



**LACNAM PAINTS AUSTRALIA**

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## TECHNICAL INFORMATION SHEET

# 258 TWIN PACK ETCH

April 2009

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### Description and uses:

258 Twin Pack Etch is an etch primer based on zinc tetroxy chromate and poly vinyl butyrate resins and is used to provide protection and promote adhesion of various topcoats. 258 Twin Pack Etch has the following features:

- Suitable for coating mild steel, aluminum, galvanized iron, copper, brass etc.
- Can be topcoated with any Lacnam enamel, or 540 Polyurethane finish. (720 Iso-Free is not recommended over 258 Twin Pack Etch).

Typical areas of application are:

- Sign writing industry.
- Plant and machinery.
- Electronic equipment housing.

### Technical Specifications:

FINISH: Yellow transparent matt finish.

THINNERS: T166

VOLUME SOLIDS: Approximately 13% (when mixed).

COVERAGE: Approximately; 12-14 Square metres per litre (at a D.F.T. of 10 microns).

RECOMMENDED FILM THICKNESS: 10 microns.

APPLICATION: Conventional or airless spray.

DRYING AT 25°C / 50% Humidity: Touch dry - 5 minutes

Handle - 20 minutes

Recoat - minimum 30 minutes, maximum 8 hours

Hard dry - 30 minutes

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APPLICATION DETAILS – PAINTING SYSTEMS			
D.F.T. um			
System 1	1 <sup>st</sup> Coat	5-10	258 Twin Pack Etch (Thinner T166)
	2 <sup>nd</sup> Coat	50-75	Any Lacnam Enamel or 540 Polyurethane Finishes.

D.F.T. um			
System 2	1 <sup>st</sup> Coat	5-10	258 Twin Pack Etch (Thinner T166)
	2 <sup>nd</sup> Coat	50-75	280 Epoxy Primer (Thinner T180)
	3 <sup>rd</sup> Coat	50-75	540, 720 Two-pack topcoat (Thinner T154 or slow T156 or T159)

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	2
Aluminum and non-ferrous metals	Light abrasive blast or treat with 212 metal clean.	1

## Surface Preparation:

- When overcoating; Aged paint coatings should be tested for adhesion using Crosshatch or Crosscut methods. If aged paint coating lifts remove it.
- Remove all rust, oxides, mill-scale and loose paint from metal surface.
- Round off all sharp edges, welding joints and weld spatter.
- All surfaces to be painted should be clean and free from dust, dirt, oil, grease and moisture.
- All abrasive blast clean ferrous surfaces should be coated within 4 hours to avoid flash rusting.
- Do not apply at temperatures below 5° Celsius. Do not apply at relative humidity above 85%, or when the substrate surface is less than 3° Celsius above dewpoint.

## Equipment Application: (Conventional or Airless Spray Recommended).

As a Guide Use:

Conventional Spray - 1.3 -2.0mm tip (or equivalent). Pressure pot set at 55 - 100kpa (8 - 15psi) and maintain gun air pressure 275 - 380kpa (40 -55psi).

Airless Spray - Use heavy-duty airless spray with 10 -15 “(0.25 – 0.38mm) plus tip and pump ratio 30:1

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## Application Thinning:

Thinning: Dry film thickness of 5-10 microns is required, thin 15-25% with T166 thinner. Increase or decrease thinner as required to suit gun setup.

Conventional or airless spray: Thin as suggested and apply a smooth wet film.

**Note:** Poor adhesion may result if:

- (1) Etch is applied over damp surfaces.
- (2) Recoating times are not adhered to.
- (3) A dry coat is applied instead of a wet smooth coat.
- (4) Film thickness is greater than 5-10 microns on non-ferrous metals.

## Safety Instructions:

**Storage:** Store in a cool, dry banded area out of direct sunlight as required for Flammable liquids DG Class 3, PG II, Hazchem 3(Y)E.

**Flammability:** Highly flammable, all sources of ignition must be eliminated in or near area of use, on burning fumes emitted are toxic. Do not smoke in immediate area.

**Handling:** Adopt adequate Occupational Work Practices to avoid personal contamination with product. Always wash hands before smoking, eating, drinking or using toilet. Food and Drink should be to stored and consumed in separate area.

**Personal Protection:** Avoid contact with skin or eyes; wear suitable clothing such as impervious overalls, PVC or neoprene gloves, safety goggles and face mask.

**Using:** Avoid inhalation of spray mist and vapours – use with adequate ventilation and suitable Personal Protection Equipment (PPE).

**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.

### REFER MSDS BEFORE USE

(Phone 02 9688 1999 or refer to [www.lacnam.com.au](http://www.lacnam.com.au) for copy MSDS)

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