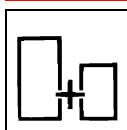


# LS158 (29158) ACRYL 1K MATT

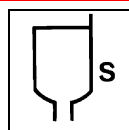
## LS407 (29407) ACRYL 1K SATIN MATT

## LS408 (29408) ACRYL 1K SEMI GLOSSY

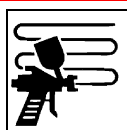
## LS409 (29409) ACRYL 1K GLOSSY



1000 ml +  
350-600 ml



18-20° FC 4  
at 20° C



Ø 1.4 mm  
4 Atm  
N° of coats: 2



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

### DESCRIPTION

One-pack acrylic enamel with different gloss levels.

### USE

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

### CHARACTERISTICS

- Easy application
- Very fast air drying
- Excellent appearance
- Very good direct adhesion to 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 D/D and W/W system on epoxy, epoxy-vinyl, epoxy-acryl and synthetic primers from the Lechsys range (except LS103 (29103) SYNTOPRIMER that gives an unstable adhesion to the topcoat overapplying).

### APPLICATION

Spray application.

#### Mixing ratio:

	weight and volume
LS158 ACRYL 1K MATT* (derived from binder 29158)	1000 parts
00824 (Slow)-00825 (Standard) LECHSYS UNIVERSAL THINNERS or	350-450 parts
00587 PS THINNER ** or	500-600 parts
00602 PS THINNER EXTRA***	500-600 parts

\*The enamel component is the same for the products LS407 – LS408 – LS409

\*\*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: 18-20" FC 4

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

Ø Air cap: 1,4 mm

Air pressure: 4 Atm

Number of coats: 2

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.

Suggested film thickness: 30-40 µ

Theoretical coverage: 1kg mixture = 7 m<sup>2</sup> at 40 µ

1 l mixture = 7,5 m<sup>2</sup> at 40 µ

V.O.C. (on average) of the product ready for use: ~ 650 g/l

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## DRYING TIME

### Air drying at 20°C

Dust-free: 5-7 min.

Handling: 10 min.

Through-drying: 4 h

### Low bake at 60°C:

20 min.

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## OBSERVATIONS

In the Lechsys System TDS (n° 0389) a table shows in detail the mixing ratios to obtain the products LS407 – LS408 – LS409 with different gloss levels, achievable by mixing together the matt enamel LS158 ACRYL 1K MATT and the gloss enamel LS157 ACRYL 1K.

**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° 0463-GB UPDATED 02/2020

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