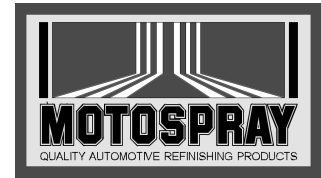




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PRODUCT INFORMATION SHEET

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SIGN LACQUER

Description:

HiChem Sign Lacquer is a fast drying thermoplastic acrylic lacquer with excellent abrasion and weather resistance. It has been specifically formulated for application to acrylic or polycarbonate sheet.

Suitable uses:

As a decorative and protective coat for a range of plastic substrates, for both first and second surfaces. It's excellent durability makes it suitable for interior and exterior use.

Properties:

Highly durable. Suitable for long term exterior exposure. Based on highest quality resins and pigments and contains special UV protection.

Flexibility - Good. Resistance - Very good resistance to splash and spillage of general chemicals and detergents. Petrol resistance - good. Not suitable for exposure to strong solvents.

Surface preparation:

The surface must be clean, dry and free from grease, etc. HiChem Sign Lacquer requires no priming prior to application.

Application :

Conventional, airless spray or volume-air.

Spray application viscosity 12-15 secs by Ford No.4 cup.

Thinning - Reduce with Reducer 285 for Acrylic substrates or Reducer 442 for Polycarbonate substrates.

Drying

HiChem Sign Lacquer is an air drying lacquer, but may be force dried if required.

Tack free: 10 minutes @ 20°C

Touch dry: 15 minutes @ 20°C

Through dry: 24 hours @ 20°C

Force dry: 30 minutes @ 50°C

Recommended coverage:

10.5 sq. metres per litre @ 75 microns wet-film thickness. This gives a theoretical dry film thickness of 25 microns.

Standard Packaging and Product Codes:

Colour	Size	Code
Clear gloss	4	SL63 4
Clear gloss	20	SL63 20
Clear matt	4	SL64 4
Permanent Green	4	SL05 4
Mid Yellow	4	SL07 4
Black	4	SL08 4
Black	20	SL08 20
Mid Blue	4	SL16 4
Magenta	4	SL20 4
Bright Orange	4	SL27 4
Deep Red	4	SL29 4
Violet	4	SL31 4
White	20	SL34 20
White	4	SL34 4
Bright Lemon	4	SL36 4
Process Blue	4	SL70 4
Ultra Blue	4	SL72 4
Reflex Blue	4	SL73 4
Scarlet	4	SL74 4

SIGN LACQUER RECOMMENDED APPLICATION PROCEDURES

1 Scope: The following procedures are recommended for the application of HiChem Sign Lacquer to Acrylic or Polycarbonate sheet.

2 Surface preparation: Ensure all surfaces to be painted are clean and dry, and free from any other contaminants. This can be achieved with Acetone and a clean cloth. Wipe over swiftly to avoid surface deterioration. Masking operations may now proceed.

3 Application:

3.1 Thinning:- HiChem Sign Lacquer must be stirred thoroughly before use. Thinning should be at the rate of 2 parts of the appropriate thinner to 1 part by volume, HiChem Sign Lacquer. This may be varied according to temperature conditions operating at the time of application. Correct application viscosity ranges 12-15 secs. using a No.4 Ford Cup.

3.2 Method of Application:- Apply the thinned HiChem Sign Lacquer by conventional spray using successive wet light coats. Allow each double pass coat to flash off before applying the next.

This method is recommended to avoid solvent entrainment and subsequent pinholing in the finished job.

The degree of opacity required determines the number of coats to be applied. Normally 2-3 coats are sufficient, depending on the colours used.

3.3 Demasking:- When the last coat is almost dry to the touch, the job is ready to be demasked. Care must be taken and the masking should be removed at right angles to the line of masking wherever possible. This method is recommended to eliminate "bridging" which occurs when the applied film becomes too hard, so that it does not always break on the required line and a jagged edge results. In itself, this does not mean any lack of adhesion to the sheet, as adhesion only becomes complete after thorough drying. This can take up to 72 hours and varies according to the climatic conditions. "Bridging" is most likely to occur when the film is particularly heavy such as with the use of less opaque colours ie: ULTRA BLUE; MID BLUE; PERMANENT GREEN; and BLACK (illuminated signs).

4 Surface defects: Cratering in the film can normally be traced to silicone contamination. Should this occur add anti-silicone drops at the rate of 1 ml. per litre of mixed lacquer and thinner.

These recommendations are intended as a guide only and will vary according to the specific conditions operating at the time of application.

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.