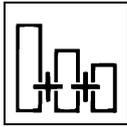
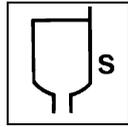


29152 - ACRYL 2K OPACO



1000 ml +
200 ml +
350-400 ml

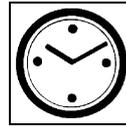
Pot-life at 20° C:
4 h



15-16" DIN 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 matt acrylic enamel with direct adhesion.

USE

Suitable for general painting in metal and plastic materials Industry.

CHARACTERISTICS

- Uniform satin aspect.
- Easy application
- Excellent appearance
- Good chemical resistance
- Very good scratch resistance
- 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 light alloys
 - brass
 - zinc-aluminium alloys
 - FGRP (polyester + fibreglass)
 - phenolic resins and urea resins
 - glass and ceramic
 - ABS
 - nylon (PA) *
 - polyurethane resins (PUR)

* Use the hardener 29343 ISOLACK INDURITORE ESP INDUSTRIA at the same weight.

N.B.: A preliminary test is always recommended. For applications on glass and ceramic it is essential to observe the relevant precautions. In case of steel outdoor exposed this product is not recommended as it has no anticorrosive power.

SUBSTRATE PREPARATION

Steel, aluminium and its alloys, brass, and zinc-aluminium alloys: degrease with 00695 SOLVENTE ANTISILICONE SLOW and rub with Scotch Brite.

PRFV, phenolic and urea resins, PU, ABS and PA: degrease with 00617 DILUENTE LV .

APPLICATION

Spray application

Mixing ratio:

	by weight and by volume
ACRYL 2K OPACO (enamel)	1000 parts
29342 ISOLACK INDURITORE ESP (hardener)	200 parts
00824-00825 LECHSYS DILUENTE UNIVERSALE (thinners) or 00740-1-2 DILUENTI AUTOREFINISHING	350 - 400 parts

Pot life at 20 °C: 4 hours

Spray viscosity at 20°C: 15" - 16" DIN 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

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:

60 min. (after 30 min. flash-off at room temperature)

The complete hardening occurs in the following 3-4 days.

NOTES

For rigid PVC substrates a mixture 1:1 between ACRYL 2K and ACRYL 1K is recommended. The mixture must be catalysed at 10% with 29342 ISOLACK INDURITORE ESP.

The mattness degree obtainable with 29152 is between 15-35 gloss according to the colour obtained, the application and drying methods.

Consider that:

- by thicker films you get glossier finishes, by thinner films you get matter finishes.
- If the drying time is accelerated by stoving (at the same film thickness) you get 15 ± 5 gloss glossier finishes.
- The colour variations you get with the same formulation turned from glossy into matt, are included in the tolerance of any modified top coat.

To obtain a glossier finishing coat increase the quantity of the binder 29143 instead of the matt binder 29152. With an increase of 29143 (10%) instead of matt binder 29152 you get a 20±5 gloss increase.

To accelerate the product's hardening in the cold season, add 09167 SPEED-O-DRY (max 5%).

The information shown in these sheets is given in good faith as being true and although every effort of verification has been made before use, we cannot accept responsibility for any inaccuracy. THIS PRODUCT IS FOR THE PROFESSIONAL PAINTING OF ROAD VEHICLES BY QUALIFIED PERSONNEL

TECHNICAL DATA SHEET N° 0407-GB
UP DATED 11/2004