

LESONAL BASECOAT SB INTERIOR CONVERTER

DESCRIPTION: When mixed with Basecoat SB, Lesonal Interior Converter Gloss and Mat is a low gloss Specialty Coating designed for application over existing and new interior automotive parts. The Gloss and Mat Interior Converters provide consistent performance in a wide range of colors. Those colors are specifically matched to both the color and gloss of OEM standards.

PRODUCT & ADDITIVES


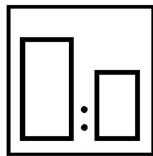


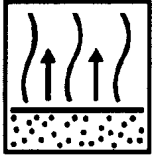
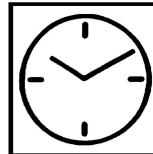
PRODUCT: Lesonal Interior Converter Gloss Toner 08/90ICG
Lesonal Interior Converter Mat Toner 09/90ICM

HARDENERS: Lesonal Clear hardener or Lesonal LV Clear Hardener

REDUCERS: Lesonal Reducers

BASIC RAW MATERIALS: Lesonal Basecoat SB Interior Converter: Vinyl/polyester resins and pigments

APPLICATION:

-  Contains vinyl/polyester resins and other ingredients. When mixed, may also contain polyisocyanate.
-  2 parts Lesonal Interior color
1 parts Lesonal Reducer
-  Use the Lesonal Measuring Stick # 4.
-  2x1
Siphon Feed: 1.6 mm
30–45 psi
Gravity HVLP: 1.3 mm
10 psi, max
-  3–5 minutes at 70°F (20°C)
-  Parts will be ready to handle in 15–20 minutes at 70°F (20°C).

SUITABLE SURFACES:

- Existing interior parts.
- New OEM interior parts (ABS, RIM)
- Lesonal All Plastic Primer (any polyolefin type plastic, i.e., PP, PE)

NOTE: Do not paint Air Bag Covers.

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SURFACE

PREPARATION: Degrease existing finishes and new parts with Lesonal Surface Cleaner or compliant surface cleaner. Removal of owner-applied waxes (Armor-All, etc.) is crucial for adhesion.

MIXING RATIO: Mix: 2 parts by volume of Lesonal Interior Color
1 parts by volume of Lesonal Reducer

UNAVAILABLE COLORS:

If a desired color is not available in the color documentation, use the color map to pick the Lesonal Basecoat SB formula closest to the original. Then mix 2 parts of the Lesonal Basecoat SB color to 1 part Lesonal Interior Converter 08 Gloss/ 09 Mat to achieve the desired gloss level. Use the Lesonal Measuring Stick # 4. Stir thoroughly, reduce and apply as normal.

GLOSS LEVEL:

The amounts of Lesonal Interior Converter mixed or blended will change the desired sheen depending on the ratio of Gloss Converter 08 or Mat Converter 09 intermixed. The total of Lesonal Interior Converter should not exceed 2 parts Lesonal SB color to 1 part Lesonal Interior Converter. Below is a chart describing the gloss level.

Gloss Description	Interior Converter	
	Gloss 08	Mat 09
Semi Gloss	100	0
Low Gloss	50	50
Matt	0	100

HARDENER SELECTION:

10% Lesonal Clear hardener or Lesonal LV Clear Hardener can be added to the Interior coating prior to reduction. The hardener will improve resistance to harsh solvents. Use of the hardener is optional. Hardener use will increase the gloss level of the coating. The balance of Gloss and Mat Interior Converter should be adjusted accordingly.

CLEARCOAT:

While not necessary or recommended, the interior finishes can be clearcoated as desired. In this case, treat the interior coating as Lesonal Basecoat SB for flash-times (20 minutes before clearcoating).

NOTE:

The interior coating with or without clearcoat should not be used on exterior parts.

SPRAYING VISCOSITY:

13–15 seconds Ford Cup #4 (13–15 seconds DIN cup #4) at 70°F (20°C).

POT LIFE:

After the components have been mixed, the pot life is 3–5 days without hardener, 4–6 hours with hardener. The reduced paint should be mixed periodically and before use.

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SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
Siphon Feed	1.6 mm 0.063"	30–45 psi
Gravity Feed	1.3–1.5 mm 0.051"–0.059"	30–45 psi
Gravity HVLP	1.3–1.5 mm 0.051"–0.059"	max. 0.8 bar max. 10 psi

APPLICATION METHOD:

Apply one single closed coat. Allow the coat to flash 3–5 minutes or until completely flashed-off. Apply a second closed coat as necessary for coverage.

FLASH TIME:

3–5 minutes at 70°F (20°C).

DRYING:

The interior coating will be dry to handle in 15–20 minutes at 70°F (20°C).

RECOATING:

The interior coating can be recoated with itself at any stage.

STOCK KEEPING:

CONTAINER SIZE:

One liter

SHELF LIFE:

Lesonal Interior Converter: 1 year at 70°F (20°C).

SAFETY ASPECTS:

FLASH POINT:

Lesonal Interior Converter: 80°F (27°C)

VOC CONTENT:

Lesonal Interior Converter: 4.8 – 5.3 lbs/gal (576–638 g/l)

READY TO SPRAY VOC:

Using the Lesonal Interior Converter mixed correctly with Lesonal Reducer, will yield a ready-to-spray VOC of 6.2 – 6.5 lbs/gal (744–780 g/l).

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.