

EPOXY PRIMER SEALER

DESCRIPTION: Lesonal Epoxy Primer Sealer provides excellent corrosion resistance as a primer and a wet on wet sealer over multiple substrates. As a sealer, this product provides excellent leveling with superior gloss retention to the topcoat. As a primer, it can be used as a pre-treatment and will provide a fast re-coat time with other primers or topcoats. Available in a white, gray and black version, for optimal coverage.

PRODUCT & ADDITIVES:




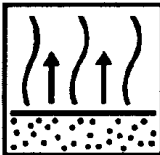
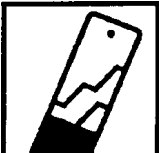
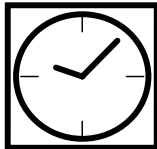
MAIN PRODUCT: Lesonal Epoxy Primer Sealer (White)
Lesonal Epoxy Primer Sealer (Gray)
Lesonal Epoxy Primer Sealer (Black)

HARDENERS: Lesonal Fast Epoxy Hardener
Lesonal Slow Epoxy Hardener

ADDITIVES: Lesonal Reducers

BASIC RAW MATERIALS: Lesonal Epoxy Primer Sealer: epoxy resins
Lesonal Epoxy Hardeners: polyamide resins

APPLICATION:

- | | | | | | |
|----|---|---|----|--|---|
| 1. |  | Contains epoxy resins. When mixed with hardener, also contains polyamides. | 4. |  | 1 Coat as a sealer
2-3 Coats as a primer surfacer
Siphon Feed: 1.6-1.8mm
Gravity HVLP: 1.3-1.5mm |
| 2. |  | 2:1+20%
Lesonal Epoxy Primer Sealer
Lesonal Fast Epoxy Hardener
Lesonal Reducers | 5. |  | 10 minutes at 70°F (20°C) |
| 3. |  | Use the Lesonal measuring Stick # 4. | 6. |  | Wet-on-Wet
15-30 minutes at 70°F (20°C)
Sanding
Overnight at 70°F (20°C)
45 minutes at 140°F (60°C) |




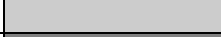


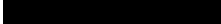
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SUITABLE SURFACES:

- Lesonal Epoxy Primer Sealer can be applied over the following 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 #P120 grit dry.
 - Galvanized steel, cleaned and sand with #P120 grit dry or scuff with a red scuffing pad.
 - Aluminum, clean and sand with #P150 to #P180 grit dry or scuff with a red scuffing pad.
 - Fiberglass and SMC, clean and sand with #P180 to #280 grit dry.
 - RIM, clean and scuffed.
 - OEM e-coat, Epoxy Primer Sealer may be applied to non-sanded, rigid OEM e-coated parts that have been thoroughly cleaned.

GRAY SHADES:

Please use the Lesonal Gray Shaded Primer System wall chart to decide which primer shade should be used, or use the recommendation in MIXIT

Code	Gray shade	Ratio	Gray shade
W	White	White (100%)	
W/G	Light gray	White 50 / Gray 50	
G	Gray	Gray (100%)	
G/B	Dark gray	Gray 50 / Black 50	
B	Black	Black (100%)	

- If the car color code is followed by “ADV” the use of the grey shade is strongly advised

MIXING RATIO:

2 parts by volume of Lesonal Epoxy Primer Sealer
1 part by volume of Lesonal Epoxy Hardener plus
20% by volume of Lesonal Reducer
For easy and accurate mixing, use the Lesonal Measuring Stick #4

NOTE:

- Mix the Epoxy material and the hardener thoroughly, and then add reducer.
- Always stir thoroughly prior to every application.
- For higher film builds the reducer is optional.

SPRAYING

VISCOSITY:

13–16 seconds DIN Cup #4 at 70°F (20°C).

POT LIFE:

After the components have been mixed, the pot life is:
12 hours with Epoxy Fast Hardener at 70°F (20°C).
12 hours with Epoxy Slow Hardener at 70°F (20°C).



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SPRAY GUN & PRESSURE

	Fluid Tip	Spraying Pressure	Fluid Pressure
Siphon Feed	1.6–1.8 mm	40–50 psi	
Gravity Feed	1.3–1.5 mm	40–50 psi	
Gravity HVLP	1.3–1.5 mm	max. 10 psi (at air cap)	
Siphon HVLP	1.8–2.2 mm	max. 10 psi (at air cap)	
Pressure Feed	1.0–1.2 mm	40–50 psi	8–10 psi

APPLICATION METHOD:

- As a **wet on wet sealer**: apply one medium flowing coat.
- As a **primer surfacer that will be sanded**: apply two-three single flowing coats allowing 10 minutes flash-off time between coats.
- As a **substrate for polyester products**: apply one single coat over the damaged areas. Allow this to dry for 30 minutes at 70°F (20°C) before applying a polyester filler.

FLASH TIME:

10 minutes between coats at 70°F (20°C).

RECOATING:

After the stated recoat time, the Lesonal Epoxy Primer Sealer can be recoated with Lesonal Basecoat SB and Lesonal surfacers for up to 7 days without sanding. After 7 days, sanding will be required to insure intercoat adhesion.

DRYING TIMES:

70°F (20°C)	Fast Hardener	Slow Hardener
Recoatable: Wet-on-wet	15 minutes	30 minutes
To sand: Two to three coats	12 hours	24 hours
140°F (60°C)		
To sand: Two to three coats	45 minutes	50 minutes

SANDING:

After the stated “dry to sand” time, Lesonal Epoxy Primer Sealer can be sanded with #P400 to #P500 grit paper dry or #P600 to #P800 grit wet before topcoating.

FILM

THICKNESS:

Approximately 1.0-1.4 mils per single coat.



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COVERAGE

RATE: Approximately 200 sq.ft./liter per coat of unmixed paint.

MINIMUM

SHELF LIFE: 2 years if stored unopened at room temperature.

SAFETY ASPECTS:

READY TO

SPRAY VOC: Lesonal Epoxy Primer Sealer, 2:1+20% ratio: 4.5 lb/gal (540 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 the Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of protective equipment when mixing and spraying this material. Protect skin with gloves and spray suits, wear safety glasses or goggles when mixing, and wear full hood fresh air fed respirator while spraying.

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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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