



Effective 1 March, 2005

LUCITE® 400

ACRYLIC LACQUER

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®
AD345	1K Thinner
AD347	Blending Thinner
3608S	Thinner
3642S	1K Multi-purpose Thinner
380S	1K Acrylic Lacquer Clear
4531S	Universal Flattening Base
3979S	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
- DuPont primers: 131S Fill'n'Sand 1K Acrylic Primer, 820R Wash Primer Filler
- DuPont sealer: 1986S Velvaseal Grey 1K Acrylic Sealer
- DuPont adhesion promoter: 222S Adhesion Promoter


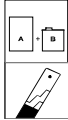









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PRODUCT PREPARATION

	Colour tools	See colour formula.				
	Mixing ratio		Solids		Metallics	
			15-25°C	25-30°C	15-25°C	25-30°C
		Lucite® 400	1	1	1	1
		3608S	1	-	1.5	-
AD345	-	1	-	1.5		
	For lower gloss add 4531S	Up to 20 % maximum by volume 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			
		AFNOR 4	15-16 s			
	Spray equipment		Fluid tip	Distance		
		Gravity feed	1.2-1.6 mm	15-20 cm		
	Suction feed	1.4-1.8 mm	15-20 cm			
	Spray pressure		Overall, panel and spot repair			
		Gravity feed	3-4 bar (30-50 psi)			
	Suction feed	3-4 bar (30-50 psi)				
	Number of coats		4-5	3-4		
	Flash time	5-10 min between coats				
	DFT		50-60 µ	40-45 µ		
	Drying		20°C			
		Dust-free	10 min			
		Tack-free	20 min			
		Dry to handle	2 hr 30 min			
		Tape-free	4 hr			
Dry to polish	4 hr for spot and panel repair					
		24 hr 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.						



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RECOMMENDED USE

Surface preparation

1. Clean surface with water and soap.
2. Degrease with 3919S. Wipe dry with clean cloth.
3. Repair according to damage.
4. Sand:
dry mechanical P320 - P400 (finally with P500 will give best results);
wet P800 - P1000.
5. Degrease with 3920S.
6. Wipe dry and tack rag.

Clearcoat application

Metallic colours must be overcoated with DuPont 380S 1K Acrylic Lacquer Clear. Immediately after the last colour coat, spray a coat with AD347 Blending Thinner, extending into area surrounding the colour coats to melt in spray dust. 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. NB: Ultimate finish appearance achieved by allowing longer drying times between coats as well as prior to polishing.

Equipment cleaning

Use 3608S.



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RECOMMENDED USE (con'd)

Product data

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

Products	Packages (l)	Shelf life at 20°C (year)
AM1x Centari® MasterTint®	1	2
AM94 Centari® MasterTint®	1	2
AM95 Centari® MasterTint®	1	2
AM7xx Centari® MasterTint®	1	3
AMxx Centari® MasterTint®	1 - 4	4
AD345	1 - 5	2
AD347	1 - 5	2
3608S	1 - 5 - 20 - 200	2
3642S	1 - 5 - 20 - 60	1
380S	1 - 3.785 - 5	2
4531S	1	2
3979S	1 - 5	2

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.

Safety

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



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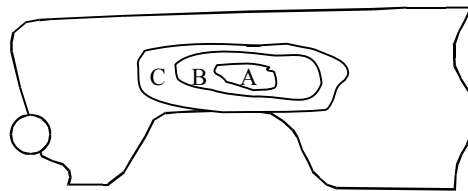
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REPAIR SYSTEMS

Spot and panel repair - Surface preparation

1. Repair with recommended undercoats according to damage.
2. Sand primed spots as recommended.
3. Prepare complete blending area with 1500S.
4. 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.

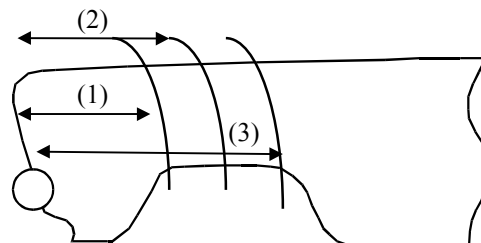
Spot and panel repair - System



- 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).
- To assist blending of metallics, use 222S (see specific TDS).
- 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 AD347 extending into surrounding areas to melt in spray dust.



Allow 4 hr air dry before polishing with 1500S or 3000S.



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REPAIR SYSTEMS (con'd)

Overall repair - Surface preparation

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

Overall repair - System

- 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.