

# 2K High Build Filler

Technical Data Sheet

06 / 03 / 2019

L2.02.06

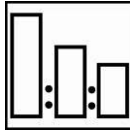
**LESONAL**

Primers/Surfacers

## Description

Two component high build primer/filler for general use in refinishing cars, and light commercial vehicles. User-friendly with excellent filling properties.

### Mixing ratio



5 2K High Build Filler  
1 Universal Hardener  
1 Multi Thinners

### Mixing stick



**G**

### Equipment



Spray gun set-up:  
1.8-2.0 mm

Application pressure:  
2 – 2.5 bar\*

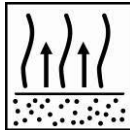
\* refer to user manual spray gun

### Application



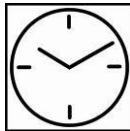
1 - 3 x 1 coat

### Flash-off



Between coats  
5 – 10 minutes at 20°C

### Drying



20°C  
3 hours

60°C  
30 minutes

### Sanding



Final sanding step:  
P400-P500

### Recoatability



Topcoat HS 420

Basecoat WB GT

### Protection



Read complete technical data sheet for detailed product information

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## Description

Two component high solid primer/filler for general use in refinishing cars, and also light commercial vehicles. User-friendly with excellent filling properties.

## Product and additives

Product 2K High Build Filler

Hardener Universal Hardeners

Thinner Multi Thinners

## Chemical Basis

2K High Build Filler	– Acrylic resins
Universal Hardener	– Polyisocyanate resins
Multi Thinner	– A blend of organic solvents

## GreyShades

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
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 GreyShade is strongly recommended

## Method of use

### Substrates

Sound original finishes, including thermoplastic acrylics  
Steel  
Aluminum, galvanized steel (first apply 1K Etch Primer)  
OEM Electrocoat (sanded)  
OEM Electrocoat Un-sanded, 2k High Build Filler can be applied directly on un-sanded surfaces, the OEM electrocoat should be thoroughly cleaned and degreased  
Lesonal 1K Multi Plastic Primer (RTS)  
Lesonal 1K Etch Primer (RTS)  
Lesonal Polyester Body Fillers  
Lesonal Polyester Spraying Filler  
Lesonal 1K Plastic Primer (RTS)  
Lesonal 2K Epoxy Primer  
Lesonal 2K Universal Plastic Primer

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## Substrate preparation

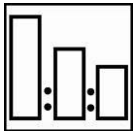
Prior to commencing any sanding work, thoroughly cleanse the surface with Lesonal Degreaser.

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 Filler, sand with P180 / P280 grit dry.

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

## Mixing Ratio



### By volume

5 volumes - 2K Sanding Filler  
1 volume - Universal Hardener  
1 volume - Multi Thinner

### By weight

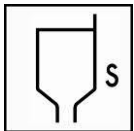
100 grams - 2K Sanding Filler  
13 grams - Universal Hardener  
12 grams - Multi Thinner

Mixing stick G

## Mixing proces

Stir or shake the 2K High Build Filler and add the Universal Hardener, stir the mix thoroughly before adding the required amount of Reducer and stir again.

## Spraying Viscosity



30 – 40 sec. DIN Cup 4 at 20°C.

## Spraying pressure



### Spraygun

HVLP Gravity / Conventional  
LVLP/HR Gravity

### Fluid opening

1.8-2.0 mm  
1.8-2.0 mm

### Spraying pressure

0.7 bar (at air cap)\*  
2-2.5 bar (at air inlet)\*

\*please refer to user manual spray gun used

## Application



Apply one coat over the total sanded area next apply the 2<sup>nd</sup> and 3<sup>rd</sup> coat within each preceding coat.

Where a full panel application is required apply 1-3 coats over the total panel dependent on the required film build.

## Pot life

1 hour at 20°C

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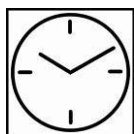
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Primers/Surfacers

## Drying Times



Dry to sand

at 20° C  
3 hrs

at 60° C  
30 min.

Infra red short-wave equipment

Half power  
3 min.

Full power  
11 min.

## Layer Thickness

70 - 100 microns

## Theoretical coverage

**Theoretical Coverage m<sup>2</sup>/ltr**

410 m<sup>2</sup>/liter, at a layer thickness of 1 micron ready for use mixture (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.

## Recoat ability

Topcoat HS 420 and Basecoat WB GT

## 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 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.

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

## Colour

White, Grey, Black

## Shelf life

2 years

## VOC

### 2004/42/IIB(c)(540)520

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. 520 g/liter.

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## **Akzo Nobel Coatings LTD**

**Address:** Unit 2B, Didcot Park  
Churchward, Southmead Industrial Estate  
Didcot, Oxfordshire, OX11 7HB  
**Tel:** 00 44 (0)1235 862226

### **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.

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#### **Head Office**

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. [www.Lesonal.com](http://www.Lesonal.com)

