

# 1924 ACRIL-PU TIXO LUCIDO

TWO-COMPONENT GLOSSY ACRYLIC TOP-COAT



Industry



Two-component



Spray

## Description and Use

Glossy top coat with good rheological properties, based on acrylic resin and isocyanate adduct. The product can be used in industrial cycles, machine tools and in general where good aesthetic performance is required. It can be coloured using the ADVANCE HT tinting system.

## Substrate preparation

### IRON SURFACES:

- Remove any trace of rust, iron scale, grease and moisture by sand-blasting SA2.5 grade; otherwise, carry out a careful mechanical cleaning followed by solvent degreasing.
- Apply FONDO R.E. code 1827 or FONDO EPOX code 1806, 1899, 1913.

### GALVANIZED STEEL:

- Remove iron scale and foreign matters, degrease carefully with organic solvents.
- Apply FONDO EPOX code 1806, 1899, 1913.

### ALUMINIUM AND LIGHT ALLOYS:

- Chromatising or phosphochromatising treatment; otherwise, slight matting with sandpaper followed by organic solvent degreasing.
- Apply FONDO EPOX code 1806, 1899, 1913.

### GLASS:

- The substrate must be perfectly cleaned using suitable products, the surface must be dry and free of chemical residues.

## Application

### Application method:

- Air spray gun (conventional) with nozzle Ø 1.4-1.6 mm and pressure of 1.5-2.0 bar.

### Product preparation:

Stir thoroughly the product to achieve even colour and consistency. Then add in the following ratio:

	By weight
<b>PRODUCT</b> 1924 ACRIL-PU TIXO LUCIDO	100
<b>HARDENER</b> 1873 INDURITORE PER ACRILICI/PU ININGIALLENTE or 1882 INDURITORE PER ACRILICI/PU ININGIALLENTE RAPIDO	25
<b>THINNER</b> 1653 DILUENTE PER ACRILICI or 1611 DILUENTE EXTRA PU	10-15

Preparation of the product for applications on glass	By weight
<b>PRODUCT</b> 1924 ACRIL-PU TIXO LUCIDO	100
<b>HARDENER</b> 1873 INDURITORE PER ACRILICI/PU ININGIALENTE or 1882 INDURITORE PER ACRILICI/PU ININGIALENTE RAPIDO	25
<b>ADDITIVE</b> 1901 ADDITIVO AGGRAPPANTE PER VETRO	10
<b>THINNER</b> 1653 DILUENTE PER ACRILICI or 1611 DILUENTE EXTRA PU	0-5

## Storage life

If stored in a cool, dry place, away from sources of heat and sheltered from sunlight, in its sealed original packaging, the product has a shelf life of 18 months. Check the product's shelf life by referring to the production batch number shown on the packaging. The batch number is made of eight numeric characters in which the first four digits identify the year and month of production. Once the product has expired, it must be disposed of in accordance with the current legislation.

## Technical features

Colour	see price list	
Appearance of the dry film	glossy	
Gloss	>85 gloss (Gardner 60°)	
Type of product	two component	
Pot-life	1.5 hours. At higher temperatures pot-life decreases.	
Application viscosity**	20 - 30 sec. cup FORD 4	
Number of coats recommended	2 waiting 5-10 minutes between 1st and 2nd coat	
Recommended wet thickness	100 µm per coat	
Recommended final dry thickness	50 - 70 µm	
Theoretical cover rate *	6 m <sup>2</sup> /kg	
Theoretical consumption ***	Air spray gun (conventional)	240 g/m <sup>2</sup>
	15-20 minutes, dust free	
	2-3 hours, dry to touch	
Air drying (20°C and 65% R.H.)	24 hours, through drying	
	Maximum chemical resistance	
after 7 days		
* The cover rate has been calculated based on the recommended dry thickness of 70 µm, on flat and regular surfaces without taking into account the variables facing during the application phase.		
** May change according to the colour.		
*** The theoretical consumption calculated to achieve the recommended dry thickness of 70 µm.		
The data are measured at a temperature of 20°C.		

## Warnings

- For industrial use only.
- Exclusively for use not restricted from Directive 2004/42/EC.
- Always read the safety datasheet before use.
- Apply only the suggested thickness. Otherwise, and especially in case of high environment temperature, blisters may come up on the film surface.
- Do not apply at temperatures below +10°C.
- Do not apply the product after the specified pot life, as the film that forms may have poor adhesion to the substrate.
- Dispose of contents / container in accordance with national regulations.
- It is recommended to acquire all the material required to finish the work of the same batch.
- The information provided on this technical datasheet is based on our technical and practical knowledge and experience. The technical data refer to the average characteristics of the basic product and are determined under controlled laboratory conditions. The variability of the raw materials available on the market and the tinting of the product can lead to slight deviations in the declared values, in the colour and in the aesthetic effects obtained. It is therefore necessary for the purchaser/user to personally verify, before application, the suitability of the product for the intended use, in particular when different batch numbers of the same material are used in the same work/site.

The above mentioned data are meant to facilitate our customers in the use of our products. IMPA is not responsible for applications of products carried out beyond its direct control. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE at [assistenza.technica@impa.it](mailto:assistenza.technica@impa.it).