Selection of a suitable MDF quality for the area of application, see manufacturer data on EU standard EN 622-5, pt. 4 Test method EN 317 (requirements on thickness swelling). Ideal panel moisture 5 - 7 %. If possible coat the MDF all around, the backs should at least receive a clear coating. Avoid sharp edges and cutaways, round-off wherever possible. Coat edges and cutaways 2x with primers, do not sand through, if need be, prime again. Thick boards that have been created by gluing together several thinner boards are, due to the variance in tension, susceptible to edge ridging. It is better to select a single MDF board of the appropriate thickness. Panels that have been glued together should always be sanded flat at the edges and colourlessly pre-insulated. Any water introduced by gluing must be allowed to evaporate prior to coating. Store primer-coated surfaces in an air conditioned location and apply the final coat in a timely manner.

>Particular properties and/or testing standards

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			
Flame retardant to B1 according to DIN 4102; on suitable substrates.	MPA-Erwitte		Test certificate number	P-MPA-E-14-522

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