

TECHNICAL INFORMATION SHEET

720 ISO-FREE Isocyanate Free Acrylic Finish

For many years two-pack coatings have essentially been restricted to the well-known polyurethane and epoxy coatings. With government regulations becoming more stringent, Lacnam Paints have developed a non-toxic two-pack isocyanate free paint system incorporating Lacnam 722 Iso-Free Primer and 720 Iso-Free Topcoats. Both products are environmentally friendly without any genotoxicity or other acute toxicity problems.

February 2019

TDS 720 Page 1 of 3

Description and uses:

720 Iso-free is a two-pack amine-epoxy functional acrylic topcoat with the following features:

- Excellent durability
- Excellent gloss and colour retention
- Recoatable
- Tough finish with good chemical resistance

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 (e.g. PowerStation's)

Technical Specifications:

FINISH: High gloss

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

THINNERS: T154, T156, T159.

POT LIFE: 10 -12 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: 6 hours

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

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February 2019

TDS 720 Page 1 of 3

| APPLICATION DETAILS – PAINTING SYSTEMS | | | |
|---|----------------------|---------|--|
| D.F.T. um | | | |
| System 1 | 1 st Coat | 50 - 75 | 284 Epoxy Primer (Thinner T180) |
| | 2 nd Coat | 50 - 75 | 720 Iso-Free (Thinner T154, T156 or T159) |
| | 3 rd Coat | 50 - 75 | Optional: 720 Iso-Free (Thinner T154, T156 or T159) |

| D.F.T. um | | | |
|-------------|----------------------|-------|--|
| System 2 | 1 st Coat | 50-75 | 722 Iso-Free Primer (Thinner T154, T156 or T159) |
| | 2 nd Coat | 50-75 | 720 Iso-Free (Thinner T154, T156 or T159) |
| | 3 rd Coat | 50-75 | Optional: 720 Iso-Free (Thinner T154, T156 or T159) |

| D.F.T. um | | | |
|-------------|----------------------|-------|--|
| System 3 | 1 st Coat | 5-10 | 260 Keycoat Etch/Primer (Thinner T166) |
| | 2 nd Coat | 50-75 | 720 Iso-Free (Thinner T154, T156 or T159) |
| | 3 rd Coat | 50-75 | 720 Iso-Free (Thinner T154, 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 2.5 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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February 2019

TDS 720 Page 1 of 3

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

Application:

Mix 720 “Part A” equal parts with 720 “Part B” (Ratio 1:1). 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 SDS BEFORE USE

(Phone 02 9688 1999 or refer to www.lacnam.com.au for copy SDS)

Although this information is presented in good faith and compiled from sources believed to be accurate, Lacnam Paints make no representations or warranty as to the completeness or accuracy thereof. As the product’s performance and suitability depends on various factors, the purchasers of our products should determine for themselves whether the product is suitable for their particular use.