

2K Topcoat MM 320

LESONAL

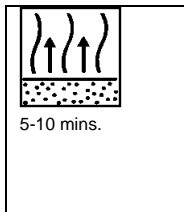
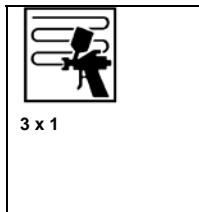
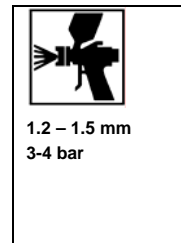
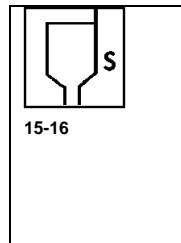
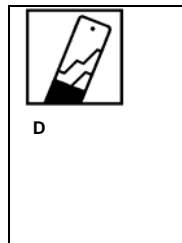
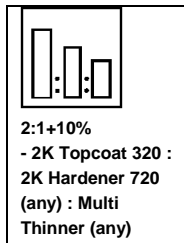
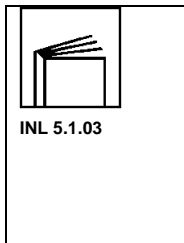
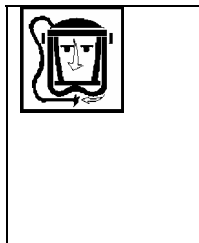
Technical Data Sheet

August 2006



INL 5.1.03

Description: Two component, mixing machine based, acrylic topcoat. Available in a wide variety of direct gloss/solid colours, including both RAL and British Standard colours. Specifically designed for the refinishing of passenger cars, light commercial vehicles, and industrial machinery. For both new work and repairs.



Product & ancillary items

Product: Lesonal 2K Topcoat MM 320.

Ancillary Product: Lesonal 2K Hardener Fast 720-B

Faster hardener for general low bake use on repairs from a single panel up to a complete respray. Recommended for use when temperature is lower than 25°C.

Lesonal 2K Hardener 720

Standard hardener for general low bake use on repairs from a single panel up to a complete respray. Recommended for use when temperature higher than 25°C.

Lesonal 2K Hardener HT 720-CC

Slow hardener for general low bake use on repairs from a single panel up to a complete respray. Recommended for use when temperature higher than 35°C.

Lesonal Multi Thinner Fast 810-B

Temperature range <20°C–30°C → single panel and spot repair.

Temperature range <20°C → multi panels and total respray.

Lesonal Multi Thinner 810-C

Temperature range >30°C → single panel and spot repair.

Temperature range 20°C–30°C → multi panels and total respray.

Lesonal Multi Thinner HT 810-CC

Temperature range >30°C → multi panels up to total respray

Basic Raw Materials

Lesonal 2K Topcoat MM 320

– Acrylic Resins

Lesonal 2K 720 (any)

– Polyisocyanate resins

Lesonal Multi Thinner 810 (any)

– A blend of organic solvents

Method of use

Suitable Substrates:	Original finishes, polyester laminates, Lesonal Fast Dry Primer 410, Lesonal 2K Primer 480 and Lesonal EP Primer Grey 440.
Substrate Preparation:	<p>Prior to commencing any sanding work, thoroughly cleanse the surface of any grease or wax with Akzo Nobel Wax and Grease Remover. Apply using two clean clothes in a wipe-on, wipe-off process.</p> <p>Sand with P800 – P1000 wet or Sand with P400 – P500 dry.</p> <p>After sanding work is completed, and just prior to the application of 2K Topcoat 320, degrease again thoroughly with Akzo Nobel Wax and Grease Remover.</p>
Mixing Ratio by Volume:	<p>2 Parts of Lesonal 2K Topcoat MM 320 1 Part of Lesonal 2K Hardener 720 (any) +10% Lesonal Multi Thinner (any)</p> <p>Use Mixing Stick D</p> <p>Stir well before use.</p>
Spraying Viscosity:	15 – 16 sec. DIN Cup 4 at 20°C.
Potlife:	4 hours at 20°C

Spray Gun Fluid Tip and Working Pressure:

<u>Spray Gun:</u>	<u>Fluid Tip:</u>	<u>Working Pressure:</u>
Gravity Feed	1.2 – 1.5 mm	3 – 4 bar
Suction Feed	1.4 – 1.6 mm	3 – 4 bar
HVLP Gravity Feed	1.3 – 1.6 mm	max 0.7 bar at the air-cap
HVLP Suction Feed	1.6 – 2.2 mm	0.7 bar
Pressure pot	1.1 – 1.2 mm	4 – 6 bar

Application Technique:

Apply 3 coats. Allow for 5 – 10 minutes flash off time between coats.

Lettering:

Lettering must be applied within 48 hours. After 48 hours, scuff with a grey scuffing pad.

Equipment Cleaning:

Use Multi Thinner 810 (any) or NC Thinner 820

Drying Times at 20°C:

	<u>720-B</u>	<u>720</u>	<u>720-CC</u>
Dust Dry	20 mins.	30 mins.	N/A
Dry to Handle	4 hrs.	9 hrs.	N/A
Hard Dry	9 hrs.	12 hrs.	N/A

Drying Times at 60°C:

	<u>720-B</u>	<u>720</u>	<u>720-CC</u>
Dust Dry	5 mins.	5 mins.	8 mins.
Dry to Handle	15 mins.	25 mins.	35 mins.
Hard Dry	20 mins.	50 mins.	60 mins.

Helpful Tips:	Application on thermoplastic acrylic finishes: These types of finishes can be very sensitive to attack from solvents in the paint that you are applying. This can result in poor gloss and in extreme cases, contour mapping, and/or sanding scratch swelling. When applying Lesonal 2K Topcoat 320, the following could be done to avoid problems: 1) Extend the flash off time between coats. 2) Don't apply excessively heavy or double coats. Similar attention should be paid when applying primers or surfacers.
	Shelflife: Lesonal 2K Topcoat MM 320 – 4 years Lesonal 2K Hardener 720 (any) – 1 year

Health & Safety Data: These products are intended for professional use only. Please refer to can labels and Safety Data Sheets concerned for more specific information. The user of these products is required to comply with the national laws pertaining to Health & Safety disposal. *The above information is given in good faith, but without warranty, as the final results are also dependent upon factors of use which are outside our control.*