



# 640 AMERCRYL

DECEMBER 2003

## Acrylic Lacquer

### Product Data

Acrylic lacquer finish.

#### Uses

For use direct to plastic, for pigmented finishes, and over lacquer primers for use on wood and metals.

Has excellent hardness and gloss retention properties.

#### Colour Availability

Full gloss solid and metallic colours available at POS.

#### Packaging

Available 1L, 4L, 20L

#### Substrates

Acrylic plastics/polycarbonate – ensure surface is free from dirt, grease and other contaminants. If unsure as to the type of plastic or suitability, please contact PPG Industries' Technical Department.

Wood/MDF – suitably primed

Steel – suitably primed

Aluminium – suitably primed

Galv – suitably primed

#### Total Solids Content

43.1% (wt), 30.5% (vol) – for white

#### Theoretical Coverage

Approximately 12 sq. m/litre @ 25µm DFT.

Practical coverage rates will be lower than theoretical and this must be taken into consideration when calculating costs.

#### Thinning and Clean Up

Thin 30-60% with 265 Floglos for spray application.

Use 640TS when coating PVC. Clean gun with 265 or 640TS.

#### Application

Conventional spray. This product should be layered up until desired film build is achieved.

#### Drying

Touch dry – 20 minutes

Hard dry – 6 hours

(Drying times depend largely on film builds).

#### Surface Preparation

Plastics – Degrease.

Wood – Sand and dust down, apply primer.

MDF – Sand faces with 150 grit, edges with 120 grit followed by 180 grit in the opposite direction, then prime.

Steel – Remove rust by blasting to SA2.5, or by using power tools or sanding. Degrease, prime.

Aluminium – Degrease, then scour with Scotchbrite. Degrease, prime.

Galv – Clean and degrease. Use a proprietary acid wash if surface has been chromate treated. Prime.

## Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of each component. Safety precautions must be strictly followed during storage, handling and use.

### CAUTION:

**Improper use and handling of this product can be hazardous to health.**

**Do not use this product without first taking all appropriate safety measures to prevent property damage and injuries. These measures may include, without limitation: implementation of proper ventilation, use of proper lamps, wearing of proper protective clothing and masks, tenting and proper separation of application areas. Consult your supervisor. Proper ventilation and protective measures must be provided during application and drying to keep spray mists and vapour concentrations within safe limits and to protect against toxic hazards. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interiors and buildings.**

**This product is to be used by those knowledgeable about proper application methods. PPG Industries makes no recommendation about the types of safety measure that may need to be adopted because these depend on application environment and space, of which PPG Industries is unaware and over which it has no control.**

**If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product.**

## Health and Safety

Avoid breathing vapour. Use with adequate ventilation. High concentrations of vapour may cause headache or nausea, affect the nervous system and respiration. When catalysed this product contains isocyanates, which are harmful by inhalation. Refer to Code of Practice for the Safe Handling of Isocyanates 1989 (or updates) for details on handling isocyanate material.

Do not use in the presence of naked flame or other sources of ignition. Store away from heat.

Wear safety glasses / goggles, an air supplied respirator or hood and PVC or nitrile chemical handling gloves. Persons with a history of respiratory problems are advised not to use this product or any other two pack polyurethane.

Store / dispose of residues in accordance with local body regulations.

## First Aid

If poisoning occurs, contact a doctor. The Poisons Information Centre may be of assistance – telephone 0800 POISON (0800 764 766).

If swallowed, do NOT induce vomiting. Give a glass of water to drink and get medical attention urgently.

If affected by vapour, get into fresh air immediately.

If splashed into the eyes, flush them with copious quantities of clean water for 15 minutes and get urgent medical attention.

If splashed onto skin, wash with soap and water.

For further information, refer to the Material Safety Data Sheet for this product.



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## Substrate Systems

Preparation

Plastics – Degrease

Wood/MDF – Sand and dust down

Steel – Remove rust, clean and degrease

Aluminium – Scour with Scotchbrite and degrease

Galv – Clean and degrease

Substrate / Recommended System	WFT / DFT (Microns)	Overcoat Time @ 20 Degrees C	Overcoat Preparation
<b>PLASTICS (Pigmented Finish)</b> 1 <sup>st</sup> coat 640 Amercryl	100-175 / 30-50	20'	
<b>WOOD / MDF (Pigmented Finish)</b> 1 <sup>st</sup> coat 931 MDF Primer 2 <sup>nd</sup> coat 640 Amercryl	120-180 / 40-60 100-175 / 30-50	40'	Sand 360
<b>STEEL / ALUMINIUM / GALV</b> 1 <sup>st</sup> coat 719 Polyetch 2 <sup>nd</sup> coat 632 Lusterprime 3 <sup>rd</sup> coat 640 Amercryl	70-100 / 7-10 150-225 / 40-60 100-175 / 30-50	20' – 8 hrs 40'	N/A Sand 360

WFT = Wet Film Thickness

DFT = Dry Film Thickness

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PPG Industries NZ Ltd • 5 Monahan Road • Mt Wellington • Auckland • Phone 0800-263 766 • Fax 0800-659 377