

2K HS Premium Clear 420

LESONAL

Technical Data Sheet

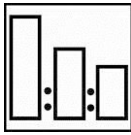
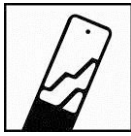


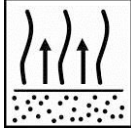
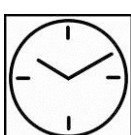

June 2016

L1.05.08 UK & Ireland

Clearcoats

Description

A complete 2 component clear system, which complies with the 420 g/l VOC limit in the EU legislation. The clearcoat is suitable for use on all types of repairs, in most application conditions. It combines easy application with good drying properties, brilliant gloss and it meets the highest demands of major motorcar manufacturers concerning scratch and car wash resistance.

Mixing ratio		5 3 1	2K HS Premium Clear 420 HS Hardener 420 Reducer Clear 420 or Accelerator
Mixing stick		P	
Equipment		Spray gun set-up: 1.2-1.4 mm	Application pressure: 1.7 – 2.2 bar* <small>*Please refer to user manual spraygun</small>
Application		2 x 1 coat	
Flash-off		Between coats 0 - 5 minutes at 20°C	Before curing 3 - 5 minutes at 20°C
Drying		Accelerator Reducer	20°C 60°C 3 hours 15 minutes 4 hours 25 minutes
Protection			

Read complete technical data sheet for detailed product information

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Product and additives

Product 2K HS Premium Clear 420

Hardener HS Hardener 420

Thinners Reducer Clear 420

Accelerator Lesonal Accelerator

Chemical Basis

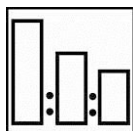
2K HS Premium Clear 420	– Acrylic resins
HS Hardener 420	– Polyisocyanate resins
Reducer Clear 420 / Accelerator	– A blend of organic solvents

Method of use

Substrates

Lesonal Basecoat WB
Lesonal WB GT

Mixing Ratio

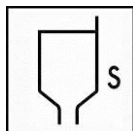


5 volumes - 2K HS Premium Clear 420
3 volume - HS Hardener 420
1 volume - Reducer Clear 420 / Accelerator

Using Mixing stick P

Mix in a parallel sided container and stir well

Spraying Viscosity



15 -17 sec. DIN Cup 4 at 20°C.

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Spraying pressure



Spraygun

HVLP Gravity
LVLP/HR Gravity

Fluid opening

1.2-1.4 mm

1.2-1.4 mm

*please refer to user manual of spraygun used

Spraying pressure

0.7 bar (at air cap)*

1.7-2.2 bar (at air inlet)*

Application



Apply a first light closed coat, after 0 to 5 minutes flash off apply a flowing second coat.
Allow 3 - 5 min. flash off before bake.

Note: Spraying without additional flash off is possible in case of larger repairs

Pot life

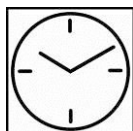
Accelerator

30 minutes at 20°C

Reducer Clear 420

45 – 60 minutes at 20°C

Drying Times



Accelerator	at 20°C	at 60°C
Dust free	30 min.	5 min.
Dry to handle	3 hrs.	15 min.
Reducer Clear 420	at 20°C	at 60°C
Dust free	1.5hrs.	15 min.
Dry to handle	4 hrs.	25 min.

Layer Thickness

45 - 60 microns in two coats

Theoretical coverage

Ready for use mixture at 1 micron layerthickness:

+/- 519 m²/liter

(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 or nitro cellulose thinner.

Shelflife

2 year at 20°C

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VOC

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/liter VOC.
The VOC content of this product in ready to use form is max. 420 g/liter.

Ancillaries

Matting Clear, TDS L1.05.03

Akzo Nobel Coatings LTD

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