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PRODUCT INFORMATION SHEET

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MOTOSPRAY ACRYLIC LACQUER

Description

Motospray Acrylic Lacquer is a premium quality thermoplastic acrylic lacquer. *Motospray Acrylic Lacquers* are based on top quality pigments and raw material components, including special UV absorbing additives. This results in an extremely durable finish. *Motospray Acrylic Lacquers* are available as factory made colours (*Acrylic Solid Colours* and *COB Base Colours*) or can be mixed from the *Motospray Acrylic Lacquer Tinting System*. All colours and tints are strictly controlled for colour and strength and *Tinters* are standardised for use on the *Motospray Acrylic Lacquer Tinting System*.

Uses

Motospray Acrylic Lacquer is designed for the spot repair and full respray of all motor vehicles. With an extensive range of tinters it is possible to mix most manufacturers colours including solid colours, mono metallics and clear over base (COB) metallics, Pearlcoats and Micas.

Properties

- * Excellent gloss off the gun
- * Excellent durability
- * Excellent adhesion
- * Excellent opacity
- * Excellent petrol resistance
- * Can be polished to a high gloss finish

Suitable substrates:

Motospray Acrylic Lacquer may be applied over the following surfaces after appropriate preparation:

- *Motospray One Step Primer Putty*
- *Motospray Acrylic Primer Surfacer*
- *Motospray Flexi Prime Plastic Primer*
- *Motospray Bumper Prime*
- *Motospray Stone Guard*
- *HiChem 2 Pack Iso-Free Primer Isolator*
- Original 2 Pack or acrylic lacquer finishes in sound condition
- Repaired areas in sound condition (ie. 2 Pack or acrylic lacquer).

Do not apply *Acrylic Lacquer* over substrates which are oxidised, cracked, contaminated or in unsound condition.

Surface preparation

Thoroughly wash the surface area with *Motospray Prepwash* wax and grease remover before and after panel beating. Eliminate rust by sanding or grinding. Apply *Motospray Deoxidiser & Rust Remover* to all rusted or bare metal areas. Peeling, chalked, cracked or paintwork in poor condition should be stripped with *Motospray Quickstrip* and bare metal areas should be treated with *HiChem Super Etch Primer*. Painted surfaces must be thoroughly sanded and edges feathered.

Filling: Grind large indentations back to bare metal, tap out as much of the dent as possible then fill with *Lightweight Body Filler*, *MicroFill* or *Superbog*. For rust holes or areas requiring extra strength, use *Reofill* or *Metal Fill* after grinding back to bare metal.

Priming: Apply *Motospray Acrylic Primer Surfacer* and *Spray Putty*, *Motospray One Step Primer/Putty*, or *2 Pack Iso-Free Primer Isolator* as per instructions on the relevant product info sheet. Apply *Motospray Spot Putty* to fill minor defects evident after priming. Ensure that puttied areas are coated with a further coat of primer prior to application of finishing coats.

Stone Guard should be applied over painted or primed surfaces only. The Acrylic Lacquer is applied directly over the Stone Guard.

Plastics should be primed with *Motospray Flexiprime*. The Acrylic Lacquer is applied directly over the Flexi Prime.

Sanding:

1. Degrease all surfaces thoroughly before and after sanding.
2. Thoroughly sand old existing paintwork to remove gloss completely as follows:-
-Metallic colours, P1000 - P1200 Wet and Dry.

- Solid colours, P800 - P1200 Wet and Dry.
3. Sand primer with P400 Freecut or P800 - P1000 Wet and Dry.

Thinning

Motospray Acrylic Lacquer is normally thinned with *Motospray Superglow Thinner*. For a slightly higher gloss off the gun, use *Aclac 20*. The addition of substitute thinners may result in a decrease in product appearance and/or performance. Add 150 parts by volume of *Motospray Superglow Thinner* to 100 parts by volume of *Motospray Acrylic Lacquer*. Mix thoroughly. When temperature exceeds 30°C, or in conditions of high humidity, up to 25% of *Motospray Retarder* may be added to the lacquer thinner mix as a partial thinner replacement.

Motospray Flexi Add should be mixed with the *Acrylic Lacquer* where the substrate is *Stone Guard* or a flexible surface such as plastic.

Application

Apply using a suction feed or gravity feed spray gun.

Typical spray set-up is:-

Suction Gun: Fluid Tip 1.6-2.0 mm Pressure 350-500 kPa (50-72 psi)

Gravity Gun: Fluid Tip 1.6-2.0 mm Pressure 350-500 kPa (50-72 psi)

Apply 2-3 double header coats or until opacity is achieved, allowing 10-15 minutes flash off time between coats at 20°C.

For spot repairs, extend each coat beyond the edge of the previous coat blending into surrounding finish. Mist coat edges with the same thinner used in the colour coat to assist the blend.

Clearcoat application:

Motospray COB Base Colour, Pearl Finishes and Metallics mixed from the tinting system must be coated with an appropriate clear coat to obtain the high gloss finish and achieve the required durability.

The recommended clear coats are *HiChem 2 Pack Iso-Free Clear(3:1)* and *Motospray Acrylic Topcoat Clear*.

(a) 2 Pack Iso-Free Clear:

Allow the paint to **dry thoroughly**. (Ideally 24 hours at 20°C . Longer in colder weather). Then apply 2-3 coats of 2 Pack Iso Free Clear allowing 10-15 minutes flash off between coats. **DO NOT FORCE DRY, AIR DRY ONLY**. Allow a minimum of 24 hours drying before cutting or buffing with Motospray Machine Grade Cutting Compound.

(b) Acrylic Top Coat Clear:

Allow 15 to 20 minutes drying at 20°C prior to application of 2-3 coats of Top Coat Clear allowing 10-15 minutes flash off time between coats. Allow a minimum of 24 hours air drying or force dry with lamps before cutting or buffing with Motospray Machine Grade Cutting Compound.

Drying times

* Dust free 5-10 minutes at approx. 20°C

* Touch Dry 10-15 mins at approx. 20°C

Do not apply waxes or sealant type polishes to films less than 4 weeks old as water spotting may result.

Cutting and Polishing

Use *Motospray Machine Grade Cutting Compound*. Allow minimum drying time of 4-5 hours at 20°C (preferably overnight) before compounding,. Do not attempt to compound before drying is complete.

If *Iso-Free Clear* is used consult the Product Information Sheet for compounding instructions.

Note: Do not cut and polish satin or matt finishes.

Clean up

Clean all equipment with *Motospray Gunwash* or *Motospray Superglow* (Multipurpose) thinner

Storage

Store in a cool dry place. Always replace the lid securely after use. Stir tinters regularly.

Safety

See material safety data sheet

Standard packages

Tinters	1litre, 4litre, 20 litre
Mixed colours	500 ml, 1 litre, 2 litre, 4 litre
Factory colours	<i>Acrylic Solid Colours</i> 4 litre
	<i>COB Base Colours</i> 4 litre
	<i>Top Coat Clear</i> Press. Pack 400g, 1litre, 4litre, 20 litre
	<i>High OpacityWhite</i> Press. Pack 400g, 1litre, 4litre, 20 litre
	<i>Jet Black</i> Press. Pack 400g, 1litre, 4litre, 20 litre
<i>Satin Black</i> 1litre	

The information contained in this bulletin is presented in good faith based on thorough laboratory and field testing but without warranty. As we have no control over the conditions under which these products are used , it is recommended that all products be tested by the end user to ensure the suitability of the product for the particular application and conditions.