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**Translucent Spray Paint**

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# Lacryl 400 Series

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Lacryl 400 Series is a translucent air dry acrylic lacquer for the plastic sign industry.



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## Features

Over 30 Standard Colors and over 3000 intermix colors.

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## Advantages / Benefits

Provides the durability and fade resistance required for sign coatings.

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## Compatible Surfaces

- Polycarbonate
- Acrylics

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## Associated Products / Required Products

- ZZ205 reducer to adjust viscosity and color saturation
- L490 clear or L491 colorless to adjust color intensity
- Sign Strip recommended as liquid maskant
- ZZ206 Cleaner remover for removal of overspray and paint

# Lacryl 400 Series

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## Directions For Use

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### Surface Preparation:

Apply over a clean surface free of dirt, lint, water, grease or oil.

### Mix Ratios:

- Dilute all colors 1:1 with ZZ205
- Dilute all whites 1:2 with ZZ205

### Reducers:

- ZZ205 to adjust viscosity for spray
- ZZ206 for removal of overspray or removal of paint from reject

### Spray Setup:

#### Air Pressure

Conventional..... 55-60 psi at the gun  
HVLP..... 10 psi at cap  
Pot Pressure..... 15-18 psi

#### Gun Setup

Siphon Feed ..... 1.3 mm 0.050 fluid tip  
HVLP..... 1.3 mm 0.050 fluid tip  
Pot Pressure ..... 1.2 mm 0.046 fluid tip

### Application:

- Stir before and during use
- Apply when air, product and surface temperature are above 50°F and at least 5 above dew point
- Face must be placed in front of a light bank before applying Lacryl 400
- Remove static using Matthews 6428 Plastic Cleaner
- Apply several coats
- Change direction with each coat
- Keep gun at least 8 inches from surface
- Do 50 to 75% overlap
- Build up to desired color slowly
- If paint is not applied evenly, the color will look blotchy
- After desired color is achieved, apply white backer to eliminate “hot spots” in the finished product

### Drying Time:

Dry to touch .....30 minutes  
Dry to handle.....1 hour  
Dry to remask using Sign Strip .....1 to 1-1/2 hours  
Dry time before exposure to weather.....24 hours

### Factory Pack Colors:

- Over 30 standard colors
- Custom color matching available

### Total Film Build:

Translucent paint, total film build will vary with color standard.

## Directions For Use

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### Equipment:

Conventional siphon gun

### Equipment Cleaning:

Use ZZ205 or other suitable solvent.

### Technical Data:

Lacryl 403 Lead Free White

VOC ..... 5.2 lb/gal

Solids ..... 33% by weight

Viscosity..... 35  $\pm$  3 seconds #2 Zahn cup

Density..... 7.65 lb/gal

### Theoretical Coverage:

Lacryl 403 Lead Free White ..... 350 sq. ft./gal @1 mil DFT

### Important:

Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition.

Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use.

Wear eye and skin protection. Observe all applicable precautions.

**See Material Safety Data Sheet and Labels for additional safety information and handling instructions.**

### Emergency Medical or Spill Control Information:

US (412) 434-4515; CANADA (514) 645-1320; Mexico 01-800-00-21-400

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