



# LECHSYS

# USER HANDBOOK

REVISION N° 5 / 2016

## COMPATIBILITY BETWEEN BASE COLOURS AND BINDERS

By following the **LECHSYS** formulations, recorded in **LECHLER MAP** or **EXPLORER** and provided with the CD for **PC** and **DATA BOX**, you will never have any compatibility problems between the base colours and the several binders.

Sometimes, for several reasons, it is needed to formulate or correct colour samples.

In these cases, it is recommended to observe the following guidelines concerning the compatibility between base colours and binders.

The colour of this table legend shows the usage of the base colours with the relevant binder:



NO problems for use.



**DO NOT USE**

### **29044 – 29046**

**must be avoided** in the following binders:

29155, 29164 e 29282

and where a considerable weather resistance is required.

### **29000**

29000 **must be avoided** in the following binders:

29180, 29182, 29184, 29185, 29186, 29190:

29000 would cause a shock between the base colours.

**Use 29001 and vice versa** (29001 can be only used in these binders: with other binders use 29000).

### **29088**

**should be avoided** in the following binders:

29100, 29101, 29102, 29103, 29204, 29105, 29106, 29107, 29108, 29109, 29175, 29180, 29182, 29184, 29185, 29186.

As the ratio between base colour and binder is high there is no particular need for its use.

Do not use at all in low opacity colours.

### **29016 – 29023**

**should be avoided** in the following binders:

29100, 29102, 29107, 29131, 29133, 29134, 29139, 29140, 29142, 29143, 29144, 29146, 29147, 29149, 29152, 29153, 29154, 29155, 29156, 29157, 29158, 29159, 29164, 29170, 29172, 29175, 29176, 29179, 29180, 29182, 29184, 29185, 29186, 29190, 29282, 29299, 29443, 29472,

as they have no solvent resistance or a lower chemical resistance than the binders and the relevant hardeners.

### **29511**

**Military Black:** used in dark colours when a special performance concerning "Heat build – up" is required.

	29511	29098	29097	29094	29093	29088	29085	29081	29072	29068	29062	29059	29054	29049	29048	29046	29044	29038	29031	29025	29024	29023	29018	29016	29015	29013	29010	29007	29001	29000		
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## HOW TO IMPROVE THE OPACITY OR TO OBTAIN HIGH OPACITY PRODUCTS

All colours obtained through **LECHSYS** System have been formulated to reach opacity by 2 cross coats, except the bright colours of yellow, orange, red-orange range, obtained in lead-free formulation having a lower opacity.

**LECHSYS** System gives you the possibility of further improving the colour opacity.

Colour opacity can be improved through 2 methods:

Recommended method

1. Use a primer/filler with the same colour as of the topcoat or a coloured primer/filler with high opacity similar to the topcoat.

For this refer to the colour chips of the LECHSYS BASE COLOURS fan (see price list code 96953) under item “undercoats”.

Example

**29107 EPOXYPRIMER** formulated in 7777731 undercoat

+

**29140 ISOLACK HIGH** formulated in RAL 1023 colour

This allows you to delete the contrast ratio primer/filler-topcoat and to obtain high opacity cycles.

2. Increase the coloured part with max. 20% (multiply the base colour weight by 1,2 and take off the added base quantity from the binder in the formulation).

### EXAMPLE: RAL 1023 COLOUR IN 29145 ISOLACK PUR

Base colour	Weight	Correction factor	Higher opacity formulation	Higher opacity formulation
			<i>Two decimals weight</i>	<i>One decimal weight</i>
29016	183,8	1,2	220,56	220,6
29000	22,7		27,24	27,2
29023	0,7		0,84	0,8
29085	0,3		0,36	0,4
29145	792,5		751,00	751,0
	1000,0		1000,00	1000,0

△ Value obtained by taking off the total quantity of base colours from 1000 g.

The new product with higher opacity keeps the same catalysis, the same dilution and the same chemical-physical characteristics as of the standard opacity product.

It is easy to guess the time saving in application above all when paintwork concerns an especially jointed manufactured item as for example a complex industrial machine.

**As regards the point 2, considering the approximate values due to the recalculations of the formulas' percentages, it is recommended to verify the effectiveness of the adjustment by a preliminary test prior to modifying the formula.**

## PRODUCTION RATIONALISATION

In the LECHSYS System rationalised cycles have been conceived, requiring the **same hardeners** and **thinners** for the PRIMER, the FILLER and for the TOPCOAT.

This is an advantage of the system and it is an important topic of the commercial proposal.

Painting process examples:

- 1) **LS109 (29109) ACRIPUR PRIMER + LS155 (29155) ACRITOP**
- 2) **LS109 (29109) ACRIPUR PRIMER + LS105 (29105) HI-BUILD FILLER + LS155 (29155) ACRITOP**

**This allows you to obtain easy mixtures, to make less catalysis and thinning mistakes and to handle lower stocks in the warehouse.**

In the LECHSYS system you have also available **many BINDERS adhering directly to metal or plastic substrate with no need of any primers or bond products.**

Besides rationalising a painting process with less product consumption, these direct adhesion topcoats considerably reduce times and costs painting.

## LECHSYS FOR SEMI-GLOSS AND SEMI-MATT ENAMELS

In the most important enamel ranges the **LECHSYS** System always gives a choice between gloss and matt enamel. These binders are mixable with each other in all ratios in order to achieve intermediate gloss levels according to the table here below:

<b>Gloss binder</b>		<b>Matt binder</b>	<b>Semi-gloss 65-75 Gloss</b>	<b>Semi-matt 40-50 Gloss</b>
29116	+	29112	1:3	1:4
29120	+	29122	1:3	1:4
29132	+	29130	1:3	1:4
29145	+	29141	1:3	1:4
29144	+	29142	1:3	1:4
29143	+	29152	1:3	1:4
29157	+	29158	1:3	1:4
29170	+	29172	1:3	1:4
29171	+	29173	1:3	1:4
29180	+	29182	1:3	1:4

When mixing 2 binders with each other to obtain an intermediate gloss level, use the hardener of the binder used at the highest percentage, in the same ratio as expected for this binder. When using 2 binders in the ratio 1:1, the hardener ratio of one or the other binder can be used, since chemical-physical characteristics do not change.

Example:

Colour from binder	Utilisation ratio	Standard catalysis	Hardener
29144		50	29344
29142		25	29342
29144 29142	2 1	50	29344
29144 29142	1 2	25	29342
29144 29142	1 1	50	29344
		25	29342

When visually evaluating and comparing colours obtained in gloss and in matt by following the same formula, a colour difference can be perceived and can vary according to the colours. This does not mean that colours are really different, but this is due to an optical distortion engendered by a different eye sensitivity in “reading” the same colour in gloss and matt effect.

It is to consider, moreover, that the final gloss result is only indicative, as it is strongly affected by lots of variables often connected with each other.

### TABLE OF GLOSS VARIABLES

AFFECTING FACTORS		OBTAINED EFFECT	
		MATTER	LESS MATT
AIR PRESSURE	HIGH	X	
	LOW		X
HARDENER	SLOW	X	
	FAST		X
THINNER	SLOW	X	
	FAST		X
DRYING TIME	AIR	X	
	LOW BAKE		X
APPLICATION	FLASH-OFF BETWEEN COATS		X
	ONE COAT	X	
FLASH-OFF	LONG		X
	SHORT	X	
FILM THICKNESS	HIGH	X	
	LOW		X
TEMPERATURE CONDITIONS	HIGH	X	
	LOW		X



# RAL COLOURS

## Information

RAL = German Institute for a quality assurance and identification

RAL 840 = System's birth (1927) – colours from N° 1 to 40  
RAL 840 R = Revision – 1939 –1940 division 1 – yellow...9 – black/white  
RAL 840 HR = Main list revision – The colour collection was increased in 1961.  
The colour references RAL 840 up to 840 HR were originally matt or semi-matt.  
These colours, as for some red, yellow and green colours, still contain mainly chrome and lead pigments.

RAL 841 GL = Gloss colour references – from 1961/1964  
Formulated with modern pigments.

Colours containing chrome and lead change over a period of time, according to the hue, the film thickness and the outside resistance. Lead-free colours have a lower opacity but are more durable over time. Undercoats are recommended to ensure a higher opacity of some colours. Undercoats can be recalled in the Lechler MAP under item "SOTTOTINTE" and are available in the colour fan *Lechs Base Colours* – code 96953.

**The user must check the colour by spraying a sample prior to painting.**

### INFO:

	COLOUR	RAL RANGE	
		FROM	TO
1	Yellow	1000	1028
2	Orange	2000	2009
3	Red	3000	3027
4	Lilac/Violet	4000	4007
5	Blue	5000	5022
6	Green	6000	6029
7	Grey	7000	7043
8	Brown	8000	8025
9	White, Black, Aluminium	9000	9018

**For Lechler RAL colours are the following:**

RAL 840 HR series is the RAL colour series formulated with base colours also containing chrome and lead mainly in the range of yellow, orange and red colours (29011-29012-29026).

RAL 841 GL series is the RAL colour series formulated with lead-free pigments (29010-29015-29025-29013-29016-29007-29018-29024).

**Difference:**

- a) Colours having the same name (ex. RAL 1018 Zinkgelb) are visually slightly different.
- b) RAL 840 HR colour opacity in the yellow, orange and red range is always higher, as formulated with base colours containing chrome and lead.  
RAL 841 GL colours in the yellow, orange and red range often need a coloured primer/filler to improve their opacity and coverage.

Not all colours for Commercial Vehicles have their colour reference in the MASTER INDUSTRY (e.g. special colours), but their code is available in the CD-ROM of system formulations and in the Lechler MAP.

Car Manufacturers of Commercial Vehicles often give the RAL reference of the colours used on their production's vehicles.

Nearly always the colour matching to RAL standard is only theoretical.

In these cases it is necessary to refer to the manufacturer's specific colour code or to start from the RAL colour formulation and then correct it.

## SUGGESTIONS AND WARNINGS FOR THE CORRECT LECHSYS SYSTEM MANAGEMENT

### **HOW TO OBTAIN 5 AND 20 KG PACKAGES BY USING THE SAME BINDER TINS:**

This system is **only** valid for all enamels.

Weigh the colour for 4-16 litres and add to the binder until you obtain the required 5-20 kg weight.

The binder tin capacity has been conceived to obtain the expected weights.

Opacity will be slightly lowered. As for catalysis and thinning please refer to TDS.

### **29100 1K FAST PRIMER:**

After adding **29000 BIANCO INTENSO** mix thoroughly and immediately with a mixing stick or an automatic shaker to avoid shock and lump formation.

### **Colours from binders 29101 SYNTOPRIMER ZINC - 29103 SYNTOPRIMER:**

Use recommended thinners or thinners for nitrocombi products, since SYNTOPRIMER products are not compatible with many synthetic competitors' thinners present onto the market.

### **Colours from binders 29108 EPOPRIMER 1K - 29171 EPOTOP 1K:**

One-pack epoxy-ester products having a slow through-drying especially at low temperatures, due to their chemical nature.

Their use must be suggested only for low film thickness.

### **Colours from binders 29131 TECNOGRIP METAL-29133 TECNOGRIP SPARKLING METAL:**

They can be overcoated with clearcoats of any chemical nature due to aesthetical reasons (synthetic, 1K and 2K polyurethane clearcoats, 2K gloss and matt acrylic clearcoats).

At least 24 hours must pass from the application of TECNOGRIP METAL.

The obtained film after the finishing clearcoat will be highly scratch and weather resistant.

### **Colours from binder 29140 ISOLACK HIGH:**

When painting commercial vehicles (buses, tanks) use 29341 ISOLACK HIGH SLOW HARDENER.

### **29143 ACRYL 2K:**

The only binder can be used as a clearcoat for **visual finishes of metals (catalysis 3:1)**: it has a direct adhesion, but it doesn't resist to yellowing.

The 2K products' **BINDERS** must be normally catalysed. We remind you that **BINDERS** do not contain any UV absorber additives and therefore they tend to yellow outdoors, while they remain unaltered indoors.

It is not recommended to use **MATT BINDERS** as finishing clearcoats since their composition was not conceived to obtain finishing matt clearcoats.

Colours obtained from **EPOXY BINDERS** have some drying limits:

Below +15°C they become slow drying and below +5°C they do not achieve any crosslinking.

Generally **epoxy topcoats** have scarce outside resistance (they tend to bleach, to yellow and to tarnish).

Colours from binder **29116 SYNTOLACK** and generally air drying synthetic enamels can be catalysed when using with 10-20% **29344 LECHSYS ISOLACK HARDENER**.

In most cases this allows you to have

- ❑ Faster drying at low temperature
- ❑ Better through-drying
- ❑ Better outdoor resistance
- ❑ Greater adhesion to the primers

To tint colours (especially white colours) with hardly weighable base colour quantities (example 0,1 g) you can prepare base colours of reduced concentration by following this example:

29081 TB LECHSYS INTENSE BLACK	20 g
29088 TB LECHSYS MIX BASE	80 g

Weigh 0,5 g in place of 0,1 g and obtain the same colour result.

In practice you multiply by 5 the quantity to weigh.

**LECHSYS** base colours are thick and stable; therefore they must be stirred by mixing machine a few times and for a short time.

It is recommended to stir 1 minute in the morning + 1 minute in the afternoon, when work starts.

Frequent stirring and low consumption make base colours thick, thus impeding at a certain point their dosage and dispersion.

It is advisable to position base colours in the mixing machine only if their consumption is suitable enough to avoid the above-mentioned phenomenon.

In order to produce ANODISED effects of various colours, you can tint the binders **ACRYL 2K (29143-29152-29153-29159)** with BRILLIANT COLORS (max. 10%) to which 5% BC000 U.V. ABSORBER ADDITIVE is to be added to improve their light resistance.

Then they must be applied directly to aluminium or steel to obtain the coloured ANODISED effect.

Please pay attention that by coat overlapping the tone deepens.

**EPODUR LS170 (29170)** and **LS172 (29172)**, after addition of 09830 GLASS ADHESION PROMOTER, have a fairly good adhesion on glass: however a preliminary test is recommended to test the painting process quality.

It is recommended to immediately mix the base colours with the binder just after weighing the base colours **ESPECIALLY FOR THE BINDERS**

**29100 1K FAST PRIMER**

**29143 ACRYL 2K**

..... **All nitrocombi binders**

Colours obtained with binder **29139 SOFT**: We suggest and remind that in order to always obtain good results the following cycle must be observed:

1. Apply specific adhesion primer on plastic or epoxy primer on metal.
2. Apply 04111 SOFT PRIMER NERO-AI or 04100 SOFT PROT.INC.SEALER (*04100 Special Product*).
3. Apply **LS139 (29139) SOFT** wet-on-wet in the desired colour.
4. Low bake for 90' at 60°C or 60' at 80°C.

To paint PVC frames and casings you can use colours from the following binders:

- **29282 FRAMECOAT PVC** when a gloss level of about 50° gloss is needed
- **29472 FRAMECOAT PVC MATT** (*special product*) when a gloss level of about 30° gloss is needed.

The two binders 29282 and 29472 are mixable with each other to obtain intermediate gloss levels.

- Mix the binder **29143 Acryl 2K** and the binder **29157 Acryl 1K** in 1:1 ratio, by adding 29157 to 29143; this mixing must preferably be carried out while stirring continuously and, in any case, it must take place immediately after adding one binder to the other. After mixing the binders add the tinters with the same mixing methods, that is either while stirring continuously or by mixing just after adding the tinters. This mixture must be catalysed with 10% of 29342 Lechsys Isolack ESP Hardener.

The mixture of the two coloured binders must be used within 7 days.

It is always recommended to carry out a preliminary test as well as to use high resistance pigments.

**LS130 (29130) TECNOGRIP** in black and derived colours totally absorbing the sun rays (unlike the other colours) becomes thermoplastic (soft) when it is applied to iron and is directly exposed to the sun rays in summer. By temperature falling it achieves its normal consistency.

In the **LECHSYS SYSTEM** it is important to use the suggested thinner to achieve the levels of expected performances. By using non-specific economic thinners you can have poor finishes as for aesthetical aspect, durability and drying.

## SPECIAL USES OF PRODUCTS FROM THE LECHSYS SYSTEM

To apply an economical and abrasion resistant paint on interior concrete floors of workshops or warehouses you can use colours from the binders **29170-172 EPODUR** after cleaning carefully the surfaces to paint with pressure washers.

Apply the first over-thinned coat as an impregnating coat and the second coat as a normal coat. Apply by brush or by roller and verify that concrete is compact, in good condition, totally free from humidity when applying and that temperature is above 15°C.

To paint **PVC tarpaulins of commercial vehicles** you can use **LS157 (29157) ACRYL 1K** after previous degreasing and cleaning.

For more valuable finishes you can use a mixture of **29132 TECNOGRIP GLOSS + 29157 ACRYL 1K** in a variable ratio from 1:4 to 1:2 according to the tarpaulin PVC.

(Use 29132+29158 in the same ratios for semi-matt version).

A preliminary test is always necessary.

To paint **centre strips** on asphalt you can use colours derived from the binder **29119 MONOSYNT** thinned with synthetic thinner (00570 for roller and brush application or 00572 for spray application).

To obtain a semi-matt, one-coat, very fast drying finish you can mix **1:1 29103 SYNTOPRIMER + 29180 NITRON**.

To apply a **colourless impregnating varnish** on **wood** you can use the only binder **29132 TECNOGRIP GLOSS** without base colours, thinned at 100-200% with 00824.

Apply directly to wood.

It is important to prepare the product already thinned, as no film must be formed and it must be all absorbed by the wood. It doesn't have, of course, either anti-mould properties or protecting properties against woodworms.

As a **Flatting** lacquer you can use the pure binder **29118 SYNTOLACK PENN MATT** with addition of 2% **29298 LECHSYS BRUSH SICCATIVE**.

The acid hardener **29385 LECHSYS NITRON 2K HARDENER** can be used as a **degreasing – phosphatising agent for steel sheets and aluminium**. After its application clean the surfaces carefully with demineralised water, allow to dry and apply a suitable painting process.

Colours obtained from the binder **29100 1K FAST PRIMER** can be used as a **weldable SHOP PRIMER**.

LECHSYS ISOCYANATE HARDENERS:  
USE AND CHARACTERISTICS

CODE	TRADE NAME	HARDENER TYPE AND CHEMICAL CHARACTERISTICS	BINDER PARTNER		CATALYSIS BY VOLUME	THINNER	
			CODE	NAME		TYPE	%
29340	ISOLACK HIGH HARDENER	HIGH QUALITY FOR OUTDOORS	29140	ISOLACK HIGH	2:1	00825/4	30-40
			29149	ISOLACK TEXT.	2:1		30-40
			29106	ISOSEALER B/B	2:1		45-50
			29299	ISOLACK HIGH EFB	5:1		0-20
29341	ISOLACK HIGH SLOW HARD.	HIGH QUALITY FOR LARGE SURFACES	29106	ISOSEALER B/B	2:1	00825/4	45-50
			29140	ISOLACK HIGH	2:1		30-40
			29149	ISOLACK TEXT.	2:1		30-40
			29154	ISOLACK ULTRA HS	2:1		0-15
			29299	ISOLACK HIGH EFB	5:1		0-20
29342	ISOLACK ESP HARDENER	ALIPHATIC	29134	TECNOGRIP 2K MET	4:1	00825/4	25-40
			29142	ISOLACK MATT	4:1		25-30
			29146	ISOLACK GFR	4:1		0-30
			29147	ISOLACK PENN	2:1		0-5
			29143	ACRYL 2K	4:1		0-50
		NON-YELLOWING HIGH QUALITY	29152	ACRYL 2K MATT	5:1		35-40
			29153	ACRYL 2K MATT	5:1		30-50
			29156	ACRYL 2K GFR	5:1		0-30
			29159	ACRYL 2K TEX.	5:1		30-35
			29282	FRAMECOAT PVC	5:1		25-35
			29443	ACRYL 2K AC	5:1		00824 10-30
29139	SOFT	3:1	00673 15-20				
29343	ISOLACK ESP INDUSTRY HARDENER	ALIPHATIC AND AROMATIC MIXTURE	29142 29146	ISOLACK MATT ISOLACK GFR	4:1 4:1	00825/4	25-30 0-30
		CHEAP FASTER AND LESS RESISTANT THAN 29342					
29344	ISOLACK HARDENER	ALIPHATIC	29141 29144 29145	ISOLACK PUR MATT ISOLACK ISOLACK PUR	4:1 2:1 4:1	00825/4	25-30 10-15 25-30
		HIGH QUALITY AND NON-YELLOWING					
		ALIPHATIC AND AROMATIC MIXTURE					
29345	ISOLACK INDUSTRY HARDENER	CHEAP SLIGHTLY YELLOWING FASTER AND LESS RESISTANT THAN 29344 FOR INDOORS	29141 29144 29145	ISOLACK PUR MATT ISOLACK ISOLACK PUR	4:1 2:1 4:1	00825/4	25-30 10-15 25-30
		ALIPHATIC AND AROMATIC MIXTURE					
		CHEAP SLIGHTLY YELLOWING FASTER AND LESS RESISTANT THAN 29344 FOR INDOORS					
		ALIPHATIC AND AROMATIC MIXTURE					
29354	ISOLACK UHS STAND.HARD.	GOOD QUALITY	29154	ISOLACK ULTRA HS	2:1	00825/4	0-15
29355	ACRITOP STANDARD HARDENER	ALIPHATIC	29105 29109 29155 29204	HI-BUILD FILLER ACRIPUR PRIMER ACRITOP IS FILLER HBF	5:1 3:1 2:1 4:1	00825/4	5-20 15-25 10-15 15-20
		HIGH QUALITY GENERAL USE FOR POLYURETHANE AND ACRYLIC LACQUERS					
		ALIPHATIC					
		HIGH QUALITY FASTER VERSION THAN 29355					
29356	ACRITOP HARDENER FAST	ALIPHATIC	29105 29155 29204	HI-BUILD FILLER ACRITOP IS FILLER HBF	5:1 2:1 4:1	00825/4	5-20 10-15 15-20
		HIGH QUALITY FASTER VERSION THAN 29355					
		ALIPHATIC					
29357	ACRITOP HARDENER SLOW	HIGH QUALITY SLOWER VERSION THAN 29355	29155 29204	ACRITOP IS FILLER HBF	2:1 4:1	00825/4	10-15 15-20
		ALIPHATIC					
09919	HARDENER	ALIPHATIC NON-YELLOWING HIGH QUALITY	29109	ACRIPUR PRIMER	3:1	00825/4	15-25

CODE	TRADE NAME	HARDENER TYPE AND CHEMICAL CHARACTERISTICS	BINDER PARTNER		CATALYSIS BY VOLUME	THINNER	
			CODE	NAME		TYPE	%
29364	ACRIPROF UHS HARDENER	ALIPHATIC	29164	ACRIPROF UHS	2:1	00825/4	5-15
29397	ACRITOP ULTRA HS FAST HARDENER	FOR TRADITIONAL USE					
29316	ACRIPROF UHS HARDENER AIRLESS	ALIPHATIC FOR SPECIFIC USE IN AIRLESS			2:1	00653	0-15

### LECHSYS AMINIC HARDENERS: USE AND CHARACTERISTICS

CODE	TRADE NAME	HARDENER TYPE AND CHEMICAL CHARACTERISTICS	BINDER PARTNER		CATALYSIS BY VOLUME	THINNER	
			CODE	NAME		TYPE	%
29302	EPOBUILD PRIMER HARDENER	POLYAMIDE -----	29102	EPOBUILD PRIMER 2K	2:1	00516	0-10
29370	EPOXYPRIMER STANDARD HARDENER	POLYAMIDE FOR LARGE SURFACES OR FOR HIGH TEMPERATURES	29107	EPOXYPRIMER	2:1	00516	0-10
29371	EPOXYPRIMER FAST HARDENER	POLYAMIDE FAST FOR SMALL SURFACES OR FOR LOW TEMPERATURES					



29376	EPODUR HARDENER	POLYAMIDE ADDUCT HIGH QUALITY	29170 29172 29176	EPODUR EPODUR MATT EPODUR EFB	5:1 5:1 3:1	00516	20-25 40-50 0-20
29377	EPODUR FAST HARDENER	POLYAMIDE ADDUCT FAST DRYING, HIGH QUALITY					
29379	EPOXYLACK HARDENER	POLYAMIDE FAST DRYING					

## LECHSYS ACID HARDENERS: USE AND CHARACTERISTICS

CODE	TRADE NAME	HARDENER TYPE AND CHEMICAL CHARACTERISTICS	BINDER PARTNER		CATALYSIS BY VOLUME	THINNER	
			CODE	NAME		TYPE	%
29385	NITRON 2K HARDENER	ACID HARDENER -----	29185	NITRON 2 K	2:1	00825	10-20

# BRIAR ROOT EFFECT PAINTING PROCESS

## BROWN BRIAR ROOT CYCLE WITH LECHSYS PRODUCTS

- Apply **ISOLACK ENAMEL** in RAL 1018 or similar colours on the substrate to paint with briar root effect.
- Allow to dry, then sand dry with grit paper P400 or wet with grit paper P800-1000. Rub down slightly with Ultra Fine Scotch Brite
- Prepare the following mixture (**Lechsys Mix Briar Root**)
  - 29038 TB LECHSYS DARK OXIDE RED 20 parts
  - 29081 TB LECHSYS INTENSE BLACK 5 parts
  - 29190 BASECOAT 75 parts
  - 00825 LECHSYS UNIVERSAL STANDARD THINNER 50 parts

To obtain other darker or less dark colours change the mixing ratio of LECHSYS base colours.

- Degrease the substrate with **00695 SILICONE REMOVER SLOW**
  - Apply the coloured mixture **with a sponge or with a lint-free cloth in irregular way.**
  - Allow to flash off for 5-10' at 20°C.
  - Stipple with a clean cloth wet with **00744 FADE-OUT BLENDER** (the cloth must be just wet not dripping). **Since the quantity and the application of 00744 on the surface affect the effect, it is important to optimise this operation.**
  - Allow to flash-off for at least 20' at 20°C.
  - Spray the following mixture in light coats:
    - 29155 ACRITOP (Binder) 975 parts
    - 29038 TB LECHSYS DARK OXIDE RED 20 parts
    - 29081 TB LECHSYS INTENSE BLACK 5 parts
    - 29355 (Standard)/356 (Fast)  
LECHSYS ACRITOP HARDENER 500 parts
    - 00825 LECHSYS UNIVERSAL STANDARD THINNER 150 parts
  - Allow to dry for 20-30' at 60°C.
  - To obtain a high quality finish sand dry with grit paper P400 or sand wet with grit paper P1000, degrease with 00695 SILICONE REMOVER SLOW and overcoat with a glossy or matt clearcoat \*.
- \* Any two-pack car refinishing clearcoat can be used.

In order to obtain a briar root effect with other colours use a lighter ground coat than the finishing coat. E.g. pink ground coat and wine-red finish or light blue ground coat and dark blue finish.

## MARBLE EFFECT PAINTING PROCESS

Apply on the substrate a primer/filler or a two-pack enamel in the desired colour.  
Allow to dry and sand dry with grit paper P400 or wet with grit paper P800.

Prepare the following mixture:

29180 NITRON (only the binder)	99 parts
LECHSYS base colour mixture	1 part
00744 FADE-OUT BLENDER	150 parts

Spray two coats in an irregular way.

Stipple immediately and in a random way with creased industrial paper.  
Allow to flash off for about 10'.

Apply thin and uniform coats of the previous colour until you obtain the desired colour.

Allow to flash off for about 10-15'.

Apply 1-2 coats of two-pack gloss or matt clearcoat.

Allow to dry for 30-40' at 60°C.

### ***Example to obtain GLOSS ROSY MARBLE EFFECT***

Apply a primer/filler or a two-pack enamel RAL 9010.

#### **Allow to dry**

Dry sanding with grit paper P400

Prepare the following mixture:

29180 NITRON (binder)	99 parts
29054 TB LECHSYS AMARANTH	1 part
00744 FADE-OUT BLENDER	150 parts

#### **Apply two irregular coats**

Stipple immediately with creased industrial paper.

Allow to flash off for about 10'

Apply 1-2 coats of the previous mixture until you obtain the desired effect.

Allow to flash off for about 10-15'

Apply two coats of gloss clearcoat 09792 MACROFAN HS 2000

Allow to dry for 30-40' at 60°C.

# TECHNICAL INSTRUCTIONS ON PRE-TREATMENT OF PLASTIC SUBSTRATES PRIOR TO PAINTING

SUBSTRATE	ESSENTIAL PREPARATION	MAXIMUM LEVEL PREPARATION
ABS	DEGREASING WITH 00617 PLASTIC CLEANER. DRYING.	DEGREASING BY SPRAY SYSTEMS WITH ALKALINE SURFACE-ACTIVE AGENTS OR ACID SURFACE-ACTIVE AGENTS. RINSE WITH DEMINERALISED WATER. DRYING.
PC/ABS		
PC		
PP	DEGREASING WITH 00617 PLASTIC CLEANER. DRYING. FLAME TREATMENT WITH OXIDISING FLAME. (WETTABILITY 48/52 DM/CM MINIMUM)	DEGREASING BY SPRAY SYSTEMS WITH ALKALINE SURFACE-ACTIVE AGENTS OR ACID SURFACE-ACTIVE AGENTS. RINSE WITH DEMINERALISED WATER. DRYING. FLAME TREATMENT WITH OXIDISING FLAME. WETTABILITY 48/52 DM/CM MINIMUM
POLYOLEFIN RUBBERS	DEGREASING WITH 00617 PLASTIC CLEANER. DRYING.	DEGREASING BY SPRAY SYSTEMS WITH ALKALINE SURFACE-ACTIVE AGENTS OR ACID SURFACE-ACTIVE AGENTS. RINSE WITH DEMINERALISED WATER. DRYING.
RIGID POLYSTYRENE		
SEMI-FOAM POLYSTYRENE		
SOFT PVC		
RIGID PVC		
SOFT FOAM POLYURETHANE	//	DEGREASING IN CHLORINATED SOLVENT VAPOURS
RIGID FOAM POLYURETHANE		
POLYURETHANE R/RIM		DEGREASING IN CHLORINATED SOLVENT VAPOURS OR DEGREASING IN WATER WITH ACID SURFACE-ACTIVE AGENTS (5 STAGE SYSTEMS). FOLLOWING DRYING.
POLIUREA	//	
NYLON	DEGREASING WITH 00617 PLASTIC CLEANER. DRYING.	DEGREASING BY SPRAY SYSTEMS WITH ALKALINE SURFACE-ACTIVE AGENTS OR ACID SURFACE-ACTIVE AGENTS. RINSE WITH DEMINERALISED WATER. DRYING.
FIBREGLASS	SANDING, DEGREASING BY HAND WITH 00617 PLASTIC CLEANER OR WITH CLEANING NITRO THINNER. DRYING WITH DRY CLOTH.	SANDING CLEANING IN HOT WATER WITH SURFACE-ACTIVE AGENTS (WATER SYSTEM OR HIGH PRESSURE JET CLEANERS) RINSE AND DRYING.

# TECHNICAL INSTRUCTIONS

## PRE-TREATMENT OF METALLIC SUBSTRATES AND THE LIKE PRIOR TO PAINTING

**R&D Lab COATINGS**

SUBSTRATES	ESSENTIAL PRE-TREATMENT	MAXIMUM LEVEL PRE-TREATMENT	SUBSTRATES	ESSENTIAL PRE-TREATMENT	MAXIMUM LEVEL PRE-TREATMENT
<b>Cold-Rolled carbon steel</b> Low thickness Without corrosion	1) Phospho-degreasing with high pressure jet cleaners •Rinsing with demineralised water •Drying  2) Degreasing with 00695 SILICONE REMOVER SLOW •Drying	•Degreasing with 00695 SILICONE REMOVER SLOW •Drying •Sanding or orbital sander •Degreasing with 00695 SILICONE REMOVER SLOW •Drying	<b>Hot Dip Galvanized steel</b>		•Degreasing with 00695 SILICONE REMOVER SLOW •Drying •Sanding or slight sanding with Scotch Brite •Degreasing with 00695 SILICONE REMOVER SLOW •Drying
<b>Cold-Rolled carbon steel</b> Low thickness With corrosion	•Degreasing with 00695 SILICONE REMOVER SLOW •Drying •Sanding or orbital sander •Degreasing with 00695 SILICONE REMOVER SLOW •Drying	•Degreasing with 00695 SILICONE REMOVER SLOW •Sandblasting to bare metal •Blowing	<b>Stainless steel</b>		•Degreasing with 00695 SILICONE REMOVER SLOW •Drying •Sanding or orbital sander •Degreasing with 00695 SILICONE REMOVER SLOW •Drying
<b>Black Hot-Rolled carbon steel</b> High thickness Without black oxide	•Phospho-degreasing with high pressure jet cleaners •Rinsing with demineralised water •Drying	•Degreasing with 00695 SILICONE REMOVER SLOW •Drying •Sanding or orbital sander •Degreasing with 00695 SILICONE REMOVER SLOW •Drying	<b>Light alloys</b>	•Degreasing with 00695 SILICONE REMOVER SLOW •Drying •Slight sanding with red Scotch Brite •Degreasing with 00695 SILICONE REMOVER SLOW •Drying	1) Degreasing with 00695 SILICONE REMOVER SLOW + Pickling + Chemical conversion: •Chromating or phospho-chromating process or •Non-fixed anodising or •Alternative pre-treatments Notes: After chemical conversion, in order to obtain the best results, paint application must be carried out within 16 hours; max. drying temperature must be between 65°C (chromating process) and 80°C (phospho-chromating and anodising process) 2) •Degreasing with 00695 SILICONE REMOVER SLOW •Sandblasting with calibrated non-metallic tools •Blowing

<b>Black Hot-Rolled carbon steel</b> High thickness With black oxide		<ul style="list-style-type: none"> <li>•Degreasing with 00695 SILICONE REMOVER SLOW</li> <li>•Sandblasting to bare metal</li> <li>•Blowing</li> </ul>	<b>PRFG</b>		<ul style="list-style-type: none"> <li>•Sanding</li> <li>•Degreasing with 00695 SILICONE REMOVER SLOW</li> <li>•Drying</li> </ul>
<b>Pre-coated steel</b> (Electrophoretic Deposition)		<ul style="list-style-type: none"> <li>•Degreasing with 00695 SILICONE REMOVER SLOW</li> <li>•Slight sanding with Scotch Brite</li> <li>•Degreasing with 00695 SILICONE REMOVER SLOW</li> <li>•Drying</li> </ul>	<b>Old solvent resistant coatings</b>		<ul style="list-style-type: none"> <li>•Degreasing with 00695 SILICONE REMOVER SLOW</li> <li>•Sanding or slight sanding with Scotch Brite U.F.</li> <li>•Degreasing with 00695 SILICONE REMOVER SLOW</li> <li>•Drying</li> </ul>
<b>Electro Galvanized steel</b>		<ul style="list-style-type: none"> <li>•Degreasing with 00695 SILICONE REMOVER SLOW</li> <li>•Drying</li> </ul>			

## 29088 TB LECHSYS MIX BASE

Among LECHSYS base colours there is also a resin 29088 TB LECHSYS MIX BASE aiming at replacing some high opacity base colours (e.g. grey, beige and brown): it keeps the same ratio between BINDERS and BASE COLOURS and reduces the final product costs.

TABLE OF CONDUCTIVITY VALUES FOR ES APPLICATION

Product	Hardener	Thinner	Siccative	Res SAMES	
LS101 (29101)	/	20% 00825	/	45 MΩcm	
LS102 (29102)	30% 29302	5% 00516		8 MΩcm	
LS103 (29103)	/	30% 00825		15 MΩcm	
LS105 (29105)	13% 29355	17,5% 00825		45 MΩcm	
LS106 (29106)	25% 29340	25% 00825		4 MΩcm	
LS107 (29107)	30% 29370	2,5% 00516		7,5 MΩcm	
LS109 (29109)	20% 29355	17,5% 00825		400 MΩcm	
LS111 (29111)	/	15% 00572	1% 29298	90 MΩcm	
LS112 (29112)		20% 00825	1% 29298	210 MΩcm	
LS114 (29114)		17,5% 00825	1% 29297	19 MΩcm	
LS116 (29116)		17,5% 00825	1% 29297	300 MΩcm	
LS119 (29119)		17,5% 00825	1% 29297	89 MΩcm	
LS140 (29140)	50% 29340	35% 00825	/	15 MΩcm	
LS141 (29141)	25% 29344	27,5% 00825		30 MΩcm	
LS142 (29142)	25% 29342	27,5% 00825		13 MΩcm	
LS143 (29143)	25% 29342	40% 00825		17 MΩcm	
LS144 (29144)	50% 29344	12,5% 00825		45 MΩcm	
LS145 (29145)	25% 29344	15% 00825		90 MΩcm	
LS146 (29146)	25% 29342	15% 00825		13 MΩcm	
LS149 (29149)	50% 29342	2,5% 00755		4 MΩcm	
LS150 (29150)	/	20% 00825		2% 29297	125 MΩcm
LS152 (29152)	20% 29342	37,5% 00825		/	50 MΩcm
LS153 (29153)	20% 29342	37,5% 00825	30 MΩcm		
LS154 (29154)	50% 29354	7,5% 00825	65 MΩcm		
LS155 (29155)	50% 29355	12,5% 00825	68 MΩcm		
LS156 (29156)	15% 29342	0-25% 00825	40MΩcm		
LS159 (29159)	20% 29342	30-35% 00825	50 MΩcm		
LS170 (29170)	20% 29376	20-25% 00516	4 MΩcm		
LS172 (29172)	15% 29376	40-45% 00516	4 MΩcm		
LS176 (29176)	20% 29376	0-10% 00516	11 MΩcm		
LS179 (29179)	25% 29379	0-15% 00516	28 MΩcm		

Tests have been carried out on **grey colour RAL 7040**.

The thinner quantity has been calculated on an intermediate value out of the values indicated on the technical data sheet.



## LECHSYS PRODUCTS SUITABLE FOR AIRLESS / AIRMIX APPLICATION

**LS109 (29109) ACRIPUR PRIMER**

**LS107 (29107) EPOXYPRIMER**

**LS164 (29164) ACRIPROF UHS**

**LS140 (29140) ISOLACK HIGH**

**LS141 (29141) ISOLACK PUR MATT**

**LS142 (29142) ISOLACK MATT**

**LS144 (29144) ISOLACK (ONLY AIRMIX)**

**LS145 (29145) ISOLACK PUR (ONLY AIRMIX)**

**LS154 (29154) ISOLACK HS**

**LS155 (29155) ACRITOP**

**LS164 (29164) ACRIPROF UHS**