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## 330 ACRYLIC LACQUER

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### DESCRIPTION

330 ACRYLIC LACQUER is a premium quality thermoplastic acrylic lacquer designed for the repair and refinishing of motor vehicles. It has been developed in Australia for Australian conditions, and is based on the latest and most innovative paint technology.

330 ACRYLIC LACQUER TINTING SYSTEM consists of a range of 58 acrylic lacquer tinters pigmented with the highest quality, light fast, automotive grade pigments. These tinters are carefully standardised and controlled to ensure uniformity of both tint strength and tone. Additionally there are 20 dry colour Special Effect Pearl Pigments. Colour mixing formulations for most vehicle manufacturers colours are available dating back to 1965, and the colour formulae range is constantly reviewed and increased as new model colours become available.

Basecoat tinters have been specifically introduced to allow the ready matching of modern vehicles which are painted in clear over base finishes. Colours mixed using basecoat tinters must be overcoated with 512 ACRYLIC LACQUER SUPER CLEAR to duplicate the depth and metallic pattern of original clear over base finishes.

### FEATURES

330 ACRYLIC LACQUER exhibits the following outstanding properties:

- Superior gloss off the gun
- Outstanding durability and resistance to weathering.
- Superior petrol resistance
- Excellent resistance to humidity blistering when used in conjunction with 432 ACRYLIC PRIMER SURFACER or 434 SPF-60 and PROTEC recommended thinners

### SUITABLE SUBSTRATES

- 330 ACRYLIC LACQUER may be applied over most properly prepared substrates including metal, fibreglass, timber and plastic. Suitable surface preparation details can be obtained from the PROTEC TECHNICAL SERVICE DEPARTMENT

### DRYING

- 330 ACRYLIC LACQUER dries to touch in approximately 10-15 minutes at normal ambient conditions.
- For metallic colours, allow 20-30 minutes air drying before application of 512 ACRYLIC LACQUER SUPER CLEAR.

### SURFACE PREPARATION

- Before and after panel beating, wash all surfaces to be painted thoroughly with R123 H/D WAX AND GREASE REMOVER to remove all traces of oil, grease, silicone, wax, perspiration and other deposits from hands.
- Sand and feather edge all painted surfaces. Baked enamel and two-pack enamel in particular, must be thoroughly sanded to remove all gloss.
- Treat all bare metal areas with 971 METAL CONDITIONER.

### DEEP FILLING

- Grind large indentations back to bare metal and fill with 570 EVOLUTION PLASTIC FILLER or 571 PLASTIC PUTTY.

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### PRIMING

- Apply 2 or more coats of 432 ACRYLIC PRIMER SURFACER to area to be painted.
- Thin 1 part by volume primer to 1 part by volume R103 ALL PURPOSE THINNER or R100 LACQUER THINNER.
- Allow to air dry for 20-30 minutes at normal ambient conditions before sanding with 400 grade free-cut paper.
- Alternately, SPF-60 SPRAY PRIMER FILLER may be used direct from the can and sanded after 60 minutes depending upon film build.

### FILLING

- Fill surface imperfections with 574 SPOT PUTTY or 439 SPRAY PUTTY. Apply putty only to previously primed surfaces.
- 439 SPRAY PUTTY is supplied ready for use by a low pressure spray gun at an air pressure around 200 kPa.
- Apply 2 to 3 light coats, allowing a short flash off between coats and allow to air dry 1-2 hours before sanding.
- Prime puttied areas with two or more coats of 432 ACRYLIC PRIMER SURFACER, sand and wipe clean with R123 H/D WAX AND GREASE REMOVER.

### THINNING

- 330 ACRYLIC LACQUER should be thinned with R212 PREMIUM ACRYLIC THINNER, R102 ACRYLIC LACQUER THINNER or R103 ALL PURPOSE THINNER.
- For optimum results, R212 PREMIUM ACRYLIC THINNER is recommended.
- To 1 part by volume of 330 ACRYLIC LACQUER add 1½ parts by volume of thinner, and mix thoroughly.
- In conditions of high humidity and/or high ambient temperature, the use of R107 ACRYLIC RETARDER THINNER may be necessary, particularly when using R102 ACRYLIC THINNER or R103 ALL PURPOSE THINNER.
- Up to 25% replacement of the normal thinner by R107 ACRYLIC RETARDER THINNER may be necessary.

### SPRAY VISCOSITY

For best results, the spraying viscosity should be adjusted as follows:

- **SOLID COLOURS** 14-16 seconds BS4 @ 25°C
- **METALLIC COLOURS** 13-14 seconds BS4 @ 25°C

### APPLICATION

#### *Conventional*

- Apply 3 double header coats of 330 ACRYLIC LACQUER thinned as previously detailed, allowing a 5 minute flash off between coats.
- To enable the reproduction of metallic effects and/or peel pattern of some production enamels, the thinning ratio may need to be varied.
- Due to the outstanding gloss off the gun displayed by 330 ACRYLIC LACQUER, compounding and polishing should not be necessary, or at least, be very minimal.
- Allow to air dry for 24 hours or force dry with heating lamps before compounding and polishing.

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- Do not apply waxes or polymer sealant type polishes for at least 6 weeks after painting.
- **NOTE: Metallic colours should be completely overcoated with 512 ACRYLIC LACQUER SUPER CLEAR before compounding. Do not rub or scuff metallic colour before application of clear.**

- Basecoat**
- Apply three SINGLE coats of 330 ACRYLIC LACQUER basecoat colour thinned as detailed above, allowing 2-3 minutes air flash between coats.
  - Thin a further 50% with the same thinner and apply one or two light coats to aid levelling and to produce an even finish.
  - Do not apply heavy coats as this may cause mottle.
  - Do not sand the basecoat.
  - Allow 20-30 minutes drying before application of 512 ACRYLIC LACQUER SUPER CLEAR.
  - Thin clear as previously detailed for 330 ACRYLIC LACQUER and apply three double header coats.
  - Compounding and polishing should not be required but when necessary, allow to air dry for 24 hours or force dry with drying lamps before commencing that operation.
  - Do not apply waxes or polymer sealant type polishes for at least 6 weeks after painting.

### HEALTH AND SAFETY

Contains highly flammable volatile solvents. Keep away from all sources of heat and open flames. Do not smoke whilst handling. Wear suitable protective clothing to avoid contact with skin and eyes and avoid breathing vapour. Do not spray in confined or poorly ventilated areas without the use of approved air supplied breathing apparatus.

### FIRST AID

<b>Eyes</b>	If splashed in eyes, irrigate with copious amounts of clean water for 15 minutes. Seek medical aid if irritation persists.
<b>Skin</b>	If splashed on skin, wash affected area thoroughly with soap and water. If irritation persists seek medical aid. Remove all contaminated clothing and launder before re-use.
<b>Inhalation</b>	If affected by exposure to vapours, remove from area, keep at rest and seek medical aid if symptoms persist.
<b>Ingestion</b>	If swallowed, give glass of water to drink and seek medical assistance. <b>DO NOT</b> induce vomiting.

*Consult separate Material Safety Data Sheet for more detailed Health and Safety information.*