

Spraying Filler

Bodyfillers

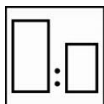
24/02/2020

L2.04.02 UK & Ireland

DESCRIPTION

A 2 component High build liquid polyester filler, which can be used on a wide range of substrates. Suitable for filling scratches and other surface imperfections. This high build Spraying Filler leaves a very smooth surface and is easy to sand even after overnight drying.

Mixing ratio



100
5
Spraying Filler
Spraying Filler Hardener

Equipment



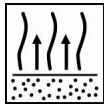
Spray gun set up:
2.2-2.5mm
Application pressure:
1.7-2.2 bar at the air inlet

Application



2-3 x 1 coat

Flash-off



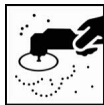
Between coats
0-5 minutes at 20°C
Before curing
0-5 minutes at 20°C

Drying



20°C
2 hrs
60°C
30 min

Sanding



Final sanding step: P280-P320

Recoatability



All Lesonal primers and fillers
With exception of waterborne products

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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PRODUCT AND ADDITIVES

Product Spraying Filler

Hardener Spraying Filler Hardener

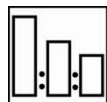
Chemical Basis	Spraying Filler	Polyester resins
	Spraying Filler Hardener	Organic peroxide

METHOD OF USE

Substrates Steel
 2K Epoxy Primer
 Polyester Body Filler

Substrate preparation Steel: Sand with P180-P280 grit dry
 Polyester Body Filler: Sand with P180-P280 grit dry

Mixing ratio 100 Spraying Filler
 5 Spraying Filler Hardener



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Spray gun set up



Spray gun:
LVLP/HR Gravity

Fluid opening:
2.2-2.5 mm

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

Refer to user manual spray gun used

APPLICATION TECHNIQUE

Application

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



Potlife

30 minutes at 20°C

Equipment cleaning

Use Multi Thinners or nitro cellulose thinner

Drying



Sanding
Dry to sand

20°C
2 hrs

60°C
30 min

Layer thickness

300 microns

Material usage

Ready for use mixture at 1 µm layer thickness :

400 m²/liter

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

Recoatability

Lesonal 1K Etch Primer (RTS)
Lesonal 1K Primer Filler (RTS)
Lesonal 2K HS Primer Filler
Lesonal 2K Filler 540 (RTS)
Lesonal 2K High Build Filler
Lesonal 2K Epoxy Primer
Lesonal Polyester Body fillers

Product storage

Avoid extreme temperature fluctuation and high humidity levels

Shelf life

6 months at 20°C

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VOC	2004/42/II(b)(250)200 The EU limit value for this product (product category : IIB.b) in ready to use form is max. 250 g/l VOC. The VOC content of this product in ready to use form is max. 200 g/litre.
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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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