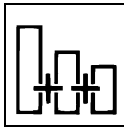
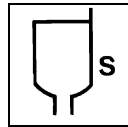


LS446 (29446) ACRYL 2K AC GLOSS



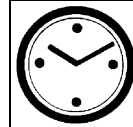
1000 g +
200-250 g +
100-250 g



25-35° FC 4
at 20°C



Ø 1,4-1,7 mm
N° coats: 2
Pressure: 2,0/3,0 Atm



Air drying at 20°C
Handling: 12 h
Through-drying: 24 h

Pot life at 20°C
1,5-2,5 h

Low baking:
60 min. at 60°C

DESCRIPTION

2K gloss acrylic topcoat (Gloss 85±10) with good anticorrosive properties and direct adhesion on steel, galvanised steel sheet, aluminium and its alloys.

USE

For painting metal industrial manufactured items, chassis and caissons of commercial and industrial vehicles.

CHARACTERISTICS

- Good chemical resistance.
- Easy application
- Very good adhesion on steel, cold and hot dip galvanized steel sheet, aluminium and its alloys
- Can be applied with AIRMIX and AIRLESS spray guns
- Gloss aspect
- Good scratch resistance

SUBSTRATE PREPARATION

Steel, galvanized steel sheet, aluminium and its alloys: Degreasing with 00695 SILICONE REMOVER SLOW followed by blowing.

See TECHNICAL INSTRUCTIONS: SUBSTRATE PREPARATION PRIOR TO PAINTING, available in the Lechsys Handbook.

APPLICATION

Spray

Mixing ratio:

	weight	volume
LS446 ACRYL 2K AC GLOSSY (derived from binder 29446)	1000	1000
29342 LECHSYS ISOLACK ESP HARDENER or 29360 INDURITORE NG1 (hardener)	200	250
00824 LECHSYS UNIVERSAL THINNER SLOW	100-150	200-350

Pot life at 20°C : 1,5 h (with hardener 29342)

Spray viscosity at 20 °C: 25-30° FC 4

Ø Air cap: 1,4 - 1,7 mm

Pressure: 2,0 - 3,0 Atm

N° of coats: 2

Recommended film thickness: 60 µ

Theoretical coverage: 1 l mixture = 6,5 m² at 60 µ

Airmix and Airless

Mixing ratio:

	weight	volume
LS446 ACRYL 2K AC GLOSSY (derived from binder 29446)	1000	1000
29346 LECHSYS ISOLACK AC HARDENER*	250	300
31490 DILUENTE LENTO*	150-250	200-300

*29346 – 31490: for 80-100 µ dry film thickness and for Airmix and Airless application

Pot life at 20°C : 2,5 h (with hardener 29346)

Spray viscosity at 20 °C: 30-35" FC 4

Ø Air cap: 9 – 11 micro inches with compression ratio from 20:1 to 50:1

Pressure in air cap: 80 to 150 Atm

N° of coats: 3-4

Flash-off between coats: at least 10 min.

Recommended film thickness: 80 µ

Theoretical coverage: 1 l mixture = 5,0 m² at 80 µ

Higher film thickness can be reached with more coats by increasing drying times.

DIR 2004/42/CE: Special finishes IIB/e – VOC ready for use 840 g/l

This product ready for use contains at most 486 g/l VOC

DRYING TIME

Air drying at 20°C:

Dust-free: 30-40 min.

Handling: 12 h

Through-drying: 24 h

Low bake with spray application:

Flash-off: 20°C for 20-30 minutes according to ventilation

Low baking: 60 min. at 60°C

Low bake with Airmix and Airless application:

Flash-off: 20°C for at least 2 h according to ventilation and applied film thickness

Low baking: 60 min. at 60°C

The curing continues in the following days.

NOTES

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 MAP®.

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

The family **ACRYL 2K AC** comprises the following products with different gloss levels:

LS441 (29441) ACRYL 2K AC SATIN MATT	Gloss 11 ± 4
LS443 (29443) ACRYL 2K AC	Gloss 70 ± 10
LS446 (29446) ACRYL 2K AC GLOSSY	Gloss 85 ± 10

TECHNICAL DATA SHEET N° 0707-GB

UPDATED 11/2019

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