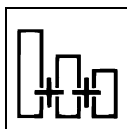
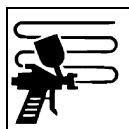


LS156 (29156) ACRYL 2K EFB



1000 ml +
200 ml +
0-300 ml

Pot life a 20° C:
4 h



Ø 1,4-2,5 mm
1-5 Atm
N° coats: 2
1st smooth effect
2nd orange peel effect



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 orange peel effect and direct adherence to the substrate.

USE

Suitable for machine tools, small metal parts and general ferrous substrates.

CHARACTERISTICS

- Easy application
- Excellent gloss
- Very good chemical and weather resistance
- Very hard film
- Very good adhesion to:
 - steel (the product does not contain any anticorrosive pigments, therefore it gives steel a protection due to barrier-effect)
 - stainless steel
 - zinc coated steel (EG and HDG)
 - aluminium and its alloys
 - brass
 - bronze
 - zamac (zinc+aluminium+magnesium)
 - FGRP (polyester + fibreglass)
 - phenol and urea resins
 - nylon (PA) *
 - polyurethane resin (PUR)

* Use the hardener 29343 LECHSYS ISOLACK ESP INDUSTRY HARDENER at the same weight.

SUBSTRATE PREPARATION

Steel, aluminium and its alloys, brass, and zamac (zinc+aluminium+magnesium): degrease with 00695 SILICONE REMOVER SLOW and rub with Scotch Brite.

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

APPLICATION

Spray.

Mixing ratio:

	weight	volume
LS156 ACRYL 2K EFB (derived from binder 29156)	1000 g	1000 ml
29342 LECHSYS ISOLACK ESP HARDENER or 29360 INDURITORE NG1	150 g	200 ml
00824 (Slow)-00825 (Standard) LECHSYS UNIVERSAL THINNER	0-250 g	0-300 ml

Pot life at 20 °C: 4 hours

Ø Air cap: 1.4 mm or more for spray guns with pressure cups
1.7 - 2.5 mm for gravity feed spray guns.

Air pressure: 1 - 2 Atm for coarse orange peel effect
4 - 5 Atm for thin orange peel effect.

Number of coats: 1st coat of product diluted at 25 - 30% (smooth effect).
2nd coat (after 15 min.) of product diluted at 0-5% to obtain the desired orange peel effect.

Suggested film thickness: 75 µ

Theoretical coverage: 1 l mixture = 7.5 - 8 m² at 75 µ
1 kg mixture = 6 - 6.5 m² at 75 µ

V.O.C. (on average) of the product ready for use: ~ 430 g/l

DRYING TIME

Air drying at 20°C

Dust-free: 20-30 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 complete hardening keep on in the following 3-4 days.

NOTES

For rigid PVC and ABS substrates a mixture 1:1 between ACRYL 2K and ACRYL 1K is recommended. 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%).

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° 0446-GB
UPDATED 11/2019

All information contained in this data sheet is the result of carefully controlled tests and is correct to the best of Lechler's knowledge at the time of issue. Since conditions of use are beyond the control of the manufacturer, information contained herein is without warranty, implied or otherwise, and final determination of the suitability of any information or material for the use contemplated and the manner of use is the sole responsibility of the user. FOR PROFESSIONAL USE ONLY.