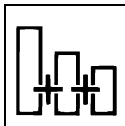




ISO55 (TK 550)

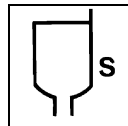
ISOFAN HS MATT TOP COAT

TK524 ISOFAN HS Rally Black MATT



1000 ml +
200 ml +
500-600 ml

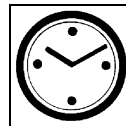
Pot life at 20° C: 3-4 h



18-20" DIN 4
at 20° C



Ø 1.2-1,4 mm
3.5-4 Atm
N° of coats: 1+1



Air drying at 20° C
Handling: 4 h
Through-drying: 7 days
Low bake at 60°C: 40 min.

DESCRIPTION

5:1 Two-pack acrylic HS topcoat with high aesthetical matt aspect.

USE

High solid topcoat for solid finishes of touch-ups and repainting of motorcycles, industrial vehicles, trucks, buses, cold stores, and general industry.

CHARACTERISTICS

- Excellent aesthetical aspect and uniform 10 gloss (60°)
- Easy application and excellent flow
- Good solids content
- Excellent light and weather resistance
- Good covering power
- Quick drying
- Good scratch resistance

SUBSTRATE PREPARATION

It can be applied on the following primers/fillers:

- ISO1 ISOFAN HS PRIMER in W/W and D/D system sanded with grit paper P320
- ISO2 ISOFAN HS SEALER in W/W and D/D system sanded with grit paper P320
- ISO3 ISOFAN HS FILLER
- LS109 (29109) ACRIPUR PRIMER
- LS107 (29107) EPOXYPRIMER
- 04384 EPOFAN PRIMER R-EC GRIGIO

APPLICATION

Spraying.

Mixing ratio:

by weight / volume

ISO55	ISOFAN HS MATT TOPCOAT (derived from binder TK550)	1000 parts
TH 810	HS STANDARD HARDENER or	200 parts
TH 815	HS FAST HARDENER	
00824 (Slow) – 00825 (Standard)	LECHSYS UNIVERSAL THINNERS	500 - 600 parts

Pot life at 20 °C: 3 h with TH 810
Spray viscosity at 20 °C: 18-20" DIN 4
Ø Air cap: conventional 1,4 mm; HVLP 1,2 – 1,4 mm
Air pressure: conventional 4 Atm; HVLP 3.5-4.0 Atm
N° of coats: 1+1
Recommended film thickness: 50 - 60 µ
Theoretical coverage: 1 kg of mixture = 6,5 - 7 m² at 50 µ

DIR 2004/42/CE: Special finishes IIB/e – VOC ready for use 840 g/l
This product ready for use contains at most 700 g/l VOC

DRYING TIME

Air drying at 20 °C

Dust-free: 20-25 min.
Handling: 4 h
Through-drying: 7 days

Low bake at 60°C

40 min. (after 30 min. flash-off at room temperature)

The complete hardening occurs in the following 3-4 days.
In winter low bake is recommended

OBSERVATIONS

In winter at low temperature and high humidity (T < 15°C) a considerable loss of gloss can occur in thin coat applications; this phenomenon can be observed after the first coat application during the flash-off. In this case proceed with the second coat application and allow to bake 30' at 60°C. After baking the film gets gloss and bright again.

In winter add 09167 SPEED-O-DRY ADDITIVE until max. 5% in order to speed up the air drying.

GLOSS TABLE TK550/TK400

Product code:	WEIGHT RATIO							
	1	2	3	4	5	6	7	8
% BINDER TK 550	60	55	52,5	50	60	50	40	30
% BINDER TK 400		5	7,5	10		10	20	30
% BLACK BASE MC 081	40	40	40	40				
% WHITE BASE MC 800					40	40	40	40
% HARDENER TH 810/815	20	20	25	25	20	20	25	30
% THINNER 00824/5	60	55	50	45	60	40	30	25
Gloss by 60^	12,5	31,7	60	75	3,5	9,5	65	94
Gloss by 85^	26	58	85	95	5,4	21	90	100

THE VALUES OBTAINED AND LISTED IN THE ABOVE TABLE ARE ONLY INDICATIONS

TECHNICAL DATA SHEET N° 0624-GB UPDATED 03/2009

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