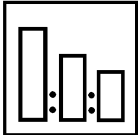


# LV650 Surfacers

**FOR PROFESSIONAL USE ONLY**

## Description

A two-component high solids urethane surface available in a dark grey color. Autocoat<sup>®</sup> BT LV650 Surfacers provides high build, excellent sanding properties and an extra smooth finish when sanded. Film build can be quickly achieved using a double coat application with minimum flash time between coats. LV650 Surfacers is specifically designed for the Truck OEM, CV Builder and Fleet markets. The LV650 Surfacers can be applied at a ready to spray VOC of 3.5 lbs/gal or 2.8 lbs/gal depending on reducer selection.



5	LV650 Surfacers
1	LV650 Hardener
1	LV650 Reducers

Use Sikkens Measuring Stick



## 23

Spray gun setup:

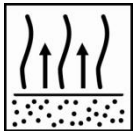
Check gun manufacturer specification



HVLP – Pressure Feed	1.4 – 2.0mm	Max 10psi	12 - 20 oz/min
HVLP – Gravity Feed	1.4 – 2.0mm	Max 10psi	



Apply two (2) to three (3) single flowing coats



Between coats  
30 seconds to 5 minutes at 70°F (21°C)

Wet on wet with topcoat  
20 minutes at 70°F (21°C)



Dry to Sand (5:1:1)	70°F (21°C)	140°F (60°C)
Dry to Sand (5:1:1 + 1oz LV650 BC Accelerator)	8 hrs	1 hour
	45 min	

70°F (21°C)

140°F (60°C)

8 hrs

1 hour

45 min



Recoat with:  
LV650 Sealer  
LV650 Basecoat  
LV650 Topcoat

Autobase Plus RV – with BT300 Hardener



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

Read complete TDS for detailed product information

# LV650 Surfacer

FOR PROFESSIONAL USE ONLY

## Description

A two-component high solids urethane surfacer available in a dark grey color. Autocoat<sup>®</sup> BT LV650 Surfacer provides high build, excellent sanding properties and an extra smooth finish when sanded. Film build can be quickly achieved using a double coat application with minimum flash time between coats. LV650 Surfacer is specifically designed for the Truck OEM, CV Builder and Fleet markets. The LV650 Surfacer can be applied at a ready to spray VOC of 3.5 lbs/gal or 2.8 lbs/gal depending on reducer selection.

## Suitable Surfaces

Existing finishes	#P220 to #P320 grit dry
Polyester bodyfiller	#P180 to #P220 grit dry
Aluminum (Alodine)	#P150 or red pad followed by Deoxidine 457 and Alodine 5700
Aluminum (Autoprep)	#P150 or red pad followed by Autoprep pretreatment wipes
Steel	#P80 to #P180 grit dry followed by B1000 / metal pretreatment
Galvanized steel	#P150 grit dry or red pad followed by B1000 / metal pretreatment
Fiberglass gelcoat (unbroken)	#P180 to #P220 grit dry
LV260 Primer EP	allow proper dry time

**\*If gelcoat surface is broken or sanded through, apply a polyester body filler prior to surfacer application**

Properly degrease substrate prior to sanding with M600, Ultra Prep surface cleaner or equivalent  
Other chemical cleaners and pretreatments need to be pre-approved by AkzoNobel

## Product and Additives

<b>Product</b>	LV650 Surfacer	
<b>Hardener</b>	LV650 Hardener	
<b>Reducer</b>	LV650 Reducer Medium	All applications
	LV650 Reducer Slow	All applications
	LV650 Reducer Extra Slow	All applications
	LV650 Reducer Exempt	All applications (2.8 VOC)
<b>Additives</b>	LV650 Basecoat Accelerator	Air dry applications

## Basic Raw Material

LV650 Surfacer	Polyol resins
LV650 Hardener	Polyisocyanate resins
LV650 Reducers	Solvents



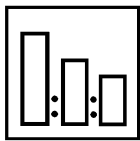
# LV650 Surfacer

FOR PROFESSIONAL USE ONLY

## Product Characteristics

WPG	13.2 +/- 0.2 lbs/gal	Gloss	Low
Volume Solids (RTS)	50% +/- 2%	Color	Dark Grey
Theoretical Coverage	795 ft <sup>2</sup> /gal @ 1mil – 100%TE	Pot Life (5:1:1)	1 hr @ 70°F (21°C)
		Pot Life (5:1:1 +1oz LV650 BC Accelerator)	30 min @ 70°F (21°C)

## Mixing

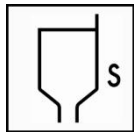


- 5 LV650 Surfacer
- 1 LV650 Hardener
- 1 LV650 Reducer

For accurate mixing, use measuring stick #23. Mix thoroughly.

Add 1oz of LV650 Basecoat Accelerator per mixed RTS gallon to speed up cure

## Viscosity



LV650 Surfacer Dark Grey                      12 – 16 sec                      EZ ZAHN #3 at 70°F (21°C)

Viscosity is reported as ready to spray

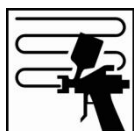
## Spray gun set-up / application pressure



HVLP – Pressure Feed	1.4 – 2.0mm	Max 10psi	12 - 20 oz/min
HVLP – Gravity Feed	1.4 – 2.0mm	Max 10psi	
HVLP – Siphon Feed	1.4 – 2.0mm	Max 10psi	
Pressure Feed	1.4 – 2.0mm	50 – 60psi	12 – 16 oz/min
Siphon Feed	1.4 – 2.0mm	50 – 60psi	
RP Gravity Feed	1.4 – 2.2mm	30 – 35psi	
Electrostatic	1.2 – 2.0mm	60 – 70psi	12 – 14 oz/min

*Check gun manufacturer specification*

## Application

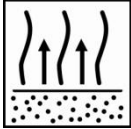


Apply two (2) to three (3) single flowing coats

# LV650 Surfacer

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## Flash off



30 seconds to 5 minutes at 70°F (21°C) between coats

20 minutes at 70°F (21°C) final flash before topcoating

## Dry times



### Object Temp

70°F (21°C)  
140°F (60°C)

### Dry to Sand (5:1:1)

8 hours  
1 hour

### Dry to Sand (5:1:1 + 1oz LV650 BC Accelerator)

45 minutes



140°F (60°C)

15 minutes

## Dry Film Thickness

Apply 1.2 – 1.4 mils per coat

## Recoatibility

LV650 Surfacer can be topcoated after a final flash of 20 minutes at 70°F (21°C). LV650 Surfacer can be topcoated without sanding up to 24 hours at 70°F (21°C), periods longer than 24 hours require the surface to be sanded.

## Recoatable with

LV650 Sealer  
LV650 Topcoat  
LV650 Basecoat

Autobase Plus RV – with BT300 Hardener

## Cleaning of equipment

Clean equipment with Sikkens Cleaning Solvent

# LV650 Surfacer

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## VOC

LV650 Surfacer	LV650 Reducer Medium, Slow, Xtra Slow	< 3.5 lb/gal	< 420 g/l
LV650 Surfacer	LV650 Reducer Exempt	< 2.8 lb/gal	< 336 g/l

VOC is ready to spray at a mix ratio of 5:1:1

## Product Storage and Shelf Life

Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.

LV650 Surfacer	2 years
LV650 Hardener	1 year
LV650 Reducers	2 years

## Available Pack Size and Item Numbers

483253	LV650 Surfacer Dk Grey	1 GL	509952	LV650 Hardener	1 QT
			397309	LV650 Hardener	1 GL
480495	LV650 Reducer Medium	1 GL			
480492	LV650 Reducer Slow	1 GL	391625	LV650 Basecoat Accelerator	1 PT
389761	LV650 Reducer Extra Slow	1 GL			
480973	LV650 Reducer Exempt	1 GL			

### FOR PROFESSIONAL USE ONLY

**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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