



---

## Translucent Spray Paint

---

# Lacryl<sup>®</sup> 400 Series

---

Lacryl 400 Series is a translucent air dry acrylic lacquer for the plastic sign industry. This translucent coating can be air sprayed to decorate back lit formed faces. Second surface application provides the durability and fade resistance required for translucent sign coatings. Lacryl 400 can be matched to most popular brands.



---

### Compatible Surfaces:

---

Lacryl 400 Series may be applied over properly prepared:

Polycarbonate  
Acrylics

---

### Associated Products:

---

#### Thinner

ZZ205/01\* General Purpose Thinner  
ZZ215/01 Slow Thinner

\*Also available in /PL and /DR

# Lacryl<sup>®</sup> 400 Series

## Directions for Use

### Surface Preparation:

**Cleaning of substrate:** 6428SP/01 quickly removes troublesome silicones and mold release agents from the substrate to be painted. Apply with a pump sprayer or clean white cloth\*, wipe in one direction only, and immediately dry with a clean, dry cloth. If sanding is required, use 6428SP/01 before and after.

**\*Caution:** Do not apply over sensitive substrates such as fresh topcoats and/or primers as softening may occur.

**Removal of static charge:** Using a spray gun or mist bottle, apply a mist coat of 6428SP/01 on the surface to be painted. This will help reduce static electricity on all treated surfaces, minimizing the attraction of dust & dirt particles.

### Mix Ratio:



Mix Ratio for Spraying (by volume)

Lacryl 400	Thinner*
------------	----------

1 part	1 part**
--------	----------

\*Choose Lacryl thinner for shop temperature:

- ZZ205/01\*\*\* General Purpose Thinner
- ZZ215/01 Slow Thinner

\*\*To adjust viscosity and color saturation, some colors, such as white, may require additional thinner (1:2 is acceptable).

\*\*\*Also available in /PL and /DR

NOTE: Some colors, such as blues and greens, are prone to an uneven appearance.

To make the color more translucent, 10-100% of L490/01 or L491/01 clear can be added. Then thin as normal. Additional coats may be required.

### Additives:



None required, but the following may be used for specific application or project needs:

- 490/01 Clear Gloss
- 491/01 Clear Matte

### Spray Set Up:



Air Pressure:	Conventional:	40 - 50 psi at the gun*
	HVLP:	10 psi at the cap*

\* Refer to spray gun manufacturer recommendations for inlet pressure.



Pressure Pot Fluid Delivery:	8 - 12 Fluid Ounces per Minute
------------------------------	--------------------------------



Gun Set Up:	Siphon Feed:	1.3 - 1.5 mm 0.051 - 0.059 fluid tip
	HVLP:	1.3 - 1.5 mm 0.051 - 0.059 fluid tip
	Pressure Pot:	1.0 - 1.2 mm 0.039 - 0.047 fluid tip

# Lacryl<sup>®</sup> 400 Series

## Directions for Use

### Application:



- Apply when ambient air, product and substrate temperature are above 60°F/16°C and at least 5°F/3°C above dew point.
- To ensure uniform application, face should be placed in front of a light bank before applying Lacryl 400.
- To remove static charge, lightly mist surface with Matthews 6428SP/01 Plastic Prep.
- Stir Lacryl thoroughly before use and agitate often during use.
- Using a 50 to 75% overlap, apply several coats with a gun distance of 8-10 inches from the surface.
- Allow proper flash time between coats.\*
- Vary the direction of the passes (i.e. apply some horizontally, some vertically, and some diagonally). This is to make sure that a uniform coating of paint is applied.
- Build up coats to desired color gradually, to avoid over-application. If paint is not applied gradually and uniformly the result could be blotchy, uneven, or off-color.
- After desired color is achieved, apply white backer to eliminate “hot spots” in the finished product.

\*Flash times will vary dependent upon film thickness, temperature, solvent selection, spray gun set-up, application, etc.

### Estimated Drying Times:



Air-Dry @ 50% Relative Humidity, 70°F/21°C

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

### Equipment Cleaning:

Use ZZ205/01\* Thinner or other suitable solvent for cleaning spray equipment.

Use ZZ206/01\* Cleaner Remover for removal of overspray and paint.

**Note: Do not leave mixed material in equipment.**

\*Also available in /PL and /DR

### Technical Data:

#### VOC Information

VOC Actual RTS 5.64 - 6.29 lbs/gal

VOC Actual RTS 676 - 754 g/L

VOC Regulatory (less water less exempt) RTS 5.72 - 6.35 lbs/gal

VOC Regulatory (less water less exempt) RTS 682 - 761 g/L

Lacryl 403 White used as standard.

For complete VOC information, visit [MatthewsPaint.com](http://MatthewsPaint.com) > Quick Links > VOC Data

#### Performance Characteristics

Volume solids (RTS) 33% by weight (403 white)

Viscosity 35 ± 3 seconds #2 Zahn cup

Theoretical Coverage (1 mil @ 100% transfer efficiency) 350 sq.ft./RTS gal

Application Conditions - Temperature 60°F (16°C) Minimum

100°F (38°C) Maximum

Application Conditions - Relative Humidity 85% maximum 5° above dew point

# Lacryl<sup>®</sup> 400 Series

---

**Important:** The contents of this package may have to be blended with other components before the product can be used. 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 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  
Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Matthews Paint. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Matthews Paint warrant freedom from patent infringement in the use of any formula or process set forth herein. If you require technical assistance, please call us toll-free 800/323-6593.



*The World's Finest Coating For Architectural Signage*

760 Pittsburgh Drive  
Delaware, OH 43015  
Toll Free: 800/323-6593  
Toll Free FAX: 800/947-0377