



HAE 34

Technical Data Sheet

Description:

Self-priming glossy water-born paint 3 in 1

Usage:

One-component fast-drying glossy self-priming (3 in 1) acrylic coating for steel constructions, pallets, transport boxes, crates, fences, eaves, parapets, windows, ceilings, casing frames, barks, furniture, other types of wood and selected types of plastics (ABS, hard PVC, polystyrene). Can be used for coating of mechanically stressed floor and other mineral surfaces. Applicable by spraying, brush or roller. For application by spraying wait 30 minutes between 2 layers of HAE 34. For application by roller or brush wait 6 hours between 2 layers of HAE 34. Suitable for painting products in indirect contact with foodstuffs, animal feed and drinking water.

Substrate:

Steel, zinc, aluminum, copper, wood, mineral substrates (floors), plastics, titanium zinc

Colours:

RAL

Specific gravity: (ČSN EN ISO 2811-1)

1,19 g/cm³

Solids: (ČSN EN ISO 3251)

by weight 55 %

by volume 46 %

Theoretical spreading rate: (ČSN EN ISO 23811)

undiluted paint			
40 µm DFT	9,6 m ² /kg	11,5 m ² /liter	104,0 g/m ²
80 µm DFT	4,8 m ² /kg	5,7 m ² /liter	207,0 g/m ²

To reach 40 µm DFT apply 87 µm undiluted paint. Practical spreading rate depends on application method and conditions, shape and roughness of the surface.

Drying: (ČSN 673052)

120 µm WFT, temperature 23 ± 2°C, relative humidity 50 ± 5%, supply viscosity	surface dry (grade 1)	to touch (grade 3)	to manipulation (grade 4)
	40 minutes	1 hour	3 hours

Drying and recoatability time strongly depend on wet film thickness, temperature, humidity, ventilation and paint colour. Fully load and measure the coated film after 7 days, laboratory testing after 3 weeks of drying under the above conditions.

Gloss: (ČSN ISO 2813)

Gloss 80 GU, angle-wise 60°, supply viscosity

Supply viscosity:

Thixotropic liquid unmeasurable by ISO outflow cup type

VITON s.r.o.
Planá 90
370 01 České Budějovice
Czech republic
Issued: 23.02.2023



mobil: +42(0) 724 580 404
tel: +42(0) 381 581 022
objednavky@viton.cz
www.viton.cz



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Recommended dilution: (ČSN 673032)

	airless	brush/roller
thinner	water	water
by weight	not dilute	not dilute
by volume	not dilute	not dilute

Sagging: (ČSN EN ISO 16862)

temperature 23 ± 2°C, relative humidity 50 ± 5%	
supply viscosity	no sagging 300 µm WFT

Application conditions:

The surface must be dry and properly ungreased. The air, surface and paint temperature cannot decrease below +10°C during application and drying. Relative humidity cannot exceed 70%. The surface temperature must be at least 3°C above the dew point. In cold weather, it is advisable to make one very thin coat first to dry quickly.

Surface preparation:

Remove oil, grease, salt and other contamination from the surface with a suitable detergent according to ČSN EN ISO 12944-4. Use the highly effective ecological cleaner CL 07.

Steel surfaces: Abrasive blast-cleaning to Sa 2½, alternatively manual or mechanical cleaning to min. Sa 3 corresponding to ČSN EN ISO 8501-1. It is necessary to apply the paint in 2 layers, recommended dry film thickness (DFT) is 80-120 µm.

Stainless steel surfaces: For reaching the required roughness use mechanical or manual sanding. Clean the surface with a ecological cleaner CL 07.

Galvanized surfaces: For reaching the required adhesion of the paint to the new hot-dip galvanized surfaces, the surface must be treated with a solution of ammonia water, which is prepared by mixing 5l of water, 0,25l of ammonia water (25% concentration) and 25ml of detergent. The surface is washed with the prepared solution until a gray foam is formed. This is followed by washing the foam off with the clean water. The paint can be applied after the surface is completely dry. When using this method the paint can be applied directly to the new hot-dip galvanized surface without a base paint.

For galvanized and older hot-dip galvanized surfaces, the required adhesion of the paint is fixed by manual roughening and subsequent washing with the ecological cleaning agent CL 07.

Titanium zinc surfaces: Remove dirt and residues of loose old paint. Degrease the surface with CL 07 eco-friendly cleaner solution, rinse with water and allow to dry thoroughly.

Aluminium surfaces: For reaching the required roughness use the sweeping method by a non-metallic abrasive, alternatively mechanical sanding. At least clean the surface with a ecological cleaner CL 07.

Copper surfaces: Use a manual sanding for reaching the required roughness and wash the surface with a ecological cleaner CL 07. If you use the pickling method for the surface treatment, the surface must be passivated then.

Previously painted surfaces: Remove oil, grease, salt and other contamination from the surface with a ecological cleaner CL 07, sanding of the surface recommended. Observe the compatibility of preceding and subsequent coats.

Wooden surfaces: The surface must be dry and cleaned of contamination, wax, grease, flaking and incoherent material. Fill cracks and holes with a stopper on wood. Sand all filled and glossy surfaces. Remove the residual dust by vacuum cleaning. In case of increased risks apply an insecticidal and an antifungal agent. As a renovation coating apply one or two layers of paint, as a priming coat of uncoated wood apply two or three layers according to the structure of wood. For reaching the highest quality gently sand the surface with a sandpaper Nr. 240 after every coat. If HAE 34 is applied on wood as a new coating, it is advisable to apply one layer

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of HAE 34 as a penetration layer, diluted 2:1 with water.

Mineral surfaces: Remove oil, grease, salt and other contamination from the surface with a suitable detergent, sanding or blast cleaning as needed. Remove the residual grit by brushing or vacuum cleaning. Use RK 975 STOPPER for touch-up repairs, leveling and smoothing of the surface. In case of highly strained systems it is necessary to test the solidity of the mineral surface. Observe the compatibility of preceding and subsequent paints when renovating previously painted surfaces. If HAE 34 is applied on mineral substrates as a new coating, it is advisable to apply one layer of HAE 34 as a penetration layer, diluted 2:1 with water. Subsequently, it is necessary to apply 2 layers (without counting the diluted penetration layer).

Plastic surfaces: For reaching the required roughness use the sweeping method by a non-metallic abrasive, alternatively mechanical sanding. At least clean the surface with a ecological cleaner CL 07.

Application method:

Spray guns, brush, roller. For airless spraying use the nozzle orifice of \varnothing 0.011" - 0.021", nozzle pressure: 120 - 180 bar, adjust the angle of application to the shape of the surface. For spraying use the nozzle orifice of 1.5 - 2 mm, nozzle pressure: 3 - 4 bar. For application by brush/roller select appropriate equipment according to the paint type and viscosity.

Storage:

In the original unopened packaging at temperatures between +5°C and +25°C. Cannot freeze!

Packaging in kg:

0,7; 3; 10

Packaging of base 0100 in kg:

0,7; 3; 10

Packaging of base 0000 in kg:

0,63; 2,7; 9

Notes:

DFT - dry film thickness
WFT - wet film thickness

MS - medium dry matter
HS - high dry matter

GU - Gloss Unit
KU - Krebs unit of viscosity

All information given in this technical data sheet are based on our best knowledge, laboratory test results and practical experience to the date specified below. According to the fact that the conditions of the product's use are out of our control, we can only guarantee the product quality itself. As a producer we cannot be responsible for damage arising from the use of the products without following above recommended instructions or for improper purposes. We reserve the right to change above specified information without prior notice. Always request the actual version of the product data sheet. This technical data sheet replaces all previously released. The validity of the data provided here will be terminated automatically after five years.