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## TECHNICAL DATA SHEET

Product Name: **480 PREMIUM ENAMEL - Fast Air Drying Enamel**

Date of Issue: **June 2006**

### Description and uses

480 Premium Enamel is a fast air drying industrial enamel ideal for agricultural, industrial machinery and earthmoving equipment that require minimum maintenance down time and outstanding exterior durability and weathering.

480 Air Drying Enamel has the following features:

- High gloss retention (interior and exterior).
- Excellent water and yellowing resistance.
- Resistant to overcoating without any time constraints.
- Enhanced dry, gloss, durability and masking properties with addition of 298 Enamel Additive.
- Compatible with all Lacnam Primers

Typical areas of application are:

- Machinery, cranes, implements and forklifts.
- Structural steel etc.
- Trucks, tractors and trailers.

### Technical Specifications

FINISH: High gloss.

THINNERS: T102, T104 or T109 (or T124 for electrostatic application).

VOLUME SOLIDS: 35-40% depending on colour.

COVERAGE: Approximately 9-10 Square metres per litre (at a D.F.T. of 40 microns).

RECOMMENDED FILM THICKNESS: 25-40 microns dry.

APPLICATION: Conventional or airless spray.

DRYING AT 25°C: Tack free 1-2 hours

Recoat- after 2 hours

Hard dry- overnight

Note: If this product is to be used where masking up and repainting, or where quicker drying is required, the use of 298 Enamel Additive is recommended. Refer to technical data sheet for 298 Enamel Additive before use.

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APPLICATION DETAILS – PAINTING SYSTEMS			
D.F.T. um			
System 1	1 <sup>st</sup> Coat	50	210 Metalprime (thinner T102 or T104)
	2 <sup>nd</sup> Coat	25-40	480 Air Dry Enamel (thinner T102, T104 or T109)
	3 <sup>rd</sup> Coat	25-40	Optional

D.F.T. um			
System 2	1 <sup>st</sup> Coat	5-10	258 Twin Pack Etch or 260 Key-Coat (thinner T166)
	2 <sup>nd</sup> Coat	25-40	480 Air Dry Enamel (thinner T102, T104 or T109)
	3 <sup>rd</sup> Coat	25-40	Optional

D.F.T. um			
System 3	1 <sup>st</sup> Coat	5-10	722 Iso-Free Primer (thinner T154 or slow T156 or T159)
	2 <sup>nd</sup> Coat	25-40	480 Air Dry Enamel (thinner T102, T104 or T109)
	3 <sup>rd</sup> Coat	25-40	Optional

APPLICATION DETAILS – SURFACE PREPARATION		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 or abrasive blast clean to AS1627.4 Class 2	1 or 3
Aluminum and non-ferrous metals	Light abrasive blast or treat with 212 metal clean.	2 or 3
Previously painted surfaces	Lightly sand glossy areas, wash down with cleaning solvent.	2

**Note:** All surfaces to be painted should be clean and free from dust, dirt, oil, grease etc. All surfaces must be free of moisture and topcoat not applied when the substrate temperature is below 5°C.

### **Application**

**Conventional spray:** Thin approximately 20-25% with T102, T104 or T109. Apply 2 coats wet on wet, allowing 15 minutes between coats using 350-400 kPa atomizing pressure.

**Airless spray:** Thin approximately 50-10% with T102, T104 or T109, apply at approximately 15 mPa atomizing pressure.

**Clean up:** T104, T109 or Gun and Brush Wash.



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### **Safety Instructions**

Flammability: Highly flammable, avoid heat and sources of ignition. Container should be earthed when pouring.

Personal Protection: Avoid contact with skin or eyes, wear suitable clothing such as impervious overalls, PVC or neoprene gloves, safety goggles. Wear an approved half-face respirator suitable for organic vapor, meeting AS1715/1716.

Engineering controls: Ensure ventilation is adequate. When spraying, ensure product is applied in a fully functional spray-booth. Keep containers closed when not in use. Do not use near ignition sources.