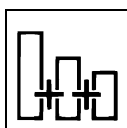
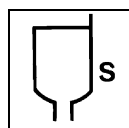


LS153 (29153) ACRYL 2 K MATT 7 GLOSS LS404 (29404) ACRYL 2K SATIN MATT LS405 (29405) ACRYL 2K SEMI GLOSSY LS406 (29406) ACRYL 2K GLOSSY

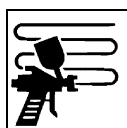


1000 ml +
200 ml +
350-400 ml

Pot life at 20° C:
4 hours



20-22" FC 4
at 20° C



Ø 1,4 mm
4 Atm
HVLP:
Ø 1,2-1,4 mm
2-2,5 Atm
N° coats 2



Air drying at 20° C
Handling: 6-8 hours
Through-drying: 48 h
Low bake at 60°C:
30 min.

DESCRIPTION

Two-pack acrylic enamel with direct adhesion to the substrate. It is available in different gloss levels.

USE

Suitable for painting metal and plastic substrates in the industrial field.

CHARACTERISTICS

- Uniform aspect
- Easy application
- Excellent appearance
- Good chemical resistance
- Very good adhesion on:
 - steel (the product does not contain any anticorrosive pigments: protection due to barrier-effect)
 - stainless steel
 - zinc coated steel (EG and HDG)
 - aluminium and its alloys
 - brass
 - zinc-aluminium-magnesium alloys
 - FGRP (polyester + fibreglass)
 - phenol and ureic resins
 - nylon (PA) *
 - polyurethane resin (PUR)

* Use the hardener 29343 LECHSYS ISOLACK ESP INDUSTRY HARDENER at the same quantity as of 29342 (20%).

SUBSTRATE PREPARATION

Steel, aluminium and its alloys, brass, and zinc-aluminium-magnesium alloys: Degrease with 00695 SILICONE REMOVER SLOW and slightly sand with Scotch Brite.

PRFV, phenolic and urea resins, PU and PA: Degrease with 00617 PLASTIC CLEANER.

APPLICATION

Spray.

Mixing ratio:

	weight and volume
LS153 ACRYL 2K MATT 7 GLOSS* (derived from binder 29153)	1000 parts
29342 LECHSYS ISOLACK ESP HARDENER or 29360 INDURITORE NG1 ** (hardener)	200 parts
00824 (Slow)-00825 (Standard) LECHSYS UNIVERSAL THINNER	350-400 parts

***The enamel part is the same for the products LS404 - LS405 - LS406**

**** See OBSERVATIONS**

Pot life at 20 °C: 4 hours

Spray viscosity at 20 °C: 20-22" FC 4

Ø Air cap: traditional 1,4 mm; HVLP 1,2-1,4 mm

Pressure: traditional 4 Atm; HVLP 2-2,5 Atm

N° of coats: 2

Flash-off between coats: 10-15 min. This time is indicative and will vary depending on application, spraygun set up, film thickness and the hardeners and thinners used. As a general rule observe the partial matting of the paint film before applying the following coat.

Suggested thickness: 25-30 µ

Theoretical coverage: 1 l of mixture = 14 m² at 30 µ; 1 kg of mixture = 12,5 m² at 30 µ

V.O.C. (on average) of product ready for use: ~ 500 g/l

DRYING

Air drying at 20°C

Dust-free: 30-40 min.

Handling: 6-8 hours

Through-drying: 48 hours

Low bake at 60°C

30 min. (after 30 min. flash-off at 20°C)

The curing continues for the following 3-4 days. The complete performance characteristics can be achieved after 15 days of air drying at 20°C.

OBSERVATIONS

In the Lechsys System TDS (n° 0389) a table shows in detail the mixing ratios to obtain the products LS404-LS405-LS406 with different gloss levels, achievable by mixing together the matt enamel LS153 ACRYL 2K MATT 7 GLOSS and the gloss enamel LS143 ACRYL 2K.

All colours applied with a 25-30 µ dry film thickness (2 coats) show a uniform gloss.

Low baking allows you to reach higher gloss levels.

To accelerate the product hardening in cold conditions, add 09167 SPEED-O-DRY ADDITIVE (max 5%).

N.B.: For production by mixing machine it is recommended to stir the product immediately after adding the tinters.

Colour formulations containing the tinters 29044 and 29046 must **ONLY** be used to paint substrates **NOT** directly exposed to sunlight.

In case of substrates exposed to sunlight, use alternative formulations (High Resistance or Ecological Formulations) available in Lechler MAP®.

The use of UV Plus Additive 33333 (up to 5% in the topcoat) allows you to further improve resistance to sunlight.

The virtual binder **29416 ACRYL 2K MATT GAR** is available to produce colours with higher opacity in the area of **YELLOWS, ORANGES** and **REDS**.

29360 INDURITORE NG1 is a hardener with free monomers <0.1% in compliance with the REACH restriction on the use of diisocyanates within the European Community (EU regulation 2020/1149). Special product available upon request.

MATT & GLOSS TABLE

The enamels of the Acryl 2K family are available in different gloss levels:

MATT 3/7 GLOSS	SEMI MATT 7/15 GLOSS	SATIN MATT 15/25 GLOSS	SEMI GLOSS 30/45 GLOSS	GLOSS 50/75 GLOSS	HIGH GLOSS ≥80 GLOSS
	LS153	LS404	LS405	LS406	LS143

TECHNICAL DATA SHEET N° 0485-GB
UPDATED 01/2022

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