

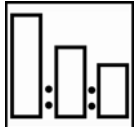
LESONAL

Lesonal Universal Clear LV

FOR PROFESSIONAL USE ONLY

Description

A two component VOC compliant clearcoat, designed for use over Lesonal Basecoat WB. Lesonal Universal Clear LV covers all sizes of repairs, under all application conditions, combined with high gloss level on Basecoat WB.



- 100 Lesonal Universal Clear LV
- 50 Lesonal Universal Clear LV Hardener
- 15 Lesonal Universal Clear LV Slow Reducer
- Lesonal Universal Clear LV Medium Reducer
- Lesonal Universal Clear LV Fast Reducer



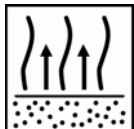
Lesonal Mixing Stick #10



<p>Spray gun set-up: 1.3-1.4 mm HVLP max. 10 psi at air cap</p>	<p>Application pressure: 29 psi (spray gun air inlet) o Check gun manufacturer specification</p>
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2 x 1 coat
First apply a medium closed coat, next apply a full coat after indicated flash off time



<p>Between coats 5-10 minutes at 70°F (20°C)</p>	<p>Before curing 0-10 minutes at 70°F (20°C)</p>
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Reducer selection	70°F (20°C)	140°F (60°C)
Lesonal Universal Clear LV Fast Reducer	4 hours	15 minutes
Lesonal Universal Clear LV Medium Reducer	5 hours	25 minutes
Lesonal Universal Clear LV Slow Reducer	6 hours	30 minutes



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

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Product and additives

Product	Lesonal Universal Clear LV
Hardener	Lesonal Universal Clear LV Hardener; a general purpose hardener for all repair sizes.
Reducers	Lesonal Universal Clear LV Slow Reducer; larger areas and overall refinishing at 95°F (35°C) and above Lesonal Universal Clear LV Medium Reducer; larger areas and overall refinishing at 77°F-95°F (25°C-35°C) Lesonal Universal Clear LV Fast Reducer; spot and panel repairs at or below 70°F (20°C)
Additives	Lesonal Flex Additive; additive to increase flexibility of Lesonal Universal Clear LV, for use on flexible parts.

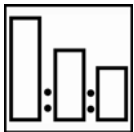
Basic raw materials

Lesonal Universal Clear LV	Polyol resins
Lesonal Universal Clear LV Hardener	Poly-isocyanate resins
Lesonal Universal Clear LV Reducers	special solvent blends

Suitable substrates

- Lesonal Basecoat WB; after a minimum flash off time of 15 minutes at 77°F (25°C).
- Existing finish that is thoroughly prepared, in the case of spot repairs and blending.

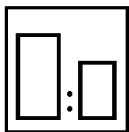
Mixing Ratio



100 parts by volume of Lesonal Universal Clear LV
50 parts by volume of Lesonal Universal Clear LV Hardener.
15 parts by volume of Lesonal Universal Clear LV Slow, Medium or Fast Reducer.

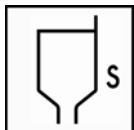
- o For easy and accurate mixing, use the attached mix by weight chart

Flexible car parts



To increase flexibility of Lesonal Universal Clear LV for use on flexible parts.
Before adding hardener and reducer prepare Lesonal Universal Clear LV as follows:
100 parts by volume Lesonal Universal Clear LV
10 parts by volume Lesonal Flex Additive
Use the measuring increments on the side of any mixing stick, 100:10%

Viscosity



14-16 seconds – DIN Cup #4 at 70°F (20°C)

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Spray gun set-up / application pressure



Spray gun

HVLP gravity
High Transfer gravity
High Transfer Pressure Feed
HVLP Pressure Feed

Fluid tip – set-up

1.3–1.4 mm
1.3–1.4 mm
1.0–1.2 mm
0.8–1.0 mm

Application pressure

HVLP max 10 psi at the air cap
○ Check gun manufacturer specification.

Application process



Apply a medium closed coat, allowing for a 5-10 minutes flash off time.
Next, apply a full coat, allowing for a 0-10 minutes flash-off time before baking.
○ Flash off between coats; in case of application to larger areas a minimal flash off time between coats is required

Pot-life

(The ready to spray mixture 100:50:15)

Lesonal Universal Clear LV Slow and Medium Reducer:	45 minutes	At 70°F (20°C)
Lesonal Universal LV Fast Reducer:	20 minutes	At 70°F (20°C)

Film thickness

Per coat: 1.0-1.2 mils. (20-30 µm)
The total dry layer thickness: 1.7-2.4 mils. (45-60 µm)

Drying times

Allow a 5 minute flash-off time before moving the car into a pre-heated drying oven (booth).
All drying times relate to standard application and object temperature.



	Lesonal Universal LV Fast Reducer	Lesonal Universal LV Medium Reducer	Lesonal Universal LV Slow Reducer
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70°F (20°C)	Dust dry	1 hour	1 ½ hours	2 hours
	Dry to handle	4 hours	5 hours	6 hours
122°F (50°C)	Dust dry	15 minutes	20 minutes	25 minutes
	Dry to handle	30 minutes	45 minutes	60 minutes
140°F (60°C)	Dust dry	10 minutes	15 minutes	20 minutes
	Dry to handle	15 minutes	25 minutes	30 minutes

Through-hardening:

Following the drying cycle at 140°F (60°C) object temperature, allow the Lesonal Universal Clear LV to cool fully to ambient temperature to complete the through-hardening process.

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Recoatability & blending

- Recoatable with itself after full drying cycle, sanding becomes necessary if there are defects or after 24 hours

Polishability



Dust and minor damage can be polished out after the stated air-dry times have been reached, or after a full bake at 140°F (60°C) object temperature, followed by a cool down of the object to ambient temperature. Carefully sand out dust particles and restore the surface according to the polishing recommendations.

- Ready to polish approximately 1 hour after cool down to ambient temperature.
- Carefully sand out dust particles with #1500 then #2000 grit paper wet or finish with the 3M Trizact Foam Disc P3000, and then start to polish the area mechanically with 3M Perfect-It 3 step system, Rubbing Compound PN 06085 with a Superbuff III 100% wool pad PN 05703. Follow with Machine Polish PN 06064 and finish with Ultrafina Machine Polish PN 06068 using the recommended pads.

Material usage

With recommended application, the theoretical material usage is ± 67.2 sq.ft./liter (6.2 m²/liter) RTS mixture.

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

Cleaning of equipment

Clean equipment with solvent borne gun cleaners

VOC

(100:50:15 Ready to spray mixture) Lesonal Universal Clear LV: 2.04 lb/gal 245 g/liter

Shelf Life

- Lesonal Universal Clear LV: One year if stored unopened at room temperature.
- Lesonal Universal Clear LV Hardener: One year if stored unopened at room temperature.
- Lesonal Universal Clear LV Reducers: One year if stored unopened at room temperature.

Akzo Nobel Car Refinishes Inc. North America

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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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