

# WARNEX: enhancing textures

## TEXTURE FORMING:

The "spattered texture" is the result of 2 coatings which are applied 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:

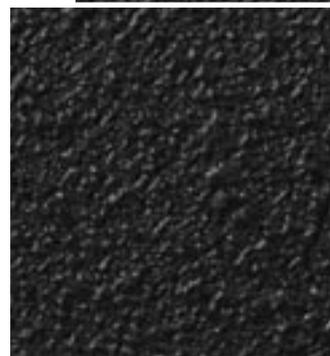
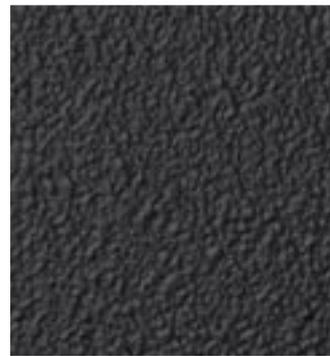
At room temperature:

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 <sup>2</sup> /kg (70 µm, base coating) 3,2 m <sup>2</sup> /kg (120 µm, total coating)	
Practical average covering rate	1,5 m <sup>2</sup> /kg for Loudspeaker cabinets	
VOC-rate Ø	160 g/l	
Specific gravity	1,15 – 1,20 g/cm <sup>3</sup>	
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	
nozzle 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

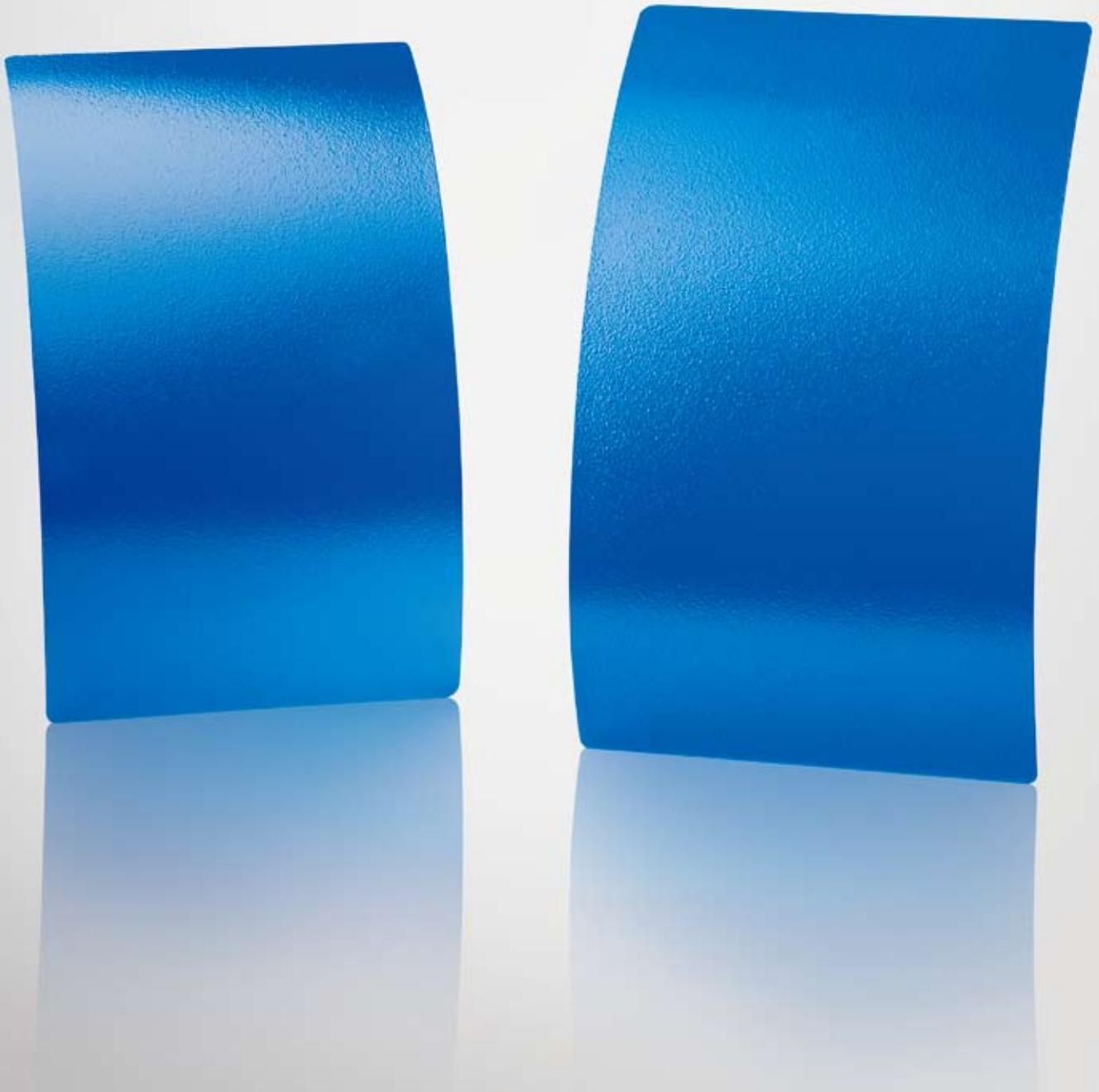
Frost free, max. 12 months in original unopened containers.



Warnecke & Böhm

## TEXTURE PAINTS

For all surfaces. For all applications. For products which inspire.



It is enthusiasm which has allowed us to grow for 125 years. Enthusiasm for our work. And for our tasks. The result of this work is innovative paints which finish their products in increasingly new and fascinating ways.

Our enthusiasm has resulted in **pioneering innovations** – such as the hammertone paint which was developed in our plant in Schliersee at the start of the fifties, the one-coat PUR texture paint 2c, which was pioneering in its application on plastic and metal undercoats, and the first fully functional UHS system with which we started the 21st century.

With its own developments such as these Warnecke & Böhm succeeded in developing a **complete product range** of conventional, waterborne, high-solid and ultra-high-solid paint systems. At the same time we have constantly contributed towards improving production processes and in so doing increased efficiency and environmental sustainability.

**“Worldwide service and worldwide instruction”** is the third supporting pillar of our company. For with our services we also provide you with all of our experience and our knowledge locally, i.e. at your production site. After you have become acquainted with the three supporting pillars of our company, we would like to introduce you on the following pages to the products and services of Warnecke & Böhm in detail. They are the result of these pillars and our high quality standards. We would be pleased if our paints inspire you as much as the enthusiasm with which they were developed!



Tailor-made solutions.  
For any task. For any company.

Tradition and development, economy and ecology: supposed opposites, yet not for us. For in the history of Warnecke & Böhm the focus has been and still is on combining these two catchwords. A combination which is distinguished by the highest quality and reliability and is always measured against the expectations of our customers. As a specialist in texture paints, as a reliable business friend and as a long-term partner we make the needs of our customers our business. Into each solution, which we develop specifically for our customers, flow the widely diverse know-how and the experience of a company with a long tradition.

Each solution is a tailor-made example of craftsmanship for a specific application in an individual company.

Warnecke & Böhm provides modern industrial companies with a wide range of products of conventional 1c and 2c paints and waterborne paints which are suitable even for extreme demands. Our comprehensive quality management gives you as our customer added security.



All Warnecke & Böhm products, processes and services meet the highest standards and are certified in accordance with DIN EN ISO 9001: 2000 (reg. no. 1830515).

# METAL & PLASTIC

Textures which inspire.



You can choose from conventional high-solid texture paints to waterborne paints. VOC and RoHS compliant.

### High-performance individualists.

Whether steel, non-ferrous metal or plastic:  
With texture paints a special effect can be achieved on any surface. They underline the design of a product and show it in a new, fascinating light. Texture paints are available from fine to coarse grain, open "spattered texture", closed surface structures and the especially pleasant non-slip fine structures.

### Powerful protectors.

As surface protection texture paints are virtually unbeatable. The high solid content not only compensates for unevenness in the undercoat, but guarantees the formation of an excellent protective coat.

### Clever performer.

Even on extremely rough undercoats, texture paints reduce time-consuming filling and sanding. Virtually any product and any surface can be turned into an eyecatcher. With closed structures a single operation is enough.

### A convincing system: time-saving industrial paints.

The time-saving industrial paint system from Warnecke & Böhm combines extremely resilient quality with versatile applications. All system or single coat applications are individually matched to the individual work process and achieve high-quality textured surfaces with impressive effects.

### Four impressive benefits. For numerous applications.

We provide highly durable paint coats in fine(st) and coarse grain structures on steel, non-ferrous metals, plastics and wooden materials.

### They can be used

- in only one operation,
- without any time-consuming preparation,
- without any smoothing with fillers and
- without sanding

### WB products at a glance

Conventional paint systems • Smoothing with fillers • Filler 2c • Primer and Primer 1c and 2c • Texture paints 2c • Smooth point 2c • HS • UHS • PUR PLUS texture paint • Waterborne paint systems • Primers 1c and 2c • AQUAPUR texture paint 2c • AQUAPUR top coat 2c

# WOOD & MDF

Simplicity which inspires.



With a musical event every detail counts. Even the design of a loud speaker.

WARNEX texture paints add a special touch to special musical events. The high-quality fine or coarse grain textures turn loudspeaker cabinets into virtually unseen perfectionists.

The WARNEX system was designed specifically for the professional music industry. As it fits into almost any design of room, is robust enough for tours and can also be easily repaired, this product range is currently considered the most impressive. The CINEMA OVERCOAT for example possesses low-reflection properties for cinema installation.

Like all of our paints, WARNEX texture paints were also developed in accordance with stringent quality criteria. They provide sure protection against surface damage and minimise manufacturing costs with simple and rational paint processes.

The user-friendly 1-component WARNEX is

- air drying and is therefore easy to apply and saves time and space
- water thinning and therefore environmentally friendly
- two products in one: finish and surface protection

## WB products at a glance

Smoothing with fillers • Primer and Primer 1c and 2c • PUR PLUS texture paint • AQUAPUR texture paint 2c • Clear coat • Primer 1c and 2c • WARNEX texture paint 1c

# GLASS

Simplicity which inspires.



Ideal accompaniment for glass, porcelain and ceramic: organic coats are perfectly suited to flowing forms, transparency and simplicity.

Whether drinking glasses, bowls, plates, vases, bottles or lights: coatings for these and many other everyday objects have to be true allrounders. Decorative. Safe for food. Pose no threat to health. And not sensitive to a range of external influences. Our waterborne paints offer a wide range of colours. Their effects become exciting, creative design elements. They are above all suitable for the production of exclusive series in small quantities and high-quality prototypes. For laboratory glass coating and similar products we also provide a special hydro glaze with a UV filter.

The quality features of water-based allrounders.

Our organic hydro coatings meet the stringent food law quality standards and are suitable for the most diverse applications. All hydro coatings are

- cadmium, lead and formaldehyde-free
- safe for food
- extremely hard, with a tough elastic surface

- long-term temperature resistant to 110 °C
- very alkali and acid resistant
- very solvent resistant
- washing machine resistant
- sterilisable (134 °C, 2 Bar, 20 min)
- filler resistant in accordance with DIN 16524 (with the exception of phenol)
- extreme non-fade
- low temperature crosslinking at 170 °C
- versatile with respect to the selection of colours and effects

Gloss or matt: brilliant appearance for cosmetic bottles.

For cosmetic bottle coating we have developed our own water-based organic coats. Their properties and their range of colours and effects make them ideal specialists.

We are happy to test the resistance of specific or new fillers for which there is as yet no experience.



WB products at a glance  
hydro glass coating • gloss • matt

# LABORATORY & DEVELOPMENT

Progress which inspires.



Continuous innovation and high environmental awareness form a strong base which distinguishes every product from Warnecke & Böhm.

Innovation for us means continuously finding new applications and creating new effects. Innovation starts with listening to our customers. Making their needs our business. And developing solutions which best meet these expectations. Regardless of whether they are looking for an efficient solution for the surface of a highly sensitive medical device, whether they would like to finish their product with extravagant effects, or whether they desire surface protection which is safe and appealing, but at the same time easy-to-apply and cost-conscious.

Innovation is environmental awareness.

Progress for us means not only being ahead of the market. Progress also means thinking ahead and testing each of our manufacturing processes against strict

environmental standards. So that you can feel absolutely sure: when using our waterborne and high-solid industrial paints you not only remain below the legal limits of the stringent VOC directives, you are today also prepared for all of the directives and requirements which are expected in future.

Environmentally-friendly, VOC-compliant paints from Warnecke & Böhm

- Low polluting emissions
- Environmentally-friendly solvents and thinners
- Greatest possible safety in processing

# APPLICATION TECHNOLOGY & SERVICE

Collaboration based on trust which inspires.



We are our customers' partners. Partners experienced in providing assistance. Partners who provide customer-oriented service. Above all though partners for personal contact.

The start of a collaboration based on trust.

In order to provide you with a clear impression of our products and services our application engineers can demonstrate at your premises or in our own training laboratory selected problem solutions and products and impart to you in compact, practice-oriented training courses everything which is important to know when working with our paints.

Worldwide presence.

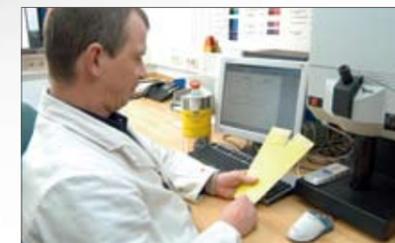
The sales consultants in our distribution network are at your disposal worldwide. Our application engineers are happy to come to your premises to provide application tests and training courses.

Service in all facets.

Our service includes a comprehensive selection of different colour systems such as

- RAL colour register including the RAL design system
- NCS colour system
- British Standard colour system
- MUNSSELL colour system
- as well as additional customer-specific company colour shades

Our PUR PLUS texture paint 2c is also available at short notice from stock in 130 RAL colour shades from the RAL colour register. And so that your entire colour needs can be met within the shortest time, Warnecke & Böhm's warehouse and logistics centre is extremely flexible and reliable. The goods leave our plant within a few days and are then delivered worldwide by reliable logistics partners.



# DISTRIBUTION NETWORK

Contacts which connect.



Germany  
France  
Netherlands  
Great Britain  
Poland  
Italy  
Czech Republic  
Austria  
Slovakia



China  
South Korea  
Malaysia  
Singapore  
USA (California)

Personal contact is the linchpin for our individual products. All around the world.

Our distribution consists of three pillars.

In Germany you are supported by a team of six field representatives.

In France, Great Britain, Italy and Poland you are supported by representatives, in Singapore and South Korea by stock-holding dealers.

In the three countries Austria, the Czech Republic and China we work together with full-service dealers who hold stock and provide application-engineering support.

Our distribution activities are also supported by distribution warehouses in California, Singapore and Malaysia.

We are continuously developing our warehouse network in consultation and collaboration with our customers in order to be able to deliver in line with demand and at optimal cost.

A compelling location.



The region around the Schliersee, where we are located, is one of the most beautiful regions in Germany. Particularly our home in the middle of this idyllic landscape provides a compelling reason for us to treat nature responsibly. Processing high-quality raw materials in an environmentally-friendly, strictly-controlled manufacturing process is a firm part of our company philosophy. You can satisfy yourself of this at any time.

We look forward to your visit!

You can reach us directly via the A 8, taking the Weyarn exit. Munich Airport is around 100 kilometres and approximately one hour's drive away.



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Lack- und Farbenfabrik

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