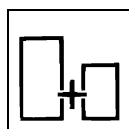
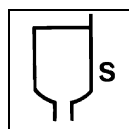


# LS157 (29157) ACRYL 1K



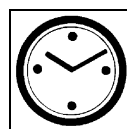
1000 ml +  
300-600 ml



16-18" FC 4  
at 20° C



Ø 1.4 mm  
4 Atm  
HVLP:  
Ø 1.2-1.4 mm  
2-2.5 mm  
N° of coats: 2



Air drying at 20°C  
Handling: 10 min.  
Through-drying: 4 h  
Low bake at 60°C:  
20 min.

## DESCRIPTION

1K acrylic enamel for gloss finishes.

## USE

Suitable for painting industrial manufactured items and especially for direct application onto PVC, ABS and rigid polystyrene (PS).

## CHARACTERISTICS

- Easy application
- Excellent appearance
- Very fast drying
- Excellent direct adhesion on PVC and ABS
- Direct adhesion on PS (no polystyrene foam) if diluted with specific thinner (00587 PS THINNER)
- Direct adhesion on methacrylate (Plexiglas), only after preliminary tests

## SUBSTRATE PREPARATION

**PVC/ABS/PS:** Degrease carefully with 00617 PLASTIC CLEANER.

**Steel and industrial manufactured items:** Apply in dry-on-dry system on epoxy primers.

## APPLICATION

Spraying.

### Mixing ratio

LS157 ACRYL 1K (derived from binder 29157)

00824 (Slow)-00825 (Standard) LECHSYS UNIVERSAL THINNERS or

00587 PS THINNER\* or

00602 PS THINNER EXTRA\*\*

### weight and volume

1000 parts

300-400 parts

500-600 parts

500-600 parts

\*Specific thinner for direct adhesion on PS

\*\*Specific thinner for direct adhesion on PS for extra-EEC countries only - Special product – Available upon request

Spray viscosity at 20°C: 16-18" FC 4

Recommended spray temperature: above 5°C under 30°C

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

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

Number of coats: 2

Suggested film thickness: 30-40 µ

Theoretical coverage: 1 l mixture: 6,6 m<sup>2</sup> at 40 μ  
1 kg mixture: 7 m<sup>2</sup> at 40 μ  
V.O.C. (on average) of the product ready for use (18-20" FC 4): ~ 670 g/l

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## DRYING TIME

### Air drying at 20°C:

Dust-free: 5-7 min.  
Handling: 10 min.  
Through-drying: 4 hours

### Low bake at 60°C:

20 min.

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## OBSERVATIONS

**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.

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## MATT & GLOSS TABLE

The enamels of the Acryl 1K family are available in different gloss levels:

MATT 3/7 GLOSS	SEMI MATT 7/15 GLOSS	SATIN MATT 15/25 GLOSS	SEMI GLOSS 30/45 GLOSS	GLOSS 50/75 GLOSS	HIGH GLOSS ≥80 GLOSS
	LS158	LS407	LS408	LS409	LS157

TECHNICAL DATA SHEET N° 0457-GB  
UPDATED 02/2020

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