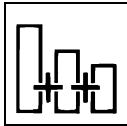
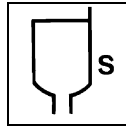


## 29143 - ACRYL 2K



1000 ml +  
250 ml +  
300-500 ml

Pot-life at 20° C:  
4 h



15-16" DIN 4  
at 20° C



Ø 1,4 mm  
4 bar  
HVLP:  
Ø 1,2-1,4 mm  
2,2,5 bar  
N. of coats: 2



Air drying at 20° C  
Handling: 6-8 h  
Through-drying: 48 h  
Low bake at 60°C:  
30 min.

### DESCRIPTION

Two-pack acrylic enamel with direct adhesion to the substrate.

### USE

Suitable for metal and plastic materials Industry.

### CHARACTERISTICS

- Easy application
- Excellent appearance
- Good chemical resistance
- Very good scratch resistance
- Very good adhesion to:
  - steel (the product does not contain any anticorrosive pigments, therefore it gives steel a protection due to barrier-effect)
  - stainless steel
  - zinc coated steel (EG and HDG)
  - aluminium and light alloys
  - brass
  - zinc alloys
  - FGRP (polyester + fibreglass)
  - phenolic resins and urea resins
  - glass and ceramic
  - ABS
  - nylon (PA) \*
  - polyurethane resins (PUR)

\* Use the hardener 29343 ISOLACK INDURITORE ESP INDUSTRIA at the same weight.

N.B.: a preliminary test is recommended. For the application on glass and ceramic it is necessary to observe the relevant precautions. In case of steel outdoor exposed this product is not recommended as it has no anticorrosive power.

### SUBSTRATE PREPARATION

**Steel, aluminium and its alloys, brass, and zinc-aluminium alloys:** degrease with 00695 SOLVENTE ANTISILICONE SLOW and rub with Scotch Brite.

**PRFV, phenolic and urea resins, PU, ABS and PA:** degrease with 00617 DILUENTE LV .

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## APPLICATION

Spray application.

### Mixing ratio:

ACRYL 2K  
29342 ISOLACK INDURITORE (hardener)  
00825 DILUENTE UNIVERSALE LECHSYS (thinner) or  
00824 DILUENTE UNIVERSALE LECHSYS LENTO or  
00740-1-2 DILUENTI AUTOREFINISH

### by weight and by volume

1000 parts  
250 parts  
300 - 500 parts

Pot-life at 20 °C: 4 hours  
Spray viscosity at 20 °C: 15 - 16" DIN 4  
Ø Ari cap: 1.4 mm; HVLP 1.2 - 1.4 mm  
Air pressure: 4 bar; HVLP 2 - 2.5 bar  
Number of coats: 2  
Film thickness: 25 - 30 µ  
Theoretical coverage : 1 l mixture = 14 m<sup>2</sup> at 30 µ  
1 kg mixture = 12,5 m<sup>2</sup> at 30 µ  
V.O.C. (on average) of the product ready for use: ~ 520 g/l

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## DRYING TIME

### Air drying at 20 °C

Dust-free: 30-40 min.  
Handling: 6-8 hours  
Through-drying: 48 hours

### Low bake at 60 °C:

30 min. (after 20-30 min. flash-off at 20°C)

The complete hardening occurs in the following 3-4 days.

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## OBSERVATIONS

For rigid PVC substrates a mixture 1:1 between ACRYL 2K and ACRYL 1K is recommended. The mixture must be catalysed at 10% with 29342 ISOLACK INDURITORE ESP.

To accelerate the product's hardening in the cold season, add 09167 SPEED-O-DRY (max 5%).

**N.B.: it is recommended to mix the product immediately after adding the base coats.**

TECHNICAL DATA SHEET N° 0397-GB  
UP DATED 11/2004

The information shown in these sheets is given in good faith as being true and although every effort of verification has been made before use, we cannot accept responsibility for any inaccuracy. THIS PRODUCT IS FOR THE PROFESSIONAL PAINTING OF ROAD VEHICLES BY QUALIFIED PERSONNEL