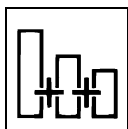
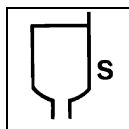


LS152 (29152) ACRYL 2K MATT



1000 ml +
200 ml +
350-400 ml

Pot life at 20° C:
4 h



15-16" FC 4
at 20° C



Ø 1,4 mm
4 bar
HVLP:
Ø 1,2-1,4 mm
2-2,5 bar
N° of 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 satin matt (15-35 gloss) acrylic enamel with direct adhesion to the substrate.

USE

Suitable for metal industry and plastics in general.

CHARACTERISTICS

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

* 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 zama (zinc+aluminium+magnesium): Degrease with 00695 SILICONE REMOVER SLOW and slightly sand with Scotch Brite.

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

APPLICATION

Spray.

Mixing ratio:

	weight and volume
LS152 ACRYL 2K MATT (derived from binder 29152)	1000 parts
29342 LECHSYS ISOLACK ESP HARDENER or	200 parts
29360 INDURITORE NG1 (hardener)	
00824 (Slow)-00825 (Standard) LECHSYS UNIVERSAL THINNER	350-400 parts

Pot life at 20 °C: 4 hours

Spray viscosity at 20°C: 15" - 16" FC 4

Ø Air cap: 1.4 mm; HVLP: 1.2 - 1.4 mm

Air pressure: 4 bar; HVLP: 2 - 2.5 bar

Number 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.

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: ~ 500 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 30 min. flash-off at room temperature)

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

NOTES

The gloss level is dependent on colour, application and drying methods.

Considering the following:

- A thicker film reaches higher gloss levels, a thinner film reaches lower gloss levels.
- Low baking allows you to reach higher gloss levels.
- Colour variations for any formulation will differ between gloss and matt within tolerance limits.

In order to obtain a higher gloss finish and to achieve a 20±5 gloss increase add 10% 29143 in place of 29152.

To accelerate the product hardening in the cold season, add 09167 SPEED-O-DRY (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° 0407-GB UPDATED 11/2019

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