

2K Filler 540

Primers/Surfacers





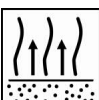




08/11/2019

L2.02.04 UK & Ireland

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 Filler 540 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		5 1 1	2K Filler 540 Universal Hardener Multi Thinner Standard / Fast
Mixing stick		G	
Equipment		Spray gun set up: 1.6-1.8mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap
Application		2-3 x 1 coat	
Flash-off		Between coats 5-10 minutes at 20°C	Before curing 5-10 minutes at 20°C
Drying			20°C 3 hrs 60°C 25-30 min
Sanding		Final sanding step: P400-P500	
Recoatability		Topcoat HS 420	Basecoat WB (GT)
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	

Read complete technical data sheet for detailed product information

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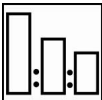



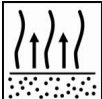


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NON-SANDING VERSION (VOC COMPLIANT)

Mixing ratio		6 1 3	2K Filler 540 HS Hardener 420 Thinner 540 Non-Sanding
Mixing stick		R	
Equipment		Spray gun set up: 1.2-1.4 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap
Application		1 x 1 coat	
Flash-off		Before Topcoat 15-20 minutes at 20°C	Recoat within 6 hours at 20°C
Recoatability		Topcoat HS 420	Basecoat WB (GT)
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	

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PRODUCT AND ADDITIVES

Product	2K Filler 540	
Hardener	Universal Hardener Extra Fast Universal Hardener Fast Universal Hardener Standard HS Hardener 420	
Thinner	Multi Thinner Fast Multi Thinner Standard Thinner 540 Non-Sanding	
Chemical Basis	2K Filler 540 Universal Hardener	Acrylic and Polyester resins Polyisocyanate resins

METHOD OF USE

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

Code	Grey Shade	Ratio	Grey Shade
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	Original finishes, including thermoplastic acrylics (sanded) OEM Electrocoat Steel 1K Etch Primer 1K Multi Plastic Primer 2K Epoxy Primer Polyester Body Filler Spraying Filler
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Substrate preparation	Original finishes: Sand with P180-P280 grit dry OEM Electrocoat: Sand with P180-P280 grit dry Steel: Sand with P180-P280 grit dry Polyester Body Filler: Sand with P180-P280 grit dry
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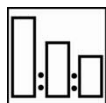
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Mixing ratio

Sanding

- 5 2K Filler 540
- 1 Universal Hardener
- 1 Multi Thinner



Mixing stick G

Non sanding VOC compliant

- 6 2K Filler 540
- 1 HS Hardener 420
- 3 Thinner 540 Non-Sanding

Mixing stick R

Spray gun set up



Sanding

Spray gun:
HVLP Gravity
LVLP/HR Gravity

Fluid opening:
1.6-1.8 mm
1.6-1.8 mm

Spraying pressure:
0.7 bar (at air cap)
1.7-2.2 bar (at air inlet)

Non sanding

Spray gun:
HVLP Gravity
LVLP/HR Gravity

Fluid opening:
1.2-1.4 mm
1.2-1.4 mm

Spraying pressure:
0.7 bar (at air cap)
2.0-2.2 bar (at air inlet)

Refer to user manual spray gun used

APPLICATION TECHNIQUE

Application

Sanding

Apply two or three single coats, allowing to dry until matt after each coat



Non sanding

Apply one single coat

Potlife

1 hour at 20°C

Equipment cleaning


Use Multi Thinners or nitro cellulose thinner

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Drying 	Sanding	20°C	60°C
	Dry to sand	3 hrs	25-30 min
	Non sanding		
	Recoat after	15-20 min	N/A
	Recoat within	6 hrs	N/A
	Dry to sand	6 hrs	1 hr
	Infrared short wave	Half power 4 min	Full power 8 min
Layer thickness	Sanding:	50 – 60 microns per coat	
	Non sanding:	15 – 20 microns	
Material usage	Ready for use mixture at 1 µm layer thickness:		
	Sanding:	400 m ² /liter	
	Non sanding:	366 m ² /liter	
	The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances		
Sandpaper grades	Dry sanding:	Initial sanding P320	Final sanding P400-P500
Recoatability	Topcoat HS 420 Basecoat WB GT		
Product storage	Avoid extreme temperature fluctuation and high humidity levels		
Shelf life	2 years at 20°C		
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/l VOC. The VOC content of this product in ready to use form is max. 540 g/litre.		
Ancillaries	Texture Additive : TDS L1.08.03 Flexible Additive : TDS L1.08.02		

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Akzo Nobel Coatings LTD

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FOR PROFESSIONAL USE ONLY

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