

## TECHNICAL INFORMATION SHEET

### 540 POLYURETHANE Isocyanate Cured Acrylic Finish

*Hydroxy functional acrylic resins are designed to cross-link at room temperature with polyisocyanates. Resistant films are quickly formed avoiding the necessity of providing stoving facilities. It also allows the end user to coat articles which are too big to be stoved, or which are sensitive to heat. These high performance coatings are suitable for a wide range of applications.*

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#### **Description and uses:**

540 Polyurethane is a two-pack acrylic modified urethane topcoat with the following features:

- Excellent durability
- Excellent gloss and colour retention
- Recoatable with minimum surface preparation
- Tough finish with good chemical resistance.
- Non-yellowing coating.

Typical areas of application are:

- Implements and farm machinery.
- Forklifts, tankers and trucks.
- Chemical and petroleum industry.
- Industrial and mining equipment.

#### **Technical Specifications:**

FINISH: High gloss

MIXING RATIO: Part A / Part B 4/1 (Volume).

THINNERS: T150 or T152.

POT LIFE: 2.0 - 4.0 hours @ 25°C.

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

VOC: 480gm/ltr. (White).

COVERAGE: 8 - 9 Square metres per litre.

RECOMMENDED FILM THICKNESS: 50 microns dry.

APPLICATION: Brush, Roller and Spray.

DRYING AT 25°C / 50% Humidity: Touch dry: 30 - 60 minutes

Recoat: 8 hours

Hard dry: 24 Hours (7 days for full cure)

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<b>APPLICATION DETAILS – PAINTING SYSTEMS</b>			
D.F.T. um			
System 1	1 <sup>st</sup> Coat	50 - 75	284 Epoxy Primer (Thinner T180)
	2 <sup>nd</sup> Coat	50 - 75	540 Polyurethane (Thinner T150 or slow T152)
	3 <sup>rd</sup> Coat	50 - 75	Optional: 540 Polyurethane (Thinner T150 or slow T152)

D.F.T. um			
System 2	1 <sup>st</sup> Coat	50-75	722 Iso-Free Primer (Thinner T154, T156 or T159)
	2 <sup>nd</sup> Coat	50-75	540 Polyurethane (Thinner T150 or slow T152)
	3 <sup>rd</sup> Coat	50-75	Optional: 540 Polyurethane (Thinner T150 or slow T152)

D.F.T. um			
System 3	1 <sup>st</sup> Coat	5-10	260 Keycoat Etch/Primer (Thinner T166)
	2 <sup>nd</sup> Coat	50-75	540 Polyurethane (Thinner T150 or slow T152)
	3 <sup>rd</sup> Coat	50-75	Optional: 540 Polyurethane (Thinner T150 or slow T152)

<b>APPLICATION DETAILS – SURFACE PREPARATION</b>		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 Or abrasive blast clean to AS1627.4 Class 2.5 or treat with 212 Metal Clean	1 or 2
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 Thin first coat 30% with T180	2
Previously Painted Surfaces	Lightly sand glossy areas, wash down with cleaning solvent	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 dew point.

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

As a Guide Use:

**Brush or Roller** - Suitable for small areas only.

**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

**Application:**

Mix 540 “Part A” equal parts with 540 “Part B” (Ratio 4:1). Allow to stand for 10 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:**

**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 SDS BEFORE USE**

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

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