

Fast Dry Primer 410

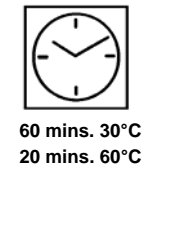
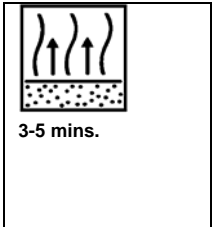
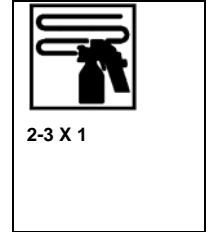
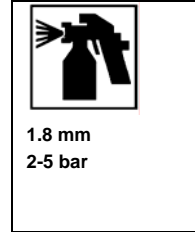
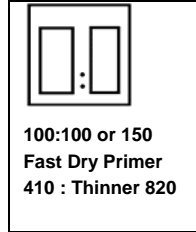
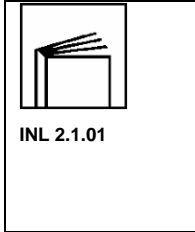
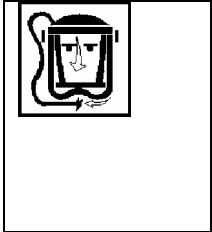


Technical Data Sheet



August 2006

Description One-component quick drying cellulose-based primer filler for general use in refinishing cars. Excellent adhesion on steel and aluminum. Easy application and quick and smooth sanding.



Product & ancillary items

Product Lesonal Fast Dry Primer 410

Thinners Lesonal NC Thinner 820

Basic Raw Materials Fast Dry Primer 410 – Combination of nitrocellulose resins
Lesonal NC Thinner 820 – A blend of organic solvents

Method of use

Suitable Substrates: Steel
Aluminum
Original finishes including thermoplastic acrylics
Lesonal 2K Putty 522

Substrate Preparation: Prior to any sanding work, thoroughly cleanse the surface of any grease or wax with Akzo Nobel Wax and Grease Remover. Apply using two clean cloths in a wipe-on, wipe-off process.

Original finishes – sand with P280 grit dry or P600-P800 wet.
Steel & aluminium – remove all traces of rust and abrade thoroughly until a clean surface is achieved.

Lesonal 2K Putty 522 – finish sand with P280 grit dry.

After sanding work is completed and just prior to the application of primer, degrease again thoroughly with Akzo Nobel Wax and Grease Remover.

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Provisional Technical Data Sheet

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INL 2.1.01

Mixing Ratio by Volume: 100 volume – Lesonal Fast Dry Primer 410
100~150 volume – Lesonal NC Thinner 820

Spraying Viscosity: 18-19 sec. DIN Cup 4 at 30°C

Potlife: There is no definitive pot life once the product has been mixed, but it is better to use it within two days. Stir thoroughly before each usage.

Spray Gun Fluid Tip and Working Pressure:	<u>Spray Gun:</u>	<u>Fluid Tip:</u>	<u>Working Pressure:</u>
	Gravity Feed	1.5-1.8 mm	2-5 bar
Suction Feed	1.8 mm	2-5 bar	
HVLP	1.2-1.5 mm	0.7 bar	

Application Technique: Apply two or three coats; allow drying until matt between each coat. Generally this will take 3 – 5 minutes in-between the coat. This time will be very much influenced by factors such as temperature and air movement at the time of application. If the product is to be applied over a thermoplastic acrylic finish, it is recommended that a thin coat is applied first, and that care is also taken in applying subsequent coats. Flash off times between each coat should also be extended. (See Helpful Tips below.)

Film Thickness: 15 - 20 µm

Equipment Cleaning: Use Multi Thinner 810 (any) or Lesonal NC Thinner 820

Drying Times: Dry to sand: 1 hour at 30°C or 20 minutes at 60°C

Recommended Sanding Grades:	<u>Method</u>	<u>Sandpaper Grade</u>
	Wet, by hand	P800-P1000
Wet, by machine	P800-P1000	
Dry, by hand	P400-P500	
Dry, by machine	P360-P400	

Helpful Tips: Always apply thin coats, application of heavy or more coats than mentioned will require longer drying times than stated.

Color: Light Grey

Shelflife: Lesonal Fast Dry Primer 410 – 2 years
Lesonal NC Thinner 820 – 4 years

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.*