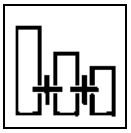
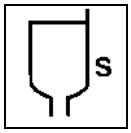
LS143 (29143)
ACRYL 2K



1000 ml +
250 ml +
300-500 ml

Pot life at 20° C:
4 h



15-16" DIN 4
at 20° C



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



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

DESCRIPTION

Two-pack acrylic enamel with direct adhesion to the substrate for internal and external use.

USE

Suitable for metal and plastic materials Industry.

CHARACTERISTICS

- Easy application
- Excellent appearance
- Good chemical resistance
- Very good scratch resistance
- Very good adhesion to:
  - steel (the product does not contain any anticorrosive pigments; protection due to barrier-effect)
  - stainless steel
  - zinc coated steel (EG and HDG)
  - aluminium and light alloys
  - brass
  - zinc alloys
  - FGRP (polyester + fibreglass)
  - phenolic resins and urea resins
  - nylon (PA) *
  - polyurethane resins (PUR)

* Use the hardener 29343 LECHSYS ISOLACK ESP INDUSTRY HARDENER at the same quantity as of 29342 (25%).

SUBSTRATE PREPARATION

Steel, aluminium and its alloys, brass, and zamac (zinc+aluminium+magnesium): degrease with 00695 SILICONE REMOVER SLOW and rub down with Scotch Brite.
PRFV, phenolic and urea resins, PU and PA: degrease with 00617 PLASTIC CLEANER .

APPLICATION

Spray.

Mixing ratio:

	weight and volume
LS143 ACRYL 2K (derived from binder 29143)	1000 parts
29342 LECHSYS ISOLACK HARDENER	250 parts
00824 (Slow) -00825 (Standard) LECHSYS UNIVERSAL THINNER	300 - 500 parts

Pot life at 20 °C: 4 hours
Spray viscosity at 20 °C: 15 - 16" DIN 4
Ø Air cap: 1.4 mm; HVLP 1.2 - 1.4 mm
Air pressure: 4 Atm; HVLP 2 - 2.5 Atm
Number of coats: 2
Film thickness: 25 - 30 µ
Theoretical coverage : 1 l mixture = 14 m² at 30 µ
1 kg mixture = 12,5 m² at 30 µ
V.O.C. (on average) of the product ready for use: ~ 520 g/l

DRYING TIME

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 20-30 min. flash-off at 20°C)

The complete hardening occurs in the following 3-4 days.

OBSERVATIONS

It is recommended to mix 1:1 29143 ACRYL 2K and 29157 ACRYL 1K for applications on rigid PVC, ABS and polymethyl methacrylate (Plexiglass) substrates. The mixture must be catalysed at 10% with 29342 LECHSYS ISOLACK ESP HARDENER.

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

N.B.: it is recommended to mix the product immediately after adding the base coats.

Colour formulations containing base colours 29044 and 29046 must be ONLY used on paint substrates NOT directly exposed to sunlight.
In case of substrates exposed to sunlight, use alternative formulations (High Resistance or Ecological Formulations) available on Lechler Explorer.
The use of UV Plus Additive 33333 (up to 5% in the topcoat) allows you to further improve resistance to sunlight.

TECHNICAL DATA SHEET N° 0397-GB
UPDATED 10/2012

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