

2K Graphite Filler

Primers/Surfacers

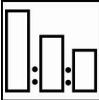



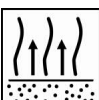

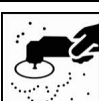


09/02/2020

L2.02.10 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 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 1 0.8	2K Graphite Filler Universal Hardener Multi Thinner Standard / Fast
Mixing stick		V	
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 4-6 minutes at 20°C	Before curing 4-6 minutes at 20°C
Drying			20°C 60°C 90 min 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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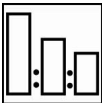



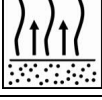


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NON-SANDING VERSION

Mixing ratio		3 1 0.6	2K Graphite Filler Universal Hardener Multi Thinner Standard / Fast
Mixing stick		W	
Equipment		Spray gun set up: 1.3-1.4 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 minutes at 20°C	Recoat within 24 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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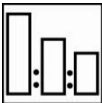



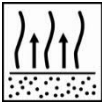


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NON-SANDING VERSION FOR LARGE AREAS

Mixing ratio		3 1 1	2K Graphite Filler HS Hardener 420 Multi Thinner Standard / Fast
Mixing stick		?	
Equipment		Spray gun set up: 1.3-1.5 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 minutes at 20°C	Recoat within 24 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 Graphite Filler	
Hardener	Universal Hardener Extra Fast Universal Hardener Fast Universal Hardener Standard HS Hardener 420	
Thinner	Multi Thinner Fast Multi Thinner Standard 2K Graphite Filler Plastic Additive Flexible Additive Accelerator	
Chemical Basis	2K Graphite Filler Universal Hardener HS Hardener 420 Multi Thinners 2K Graphite Filler Plastic Additive	Acrylic and Polyester resins Polyisocyanate resins Polyisocyanate resins A blend of organic solvents Polyolefine resin

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

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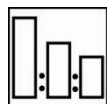
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Substrates Original finishes, including thermoplastic acrylics (sanded) OEM Electrocoat
 Steel
 1K Etch Primer
 1K Multi Plastic Primer
 2K Epoxy Primer
 Polyester Body Filler
 Spraying Filler

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

Mixing ratio/s



Sanding 4 2K Graphite Filler
 1 Universal Hardener
 0.8 Multi Thinner

Mixing stick V

Non sanding 3 2K Graphite Filler
 1 Universal Hardener
 0.6 Multi Thinner

Mixing stick W

* This mixture is to be sprayed only over 1K Etch Primer

Non sanding for (large surfaces) 3 2K Graphite Filler
 1 HS Hardener 420
 1 Multi Thinner Standard

Mixing stick

* This mixture is to be sprayed only over 1K Etch Primer

Plastic application (sanding) 3 2K Graphite Filler + Flexible Additive (3.1 or 85:15)
 1 Universal Hardener
 0.6 Multi Thinner

Mixing stick W

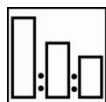
2K Graphite Filler

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Mixing ratio/s



Plastic application (non sanding) 3 2K Graphite Filler
1 Universal Hardener
0.6 Graphite Filler Plastic Additive

Mixing stick W

Under the Hood application 4 2K Graphite Filler + 2K HS Premium Clear 420 (70:30)
1 Universal Hardener
0.8 Multi Thinner

Mixing stick W

Spray gun set up



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)
1.7-2.2 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

With Multi Thinner: 1 hour at 20°C
With Accelerator : 15 minutes at 20°C

Equipment cleaning

Use Multi Thinners or nitro cellulose thinner

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09/02/2020

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Drying



Sanding	20°C	60°C
Dry to sand	90 min	30 min
Non sanding		
Recoat after	15 min	N/A
Recoat within	24 hrs	N/A
Dry to sand	6 hrs	1 hr
Infrared short wave	Half power 4 min	Full power 8 min

Layer thickness	Sanding :	40 – 45 microns per coat
	Non sanding :	25 – 30 microns

Material usage	Ready for use mixture at 1 µm layer thickness :	
	Sanding :	400 m ² /liter
	Non sanding :	389 m ² /liter
	Non sanding for large surfaces :	422 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		

Sanding grades	Initial sanding	Final sanding
	Dry sanding : P320	P400-P500

Recoatability	Topcoat HS 420 Basecoat WB GT
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Product storage	Avoid extreme temperature fluctuation and high humidity levels
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Shelf life	2 years at 20°C
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VOC	2004/42/II B(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/liter.
Ancillaries	Texture Additive : TDS L1.08.03 Flexible Additive : TDS L1.08.02

Akzo Nobel Coatings LTD

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FOR PROFESSIONAL USE ONLY

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Head Office

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