

Blend Fix 620



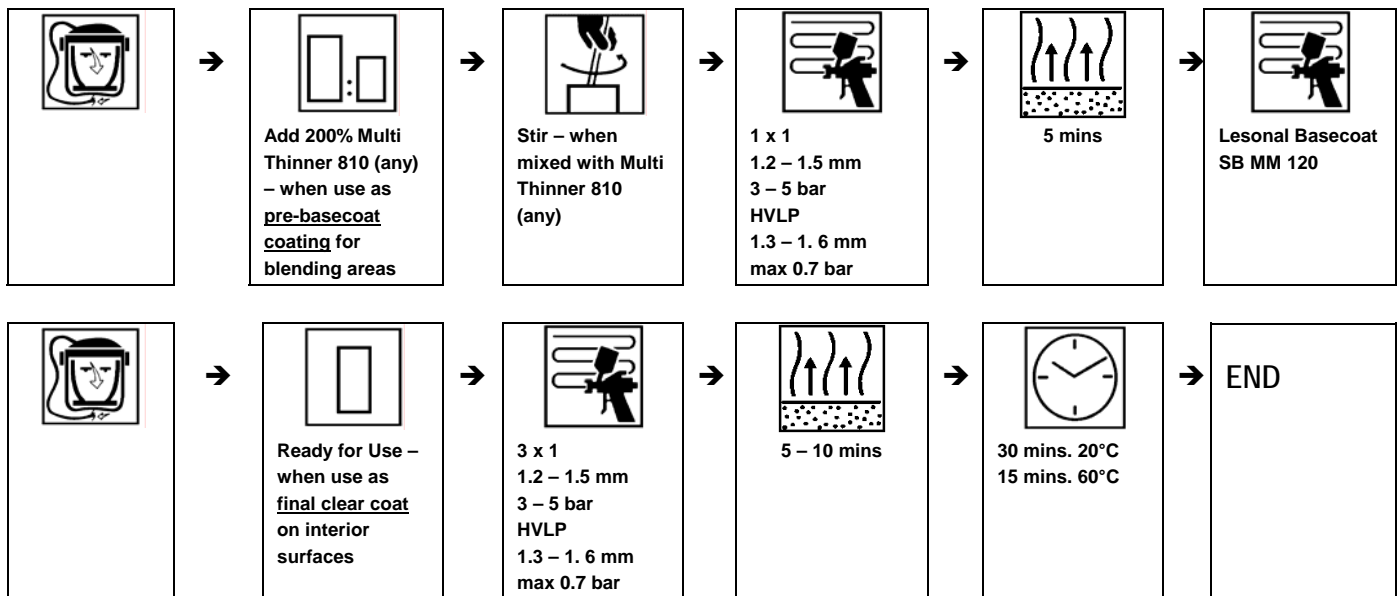
Technical Data Sheet



August 2006

INL 6.2.02

Description One-pack, air drying pre-basecoat coating for blending areas. Lesonal Blend Fix 620 can also be used as the final clear coat on interior surfaces.



Product & ancillary items

Product	Lesonal Blend Fix 620
Thinners	Lesonal Multi Thinner 810 (any)
Basic Raw Materials	Lesonal Blend Fix 620 – Physical drying binders Multi Thinner 810 (any) – A blend of organic solvents
“Method of use (Pre-Basecoat Coating)”	
Suitable Substrates:	Existing basecoat and clearcoat First degrease these areas with Akzo Nobel Wax and Grease Remover and abrade them with grey scuffing pad.
Mixing Ratio by Volume:	100 part of Lesonal Blend Fix 620 200 parts of Lesonal Multi Thinner 810 (any)
Application Technique:	Spray 1 single wet coat, allowing a flash-off time of 5 minutes before recoating with Lesonal Basecoat SB MM 120.
“Method of use (Final Clear Coat)”	
Suitable Substrates:	Interior car surfaces – under the hood
Mixing Ratio by Volume:	Ready for Use or add with Lesonal Multi Thinner 810 (any)

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Application Technique:	Spray 3 single wet coats, allowing flash off time of 5 – 10 minutes between coats.		
Drying Times:	30 minutes at 20°C or 15 minutes at 60°C Any overspray settled on the exterior surface of the car can be wet flatted lightly with P1000-grit paper after the specified drying times.		
Film Thickness:	10 – 20 µm per coat		
Theoretical usage per m2:	10 m ² at layer thickness of 15 micron. The practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances.		
Application Equipment and Spraying Pressure:	Spraygun	Fluid Opening	Spraying Pressure
	Gravity Feed	1.2 – 1.5 mm	3 – 5 bar
	Syphon Feed	1.4 – 1.6 mm	3 – 5 bar
	Pressure Feed	1.1 – 1.2 mm	5 – 6 bar
	HVLP Gravity Feed	1.3 – 1.6 mm	max 0.7 bar at the air-cap
	HVLP Suction Feed	1.5 – 1.7 mm	max 0.7 bar at the air-cap
Equipment Cleaning:	Use Lesonal Multi Thinner 810 (any) or Lesonal NC Thinner 820		
Colour:	Yellowish transparent		
Shelf life:	2 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.*