

LUCITE® 400

27.08.2014

1K ENAMEL

DESCRIPTION

A new generation 1-component topcoat system for solid and metallic colours for use on cars. The Lucite□ 400 Acrylic Lacquer colours are mixed from the AM Centari□ MasterTint□ tinting system.
Composition based on acrylic resin.

PRODUCTS

AM	Centari® MasterTint®
3608S	Thinner
380S	1K Acrylic Lacquer Clear
4531S	Universal Flattening Base
3989S	Retarder

PROPERTIES

- Lucite□ 400 combines the ease of application and fast drying with the colour and gloss retention of high quality baking enamels.
- Lucite□ 400 can be used for spot, panel as well as overall repair of original refinishing as lacquers or baking enamels.

SUBSTRATES

- All cleaned and sanded sound old finishes.
Cromax primers: 131S Fill'n'Sand 1K Acrylic Primer, 825R Wash Primer Filler
Cromax sealer: 1986S Velvaseal Grey 1K Acrylic Sealer
Cromax adhesion promoter: 222S Adhesion Promoter

TECHNICAL DATA SHEET


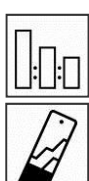









LUCITE® 400

27.08.2014

1K ENAMEL

PRODUCT PREPARATION

	Colour tools	See colour formula				
	Mixing ratio	Lucite® 400 3608S AD345	Solids		Metallics	
			15 - 25°C	25 - 30°C	15 - 25°C	25 - 30°C
			1	1	1	1
			1	-	1.5	-
		-	1	-	1.5	
		For lower gloss add up to 20% by vol. 4531S to thinned product				
	VOC	720 - 750 g/l				
	Pot life at 20°C	Not applicable				
	Spray viscosity at 20°C	DIN 4	13 – 15 s			
		FORD 4	13 – 15 s			
	Spray equipment	Gravity feed Suction feed	Fluid tip		Distance	
			1.2 – 1.6 mm	1.4 – 1.8 mm		15 - 20 cm
			15 - 20 cm			
	Spray pressure	Gravity feed Suction feed	Overall, panel and spot repair			
			3 – 4 bar	3 – 4 bar		
	Number of coats		4 - 5		3 - 4	
	Flash time at 20°C	5 – 10 min between coats				
	DFT		50 – 60 µm		40 – 45 µm	
	Drying at 20°C	Dust free Tack free Dry to handle Tape free Dry to polish	10 min 20 min 2 h 30 min 4 h 4 h for spot and panel repairs 24 h for overall repair			
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.						

LUCITE® 400

27.08.2014

1K ENAMEL

SURFACE PREPARATION

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Repair according to damage.
4. Sand surface:
 - a. mechanical P320 - P400 (finally with P500 will give best results);
 - b. wet P800 - P1000.
5. Remove all traces of sanding dust, blowing oil-free compressed air.
6. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
7. Tack rag.

CLEARCOAT APPLICATION

Metallic colours must be overcoated with Cromax 380S 1K Acrylic Lacquer Clear.
Allow 20-30 min flash for metallics before topcoating with 1K clearcoat (refer to TDS 380S 1K Acrylic Lacquer Clear).
Allow final coat to air dry 4 hr before polishing.

Note: Ultimate finish appearance achieved by allowing longer drying times between coats as well as prior to polishing. On well prepared surface, apply 2 full coats with 10 min flash between coats.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

LUCITE® 400

27.08.2014

1K ENAMEL

RECOATABILITY

At any time after tape-free time. After 24 hr, scuff sanding is required.

REMARKS

- Centari® MasterTints® have to be thoroughly mixed before weigh-out and the Lucite® 400 colour has to be mixed immediately after weigh-out.
- To lower gloss levels add up to maximum 20 % 4531S Universal Flattening Base to already thinned Lucite® 400 colour or 1K clearcoat.
- Excessive coats of colour will slow up drying, avoid heavy coats.
- For flexible application refer to 305S/306S Medium and High Gloss Centari® Vinyl Binder TDS.
- Use of 3608S/3642S will allow faster evaporation. Gloss may be slightly reduced.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Theoretical coverage: 5 - 7 m²/l at recommended DFT - ready-to-spray

SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

SPOT REPAIR

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Repair with recommended undercoats.
4. Sand treated spots as recommended.
5. Prepare complete fade-out area with a non silicone containing rubbing compound or sand wet with P1200.
6. Rinse with water and dry.
7. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
8. Tack rag.
9. The following spot repair method can be used:
 - AK350 Fade-out Thinner method.

LUCITE® 400

27.08.2014

1K ENAMEL

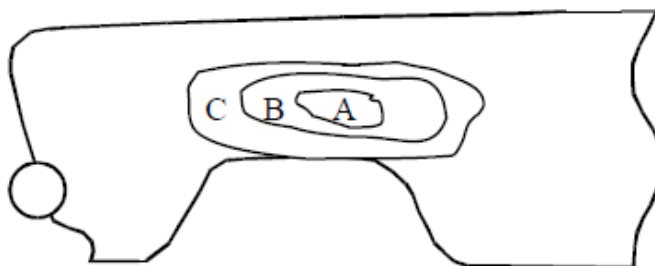
SPOT AND PANEL REPAIR

Surface preparation:

1. Repair with recommended undercoats according to damage.
Sand primed spots as recommended.
2. Prepare complete blending area.
Clean carefully afterwards with 3920S. For poor hiding colours, the use of tinted 1986S, or a tinted primer (see specific TDS) will help colour coverage.

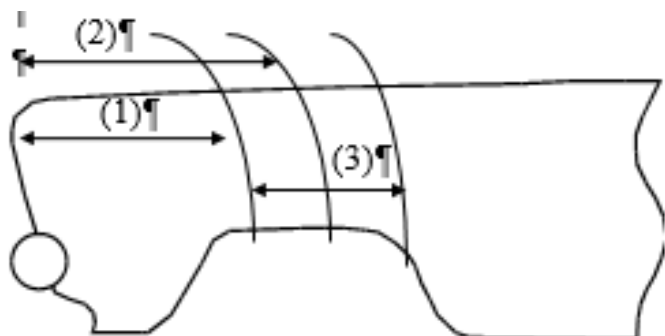
Method:

1. Apply 1 coat over the primer spot (A). Flash 5-10 min. Wipe off spray dust with tack rag in zone B-C, if needed.
2. To assist blending of metallics, use 222S (see specific TDS).
3. Apply 3 to 4 coats. Extend each slightly beyond previous one and always allow each coat to flash (5-10 min) before applying the next coat. Tack wipe after each coat to eliminate spray dust around the colour coat, if needed



AD347 CENTARI® BLENDING THINNER METHOD

1. Apply 1st coat Lucite® 400.
2. Apply 4 to 5 coats extending each beyond the previous coat
Flash 5-10 min between each coat
3. Immediately after last coat, spray 3608S extending into surrounding areas to melt in spray dust



Allow 4 hours air dry before polishing.

LUCITE® 400

27.08.2014

1K ENAMEL

AD347 CENTARI® BLENDING THINNER METHOD

Surface preparation

1. Repair with recommended undercoats according to damage.
2. Sand primed spots or old finish as recommended.
3. Degrease surface with 3920S using clean Sontara® cloths.
4. Wipe dry.

Method:

- Apply 3 to 4 coats with flash time of approximately 5-10 min between coats. Dust wipe the horizontal surfaces with a tack rag before each coat. If required reduce last coat with 30 % thinner for better flow. This is ideal for Lucite□ solid colours.
- Allow 20-30 min flash for metallics before topcoating with 1K clearcoat (refer to TDS 380S 1K Acrylic Lacquer Clear).
- Do not polish with ammonia containing compounds.

All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.