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TECHNICAL INFORMATION SHEET

724 ISO-FREE

Isocyanate Free Acrylic High Primer

For some time now, two-pack epoxy primers have been used under two-pack finishes to withstand aggressive environments and to protect various substrates, especially in the machinery and protective coatings market for a longer period than one component systems. Lacnam Paints objective was to develop alternative technologies and produce a two-pack primer which is less harmful to the environment and ecology.

May 2009

TDS 724 page 1 of 4

Description and uses:

724 Iso-free High Build is a two-pack amine-epoxy functional acrylic zinc phosphate primer with the following features:

- Fast curing
- Suitable for epoxy, polyurethane iso-free topcoats
- Excellent adhesion to most substrates
- Good sanding properties
- Good gloss hold-out

Typical areas of application are:

- Implements, materials handling industry
- Marine coatings.
- Chemical and petroleum industry
- Industrial and mining equipment

Technical Specifications:

FINISH: Matt Buff Colour.

MIXING RATIO: Part A / Part B 3/1 (Volume).

THINNERS: T154, T156, T159.

POT LIFE: 10-12 hours @ 25°C.

VOLUME SOLIDS: 60%.

VOC: 395gm/ltr mixed.

COVERAGE: 6 - 8 Square metres per litre.

RECOMMENDED FILM THICKNESS: 100 microns dry.

APPLICATION: Brush, Roller and Spray.

724 ISO-FREE

May 2009

TDS 724 page 2 of 4

Technical Specifications:

Cure: (25°C & 50% Humidity) at 100 micron DFT.

Touch
60 minutes

Hard dry
24 Hours

Full Cure
7 Days

Recoat: (25°C & 50% Humidity).

Enamel
Min 6 Hours (preferably o'night)
Max 36 Hours

2 Pack (A & B)
6 Hours (preferably o'night)
28 Days

Itself
6 Hours
28 Days

The above recoat times are a guide only as factors such as thinners used, film thickness, ventilation, substrate temperature etc need to be taken into account. Ensure 724 High Build Primer is free of contaminants before overcoating, clean with T192 (Wax & Grease Remover).

Overcoating after the suggested maximum time could reduce inter-coat adhesion between coats. Abrade and clean 724 High Build Primer surface with T192 (Wax & Grease Remover) before overcoating.

APPLICATION DETAILS – PAINTING SYSTEMS

D.F.T. um			
System 1	1 st Coat	90-110	724 Iso-Free High Build Primer (Thinner T154 or slow T156 or T159)
	2 nd Coat	50-75	720 Iso-Free (Thinner T154 or slow T156 or T159)
	3 rd Coat		Optional

D.F.T. um			
System 2	1 st Coat	90-110	724 Iso-Free High Build Primer (Thinner T154 or slow T156 or T159)
	2 nd Coat	50-75	540 Polyurethane (Thinner T150 or T152)
	3 rd Coat		Optional

D.F.T. um			
System 3	1 st Coat	90-110	724 Iso-Free High Build Primer (Thinner T154 or slow T156 or T159)
	2 nd Coat	50-75	390 or 480 enamel with 298 enamel additive (Thinner T102 or T104)
	3 rd Coat		Optional

724 ISO-FREE

May 2009

TDS 724 page 3 of 4

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, 2 or 3
Aluminum, Galvanized 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	1, 2 or 3
Fibreglass	Light sand and wash down with thinner or cleaning solvent	1, 2 or 3
Previously Painted Surfaces	Lightly sand glossy areas, wash down with cleaning solvent	1, 2 or 3

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, millscale 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.
- Applied 724 Iso - Free high Build Primer coat subjected to exterior exposure for extended period of time should be accessed for "Chalking" before applying suitable topcoat to achieve optimum inter-coat adhesion.

Equipment Application: (Conventional or Airless Spray Recommended).

As a Guide Use:

Brush or Roller - Suitable for small areas only.

Conventional Spray - 1.5 -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

724 ISO-FREE

May 2009

TDS 724 page 4 of 4

Application Thinner:

Mix 724 "Part A" 3 to 1 with 724 "Part B", allow to stand for 20 minutes. Then stir again before using.

Brush or Roller - Suitable for small areas only; May require Slow or Retarding Thinners (T159 / T122), to improve brushability. Thin initially 5%, and then increase to suit.

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:

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 for copy MSDS)

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