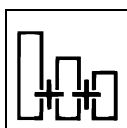
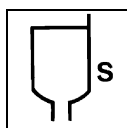


# LS153 (29153) ACRYL 2 K MATT 7 GLOSS LS404 (29404) ACRYL 2K SATIN MATT LS405 (29405) ACRYL 2K SEMI GLOSSY LS406 (29406) ACRYL 2K GLOSSY

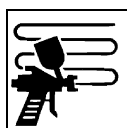


1000 ml +  
200 ml +  
350-400 ml

Pot life at 20° C:  
4 hours



20-22" FC 4  
at 20° C



Ø 1,4 mm  
4 Atm  
HVL P:  
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 .

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## 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**

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 m<sup>2</sup> at 30 µ

1 kg of mixture = 12,5 m<sup>2</sup> at 30 µ

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

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## 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.

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## NOTES

**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 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.

**MATT & GLOSS TABLE**

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

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

**TECHNICAL DATA SHEET N° 0485-GB**  
**UPDATED 11/2019**

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