

2K Graphite Filler

Technical Data Sheet

29 / 11 / 2018

L2.02.10 UK & Ireland

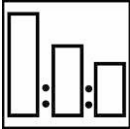



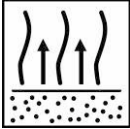




LESONAL

Primers/Surfacers

Description

Two component, VOC compliant dual-purpose filler, for general use in refinishing cars, and light commercial vehicles. By using a different mixing ratio Lesonal 2K Graphite Filler can be used as medium build sanding primer, or as lower build non-sand filler. Available in a white, grey and black version, for optimal coverage.

Sanding version

Mixing ratio		4 Lesonal 2K Graphite Filler 1 Lesonal Universal Hardeners 0.8 Lesonal Multi Thinner Standard / Fast
Mixing stick		V
Equipment		Spray gun set-up: 1.6-2.0 mm Application pressure: 1.7 – 2.2 bar at air inlet* *refer to user manual spray gun
Application		2 - 3 x 1 coat
Flash-off		Between coats 4 - 6 minutes at 20°C Before curing 4 - 6 minutes at 20°C
Drying		20°C 90 minutes 60°C 30 minutes
Sanding		Final sanding step: P400-P500
Recoatability		Topcoat HS 420 Basecoat WB Basecoat WB (GT)
Protection		

Read complete technical data sheet for detailed product information

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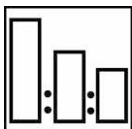
Primers/Surfacers

Description

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Non-Sanding version

Mixing ratio



3 Lesonal 2K Graphite Filler
 1 Lesonal Universal Hardeners
 0.6 Lesonal Multi Thinner Standard / Fast
 Lesonal 2K Graphite Filler Plastic Additive

Mixing stick



W

Equipment



Spray gun set-up:
 1.3-1.5 mm

Application pressure:
 1.7 – 2.2 bar at air inlet*

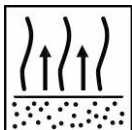
*refer to user manual spray gun

Application



1 x 1 coat

Flash-off



Flash off time before topcoat
 15 minutes at 20°C

Recoat within:
 24 hours at 20°C

Recoatability



Topcoat HS 420

Basecoat WB
 Basecoat WB (GT)

Protection



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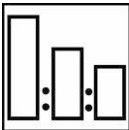



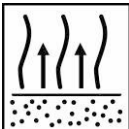


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Primers/Surfacers

Description

Two component, VOC compliant dual-purpose filler, for general use in refinishing cars, and light commercial vehicles. By using a different mixing ratio Lesonal 2K Graphite Filler can be used as medium build sanding primer, or as lower build non-sand filler. Available in a white, grey and black version, for optimal coverage.

Non-Sanding version for large surfaces

Mixing ratio		3 1 1	Lesonal 2K Graphite Filler Lesonal HS Hardener 420 Lesonal Multi Thinner Standard / Fast
Mixing stick		?	
Equipment		Spray gun set-up: 1.3-1.5 mm	Application pressure: 1.7 – 2.2 bar at air inlet* <small>*refer to user manual spray gun</small>
Application		1 x 1 coat	
Flash-off		Flash off time before topcoat 15 minutes at 20°C	Recoat within: 24 hours at 20°C
Recoatability		Topcoat HS 420	Basecoat WB Basecoat WB (GT)
Protection			

Read complete technical data sheet for detailed product information

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Description

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Product and additives

Lesonal 2K Graphite Filler Black, Grey, White
Lesonal Universal Hardener Fast
Lesonal Universal Hardener Extra Fast
Lesonal Universal Hardener Standard
Lesonal HS Hardener 420
Lesonal Multi Thinner Fast
Lesonal Multi Thinner Standard
Lesonal Multi Thinner HT
Lesonal 2K Graphite Filler Plastic Additive
Lesonal Flexible Additive
Lesonal Accelerator

Chemical Basis

Lesonal 2K Graphite Filler – Acrylic and Polyester resins
Lesonal Universal Hardener – Polyisocyanate resins
Lesonal HS Hardener 420 – Polyisocyanate resins
Lesonal Multi Thinners – A blend of organic solvents
Lesonal 2K Graphite Filler Plastic Additive – Polyolefine resin

Method of use

Grey Shades Please use the Lesonal GreyShaded Primer System wall chart to decide which primer shade should be used, or use the recommendation in LCD2000/Mixlink:

Code	GreyShade	Ratio	GreyShade
W	White	White 100	
W/G	Light Grey	White 50 / Grey 50	
G	Grey	Grey 100	
G/B	Dark Grey	Grey 50 / Black 50	
B	Black	Black 100	

If the code is followed by "ADV" the use of the Grey Shade is strongly recommended

Substrates

Sound original finishes, including thermoplastic acrylics
(Sanded) OEM Electrocoat
Directly on thoroughly cleaned OEM Electrocoat
Bare Steel
Lesonal 1K Etch Primer (RTS)
Lesonal Polyester Body Fillers
Lesonal Spraying Filler
Lesonal 1K Multi Plastic Primer (RTS)
Lesonal 2K Epoxy Primer

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Substrate preparation

Prior to commencing any sanding work, thoroughly cleanse the surface with Lesonal Degreaser.

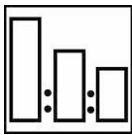
Original finishes and polyester laminates - Sand with P180 - P280 grit dry, or P280 - P400 wet.

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.

Lesonal Polyester Body Fillers - Finish sand with P180 / P280 grit dry.

After sanding work is completed, again degrease thoroughly with Lesonal Degreasers.

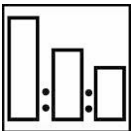
Mixing Ratio overview



Sanding

- 4 - Lesonal 2K Graphite Filler
- 1 - Lesonal Universal Hardener
- 0.8 - Lesonal Multi Thinner Standard / Fast

Mixing stick V

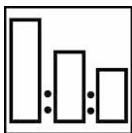


Non- sanding

- 3 volumes - Lesonal 2K Graphite Filler
- 1 volume - Lesonal Universal Hardener
- 0.6 volumes - Lesonal Multi Thinner Standard / Fast / Accelerator*

Mixing stick W

*This combination is **only** allowed over 1K Etch Primer

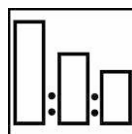


Non- sanding for large surfaces

- 3 volumes - Lesonal 2K Graphite Filler
- 1 volume - Lesonal HS Hardener 420
- 1 volume - Lesonal Multi Thinner Standard / Fast / Accelerator

Mixing stick?

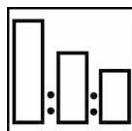
*This combination is **only** allowed over 1K Etch Primer



Plastic application (non- sanding)

- 3 volumes - Lesonal 2K Graphite Filler
- 1 volume - Lesonal Universal Hardener
- 0.6 volumes - Lesonal 2K Graphite Filler Plastic Additive

Mixing stick W



Plastic application (non- sanding)

- 3 volumes - Lesonal 2K Graphite Filler + Lesonal Flexible Additive (3:1 or 85:15)
- 1 volume - Lesonal Universal Hardener
- 0.6 volumes - Lesonal Multi Thinner

Mixing stick W

2K Graphite Filler

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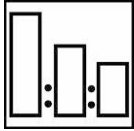
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Primers/Surfacers

Mixing Ratio (continued)



Under the Hood application

- 4 - Lesonal 2K Graphite Filler + 2K HS Premium Clear 420 (70:30)
- 1 - Lesonal Universal Hardener
- 0.8 - Lesonal Multi Thinner Standard / Fast

Mixing stick V

Spraying pressure



Sanding

Spraygun

- HVLP Gravity
- LVLP/HR Gravity

Fluid opening

- 1.6-2.0 mm
- 1.6-2.0 mm

Spraying pressure

- 0.7 bar (at air cap) *
- 1.7-2.2 bar (at air inlet) *

Non- sanding

Spraygun

- HVLP Gravity
- LVLP/HR Gravity

Fluid opening

- 1.3-1.5 mm
- 1.3-1.5 mm

Spraying pressure

- 0.7 bar (at air cap) *
- 1.7-2.2 bar (at air inlet) *

*Please refer to user manual spraygun used

Application



Sanding

Apply two or three single coats, allow to dry until mat after each coat

Non- Sanding

Apply one single coat

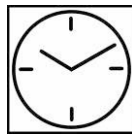
(Drying times will be very much influenced by factors such as temperature and air movement at the time of application).

Pot life

1 hour at 20°C

In combination with Accelerator 15 minutes at 20°C

Drying Times



<i>Sanding</i>	at 20° C	at 60° C
Dry to sand	90 min	30 min.
<i>Non- Sanding</i>		
Dry to recoat with topcoat	15 min.	N/A
Must be recoated within	24 hrs	N/A
Dry to sand	6 hrs	1 hour
Infra-red short-wave equipment	Half power	Full power
	4 min.	8 min.

Layer Thickness

Sanding: 40 - 45 microns

Non- sanding: 25 - 30 microns

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Theoretical coverage

Ready for use mixture at 1-micron layer thickness with ready for use mix:

Sanding: m ² /l	400
Non- sanding: m ² /l	389
Non- sanding for large surfaces m ² /l	422

Note: The practical coverage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Recoatability

Lesonal Topcoat HS 420
Lesonal Basecoat WB
Lesonal Basecoat WB GT

Recommended sandpaper grades

Method	Initial sanding	Final sanding
Wet sanding	P600	P800 – P1000
Dry sanding	P320	P400 – P500

Cleaning Equipment

Lesonal Use Multi Thinners or nitro cellulose thinner.

Helpful Tips

To ensure maximum adhesion and corrosion resistance on steel Lesonal 1K Etch Primer should be applied first. If the non- sanding version is allowed to dry for longer than 24 hours, it must 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.

Please use the Lesonal Grey Shaded Primer System wall chart to decide which primer shade should be used.

Color

White, Grey, Black

Shelf life

2 years

VOC

2004/42/IB(c)(540)540

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/liter VOC.
The VOC content of this product in ready to use form is max. 540 g/liter.

Ancillaries

Texture Additive, TDS L1.08.03
Flexible Additive, TDS L1.08.02

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Primers/Surfacers

AkzoNobel Coatings LTD

Address: Unit 2B, Didcot Park,
Churchward Road, Southmead Industrial Estate,
Didcot, Oxfordshire, OX11 7HB

Tel: 00 44 (0)1235 862226 **FOR PROFESSIONAL USE ONLY**

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