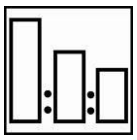
2K High Build Filler

Technical Data Sheet 06 / 03 / 2019 L2.02.06 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

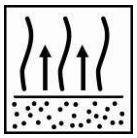
Spray gun set-up:
1.8-2.0 mm

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

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

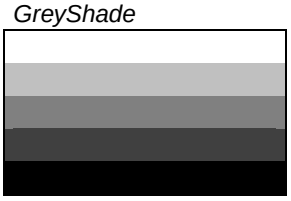
Chemical Basis

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*	*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 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

Substrate preparation

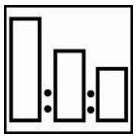
Prior to commencing any sanding work, thoroughly cleanse the surface with Lesonal Degreaser.

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



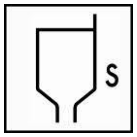
By volume		**By weight**	
5 volumes	- 2K Sanding Filler	100 grams	- 2K Sanding Filler
1 volume	- Universal Hardener	13 grams	- Universal Hardener
1 volume	- Multi Thinner	12 grams	- Multi Thinner

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	**Fluid opening**	**Spraying pressure**
HVLP Gravity / Conventional	1.8-2.0 mm	0.7 bar (at air cap)*
LVLP/HR Gravity	1.8-2.0 mm	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 2nd and 3rd 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

Drying Times

	at 20° C	at 60° C
Dry to sand	3 hrs	30 min.
Infra red short-wave equipment	**Half power**	**Full power**
	3 min.	11 min.

Layer Thickness

70 - 100 microns

Theoretical coverage

Theoretical Coverage m²/ltr

410 m²/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.

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

Head Office
AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.Lesonal.com