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TECHNICAL DATA SHEET

Product Name: **820 ISO - FREE - Isocyanate Free Acrylic Finish**

Date of Issue: **June 2006**

Lacnam Paints Premium Two Pack Coating, 820 Iso-Free is user friendly and does not pose any health or environmental threat when used in accordance with Occupational Health guidelines.

820 Iso-Free provides outstanding durability and gloss retention, superior to two pack Polyurethane with prolonged exterior exposure.

Description and uses

820 Iso-Free is a Two pack Isocyanate Free catalysed acrylic topcoat which features:

- Superior exterior durability,
- Excellent gloss and colour retention,
- Unlimited recoatability,
- Tough finish with good chemical resistance,
- Flexible.

Typical areas of application are:

- Implements and farm machinery,
- Forklifts, tankers and trucks,
- Chemical plants, breweries, concrete floors,
- Industrial and mining equipment,
- Electrical generating equipment (eg PowerStation's).

Technical Specifications

FINISH: High gloss.

MIXING RATIO: Part A / Part B 4/1 by volume.

THINNERS: T154, T156, T159.

POT LIFE: 10-12 hours @ 25°C.

VOLUME SOLIDS: 40-45% (depending on colour).

COVERAGE: 8-9 Square metres per litre.

RECOMMENDED FILM THICKNESS: 50 microns dry.

APPLICATION: Brush, roller and spray.

DRYING AT 25°C: Touch dry – 30-60 minutes,

Recoat – 30 minutes,

Hard Dry – 24 hours (7 days for full cure).



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APPLICATION DETAILS – PAINTING SYSTEMS

D.F.T. um			
System 1	1 st Coat	50-75	280 Epoxy Primer (Thinner T180)
	2 nd Coat	50-75	820 Iso-Free (Thinner T154 or slow T156 or T159)
	3 rd Coat		Optional
D.F.T. um			
System 2	1 st Coat	50-75	722 Iso-Free Primer (Thinner T154 or slow T156 or T159)
	2 nd Coat	50-75	820 Iso-Free (Thinner T154 or slow T156 or T159)
	3 rd Coat		Optional
D.F.T. um			
System 3	1 st Coat	5-10	260 Key-Coat (Thinner T166)
	2 nd Coat	50-75	820 Iso-Free (Thinner T154 or slow T156 or T159)
	3 rd Coat		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 2.5		1 or 2
Aluminium, Galvanised steel or Zinc anneal	Light abrasive blast or treat with 212 Metal Clean		1, 2 or 3
Concrete and Masonry	New concrete must be fully cured. Light abrasive blast or acid etch		2
Fibreglass	Light sand and wash down with thinner or cleaning solvent		1 or 2
Previously painted surfaces	Lightly sand glossy areas, wash down with cleaning solvent		3

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.



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Application

Mix 820 Part A 4 parts with 820 Part B 1 part (4:1 by volume). Allow to stand for 20 minutes, then stir again before using.

Brush or Roller – Thinning not normally required

Conventional Spray – Thin approximately 20% and apply 2 coats wet on wet.

Airless Spray – Thin approximately 5-10% and apply.

Clean Up – T154 or T134 All Purpose Thinner.

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, and safety goggles. Wear an approved half-face respirator suitable for organic vapour, meeting AS 1715/1716.

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.