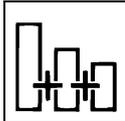


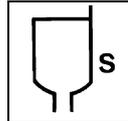
LS282 (29282) FRAMECOAT PVC

LS532 (29532) FRAMECOAT PVC TXT



1000 ml +
200 ml +
250-350 ml

Pot life at 20° C:
6 hours



20° FC 4
at 20° C



Ø 1,4 mm
4 Atm
HVLP:
Ø 1,2-1,4 mm
2-2,5 Atm
N° of coats: 2-3



Air drying at 20°C
Handling: 4-6 hours
Through-drying: 7 days
Low baking at 60°C:
60 min.

DESCRIPTION

Two-pack semi-gloss acrylic enamel (40-50 Gloss), with direct adhesion to PVC substrates.

USE

Painting of rigid PVC sections, PVC window frames, ABS and PC/ABS substrates and of the following types of aluminium and its alloys: Antikorodal alloy - Al 99.5.

CHARACTERISTICS

- Uniform aspect
- Easy to apply
- High weather resistance
- Excellent protective action on PVC exposed to the sun rays
- Excellent adhesion on PVC, ABS and PC/ABS and on the following types of aluminium and its alloys:
 - Antikorodal alloy
 - Al 99.5

SUBSTRATE PREPARATION

PVC, ABS and PC/ABS: degrease with 00617 PLASTIC CLEANER.

Due to the possible different composition of PVC substrates proposed by the market, it is recommended to always test adhesion possibly according to the Standard ASTM D 3359 (B), prior to proceeding with the final application.

Aluminium alloys: Degrease with 00695 SILICONE REMOVER SLOW and slightly sand with Scotch Brite or refer to the **Technical Instructions for the pre-treatment of metallic substrates and the like prior to painting, Light alloys, point 1**, available in the Lechsys Handbook.
For outdoor applications apply epoxy primers or wash primer.

APPLICATION

Spray.

Mixing ratio:

	weight and volume
LS282 FRAMECOAT PVC* (derived from binder 29282)	1000 parts
29342 LECHSYS ISOLACK ESP HARDENER or 29360 INDURITORE NG1 (hardener)	200 parts
00824 (Slow) -00825 (Standard) LECHSYS UNIVERSAL THINNER	250-350 parts

*The enamel part is the same for the virtual product LS532 FRAMECOAT PVC TXT

Pot life at 20 °C: 6 hours

Spray viscosity at 20 °C: 20" FC 4

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

Air pressure: conventional 4 Atm; HVLP 2-2,5 Atm

N° of coats: 2-3

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.

Recommended film thickness: 30 µ

Theoretical coverage: 1 l mixture = 8,5 m² at 30 µ

1 kg mixture = 7,5 m² at 30 µ

V.O.C. of the mixture ready for use: ~ 600 g/l

DRYING TIMES

Air drying at 20°C

Dust-free: 30 min.

Handling: 4-6 hours

Through-drying: 7 days

Low bake at 60°C

60 min. (after 20 min. flash-off)

The curing continues for the following 7 days.

OBSERVATIONS

The gloss level obtainable with LS282 is 40-50 Gloss.

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.

The product LS282 has also shown an excellent adhesion on the rubbed down and not rubbed down surface of the following types of aluminium and its alloys:

- Antikorodal alloy
- Al 99.5

The product LS282 does not contain anticorrosive pigments, therefore the application field for the painted manufactured item is critical: LS282 is compliant with painting profiles, handles, furniture components, window frames, but it is not compliant with painting large surfaces or panels constantly exposed outside such as cladding, or manufactured items related to heavy carpentry.

For manufactured items exposed outside in the Architectural field use colours available in "Manufacturer" => Architectural of Lechler MAP®.

For all other colours contact the Technical Assistance.

Avoid application on manufactured items to be placed in especially aggressive and contaminated environments such as marine and industrial.

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

The product FRAMECOAT PVC is available in two different gloss levels :

LS282 (29282) 40-50 Gloss

LS472 (29472) 20-25 Gloss

Texture effects can be obtained with the virtual enamel LS532 FRAMECOAT PVC TXT available in the “manufacturer” TEXTURE of the Software Lechler MAP®.

Preparation modes are indicated in detail in the specific TDS ADDITIVI TEXTURE LECHSYS n° 0722.

TECHNICAL DATA SHEET N° 0527-GB

UPDATED 11/2019

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