

Substrate preparation	<p>Prior to commencing any sanding work, thoroughly cleanse the surface with Akzo Nobel Wax and Grease Remover.</p> <p>Original finishes and polyester laminates - Sand with P180 - P280 grit dry, or P280 - P400 wet. Steel - Remove all traces of rust and abrade thoroughly until a clean surface is achieved (see Helpful tips below). Any mill scale should be removed by shot blasting.</p> <p>Lesonal Polyester Body Filler - Finish sand with P180 / P280 grit dry. After sanding work is completed and just prior to the application of 2K Filler 540, again degrease thoroughly with Akzo Nobel Wax and Grease Remover.</p>		
Mixing Ratio	<u>Sanding:</u>		
Mixing stick 9	3 volumes	- 2K Filler 540	
	1 volume	- 720 Hardener	
	10% volumes	- Multi Thinner 810	
	<u>Non Sanding:</u>		
Mixing stick 9	3 volumes	- 2K Filler 540	
	1 volume	- 720 Hardener	
	1 volume	- Multi Thinner 810	
Spraying Viscosity	<p>23 - 25 sec. DIN Cup 4 at 20°C. 15 - 17 sec. DIN Cup 4 at 20°C.</p>		
Pot life	After mixing, use within 1 hour at 20°C.		
Spraying pressure	Spraygun	Fluid opening	Spraying pressure
	LVLP/HR Gravity	1.8-2.0 mm	2-4 bar (at air inlet)
	HVLP Gravity	1.8-2.0 mm	0.7 bar (at air cap)
	<i>Non Sanding</i>		
	LVLP/HR Gravity	1.3-1.5 mm	2-4 bar (at air inlet)
	HVLP Gravity	1.3-1.5 mm	0.7 bar (at air cap)
Application	<u>Sanding:</u>		
	Apply two or three single coats, allow to dry until mat between each coat, generally this will take 5 - 10 minutes.		
	<u>Non Sanding:</u>		
	Apply one to two single coats, allow to dry until mat between each coat, generally this will take 5 - 10 minutes.		
	(Drying times will be very much influenced by factors such as temperature and air movement at the time of application).		

Layer Thickness	50 – 60 micron		
<i>Sanding</i>	15 – 20 micron		
<i>Non Sanding</i>			
Theoretical use per Ltr/m²	<u>Sanding:</u> Taking in account a transfer efficiency of 70%, the theoretical material usage for a dry paint film of 60 µm is 5 m ² /l ready to spray mixture, which counts for 8 m ² /l unthinned paint.		
	<u>Non sanding:</u> Taking in account a transfer efficiency of 70%, the theoretical material usage for a dry paint film of 20 µm is 16 m ² /l ready to spray mixture, which counts for 25 m ² /l unthinned paint.		
	Note: The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.		
Cleaning Equipment	Use Multi Thinners 810 or nitro cellulose thinner.		
Drying Times	at 20° C	at 60° C	
<i>Sanding:</i>	Dry to sand:	3 hrs.	35 min.
<i>Non Sanding:</i>	Dry to recoat with topcoat	15-20 min.	N/A
	Must be recoated within	6 hrs	N/A
	Dry to sand	6 hrs	1 hour
		Half power	Full power
	Infra red short wave equipment:	4 min.	8 min.
Recommended sandpaper grades	Method:	Initial sanding	Final sanding
	Wet, by hand or machine	P500-P600	P800-P1000
		P280-P360	P400-P500
		P280-P360	P400-P500
	Dry, by hand or machine	P280-P320	P400-P500
Recoatibility	Recoatible with Topcoat MM 320 and Basecoat SB 120		
Helpful Tips	To ensure maximum adhesion and corrosion resistance on steel an etch Primer should be applied first. If the non sanding version is allowed to dry for longer than 6 hours, it should be thoroughly sanded before a topcoat is applied. As is usual when refinishing thermoplastic acrylic finishes, extra care should be taken and flash-off times should be extended.		
Colour	Grey		
Shelflife	1 year at 20°C		

FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

Brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

Head Office

Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.Lesonal.com