

Metallic Flip-Flop effect-coat based on Alberdingk U 3251+U 6150 VP

	Raw Material	Supplier	% by wt.	% by wt.	
Formulation basis coat	Alberdingk U 3251	(1)	20.70	20.70	
	Alberdingk U 6150 VP	(1)	7.50	7.50	
	Water		28.05	28.05	
	LUBA-print 942/A	(2)	3.75	3.75	
	<i>Mix for about 5 min</i>				
	Water		11.14	13.12	
	Borchi® Gel 0621	(3)	0.56	—	
	Borchi® Gel 0620 , 10% in butyl glycol	(3)	—	1.88	
	<i>Mix for about 10 min</i>				
	Water / Butyl diglycol (1:1)		3.30	—	
Total		75.00	75.00		
<i>Mix for about 10 min</i>					
Formulation effect coat	Stapa Hydroxal W 24n.I.	(4)	6.00	6.00	
	Butyl glycol		6.00	6.00	
	<i>Dispersion</i>				
	Borchi® Gol LA 50	(3)	0.70	0.70	
	Methoxy propyl acetate		1.10	1.10	
	Defoamer		0.20	0.20	
	Hombitec RM 220 WP	(5)	10.00	10.00	
	Sandospers E-B2G pa	(6)	1.00	1.00	
	<i>Mix for about 15 min.</i>				
	Basis coat (see above)		75.00	75.00	
Total		100.00	100.00		
<i>Mix for about 15 min.</i>					
<i>Let rest minimum 8 hours before application.</i>					

pH-value: approx. 8

Remarks Afterwards is recommended to apply a clear coat.
(for example acc. to RR 1.17.A)

Application Compressed-air spraying
Spray viscosity (DIN 53211-cup 4mm): approx. 15 s
Drying: 30 min at 80 °C

Suppliers

- (1) Alberdingk Boley (www.alberdingk-boley.de)
- (2) L.P. Bader (www.lubaprint-bader.de)
- (3) Borchers (www.borchers.com)
- (4) Eckart Pigments (www.eckart.de)
- (5) Sachtleben (www.sachtleben.de)
- (6) Clariant (www.clariant.com)

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