

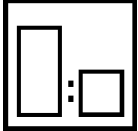
Gray Urethane Surfacer

FOR PROFESSIONAL USE ONLY

Description

Lesonal Gray Urethane Surfacer is intended for use as a high build surfacer that offers excellent filling, easy sanding, and fast dry times. Depending upon the mixing ratio used, Lesonal Gray Urethane Surfacer can also be used as a wet-on-wet primer sealer.

Mixture A: Primer Surfacer



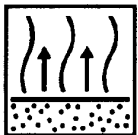
3:1
3 Parts Gray Urethane Surfacer
1 Part Urethane Surfacer Hardener



Use the Lesonal measuring stick #9



1x3x1
Siphon Feed:
0.071"– 0.078" (1.8–2.0 mm)
Gravity Feed:
0.071"–0.078" (1.8–2.0 mm)



5-10 minutes at 70°F (20°C)



3-4 hours at 70°F (20°C)
40 minutes at 140°F (60°C)



Use suitable respiratory protection

Contains acrylic and polyester resins. When mixed with hardener, also contains polyisocyanate.

Read complete TDS for detailed product information



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Product and additives

Product:	Lesonal Gray Urethane Surfacer
Hardeners:	Lesonal Urethane Surfacer Hardener
Reducers:	Lesonal Reducers
Additives:	Lesonal Accelerator Lesonal Flex Additive

Basic raw materials

- Lesonal Gray Urethane Surfacer: acrylic/polyester resins
- Lesonal Urethane Surfacer Hardener: polyisocyanate resin

Suitable surfaces

- Existing finishes, cleaned and sanded with #P240 to #P320 grit paper dry or #P500 to #P600 grit wet.
- Steel, cleaned and sanded with #P80 then #P180 grit dry.
- Lesonal Epoxy Sealers and Self-Etching Primer.
- Fiberglass gelcoat cleaned and sanded with #P180 grit dry

Note: For large areas of bare metal, one coat of Lesonal Gray Self-Etching Primer or Lesonal Epoxy Primer Sealer is recommended for maximum corrosion resistance.

Mixing ratio

Mixture A: As a surface

- 3 parts by volume of Lesonal Gray Urethane Surfacer
- 1 part by volume of Lesonal Urethane Surfacer Hardener

OPTIONAL UP TO:

- 1 part by volume of Lesonal Reducer

Note: For high build application, reducer is optional.

Accelerated Mixing: Add up to 2 capfuls or ½ ounce of Lesonal Accelerator per mixed ½ quart to the above mixing ratios.

Spraying viscosity

23–30 seconds DIN Cup #4 at 70°F (20°C).

Pot life

1 hour at 70°F (20°C)

With Accelerator: 30 minutes at 70°F (20°C).



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Spray gun & pressure

	Fluid Tip	Spraying Pressure	Fluid Pressure
Siphon Feed	1.8–2.0 mm (0.071"–0.078")	40–50 psi (3–4 bar)	
Gravity Feed	1.8–2.0 mm (0.071"–0.078")	40–50 psi (3–4 bar)	
Siphon HVLP	2.6 mm (0.125")	max. 10 psi max. (0.8 bar)	3–8 psi (0.3–0.6 bar)
Gravity HVLP	1.7–2.2 mm (0.067"–0.087")	max. 10 psi max. (0.8 bar)	

Application method

Apply 2 or 3 coats depending on the film thickness desired. Allow 5–10 minutes flash off between coats or until completely mat.

Film thickness

2.0-2.5 mils per single coat.

Flexible parts

As a primer surfacer for flexible parts, mix 5 parts of Gray Urethane Surfacer to 1 part of Flex Additive first (3:1 for soft parts), then add the appropriate hardener and reducer at a 3:1:1 ratio.

Drying times

To Sand	70°F (20°C)	100°F (38°C)	140°F (60°C)
w/o Accelerator	3–4 hours	1½ hours	40 minutes
w/ Accelerator	2–3 hours	1 hour	30 minutes

Sanding

Dry Sanding: pre-sand with #P220–#P240 grit, final sand with #P360–#P400 grit.
Wet Sanding: pre-sand with #P400 grit, final sand with #P500 to P600 grit

Recoatibility

Gray Urethane Surfacer may be recoated after sanding with all Lesonal topcoats.

Cover rate

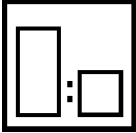
Approximately 60–70 sq. ft. per liter of Polysurfacer at a film thickness of 4 mils.

Gray Urethane Surfacers

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Description

Lesonal Gray Urethane Surfacers is intended for use as a high build surfacer that offers excellent filling, easy sanding, and fast dry times. Depending upon the mixing ratio used, Lesonal Gray Urethane Surfacers can also be used as a wet-on-wet primer sealer.

Mixture B: Wet on Wet Sealer

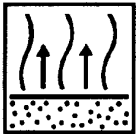
2:1:20%
 Gray Urethane Surfacers
 Urethane Surfacers Hardener
 Lesonal Reducer



Use the Lesonal measuring stick #4



1x1
 Siphon Feed:
 0.055"– 0.067" (1.4–1.8 mm)
 Gravity Feed:
 0.051"–0.059" (1.3–1.5 mm)



15 minutes at 70°F (20°C)



15 minutes at 70°F (20°C)
 Maximum 4 hours at 70°F (20°C)

**Use suitable respiratory protection**

Contains acrylic and polyester resins. When mixed with hardener, also contains polyisocyanate.

Read complete TDS for detailed product information

Gray Urethane Surfacer

FOR PROFESSIONAL USE ONLY

Suitable surfaces

- Existing finishes, cleaned and sanded with #P320 to #P400 grit paper dry or #P500 to #P600 grit wet.
- Steel, cleaned and sanded with #P80 then #P180 grit dry.
- Lesonal Epoxy Sealers and Self-Etching Primer.
- Fiberglass gelcoat cleaned and sanded with #P320 grit dry

Note: For large areas of bare metal, one coat of Lesonal Gray Self-Etching Primer or Lesonal Epoxy Primer Sealer is recommended for maximum corrosion resistance.

Mixing ratio**Mixture B: As a wet on wet sealer**

- 2 parts by volume of Lesonal Gray Urethane Surfacer
- 1 part by volume of Lesonal Urethane Surfacer Hardener
- 20% by volume of Lesonal Reducer
- Use measuring stick #4

Flexible parts

As a wet-on-wet sealer for flexible parts, mix 5 parts of 2.1–3.8 Urethane Surfacer to 1 part of Flex Additive first (3:1 for soft parts), then add the appropriate hardener and reducer at a 2:1:20% ratio.

Spraying viscosity

16-17 seconds DIN Cup #4 at 70°F (20°C).

Pot life

1 hour at 70°F (20°C)

Spray gun & pressure

	Fluid Tip	Spraying Pressure	Fluid Pressure
Siphon Feed	1.4–1.7 mm (0.055"–0.067")	40–50 psi (3–4 bar)	
Gravity Feed	1.6–1.8 mm (0.051"–0.055")	40–50 psi (3–4 bar)	
Siphon HVLP	1.8-2.2 mm (0.071"–0.087")	max. 10 psi max. (0.8 bar)	3–8 psi (0.3–0.6 bar)
Gravity HVLP	1.3–1.5 mm (0.051"–0.059")	max. 10 psi max. (0.8 bar)	

Application method

Wet-on-wet: Spray one single wet coat. On sanded through areas, first apply one thin coat, flash for 5-10 minutes, then apply one single wet coat, allowing for a flash off time of 15 minutes prior to topcoat (depending on temperature and film thickness applied).

Film thickness

1.2-1.5 mils per single coat.

Drying times

When used as a wet-on-wet sealer Lesonal Gray Urethane Surfacer used as a sealer can be recoated wet-on-wet after 15 minutes.



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Sanding

Dry Sanding: sand with #P360–#P400 grit
Wet Sanding: sand with #P500 to P600 grit

Recoatability

Lesonal Gray Urethane Surfacer may be recoated with all Lesonal topcoats up to 4 hours after initial application. After these stated dry times, sanding is required before application of topcoat.

Coverage rate

Approximately 220 sq.ft./liter per coat of unmixed paint as a wet-on-wet primer sealer and 100 sq.ft./liter as a primer surfacer.

Minimum shelf life

2 years if stored unopened at room temperature.

Color range

Medium Gray

Safety aspects**VOC Content:**

Lesonal Gray Urethane Surfacer: 1.4 lb/gal (168 g/liter)
Lesonal Urethane Surfacer Hardener: 5.2 lb/gal (625 g/liter)

Ready to Spray VOC

Lesonal Gray Urethane Surfacer, 3:1:1 ratio: 3.75 lb/gal (450 g/liter)
Lesonal Gray Urethane Surfacer, 2:1:20% ratio: 3.36 lb/gal (403 g/liter)

Notice: Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

Akzo Nobel Car Refinishes Inc. North America

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Tel: 770-662-8464

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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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