




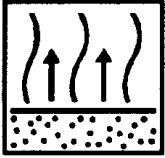

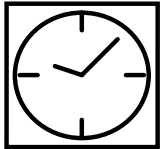
UNIVERSAL CLEAR

DESCRIPTION: Lesonal Universal Clear is a high-solids acrylic urethane clearcoat for use over Lesonal Basecoat SB. Lesonal Universal Clear offers high gloss and is designed for air-dry and baking conditions.

PRODUCT & ADDITIVES:

- PRODUCT:** Lesonal Universal Clear
- HARDENER:** —Lesonal Clear Hardener: a general-purpose hardener for all repairs.
- REDUCERS:**
- Lesonal Clear Extra Slow Activator: an extra slow activated reducer for larger areas and overall refinishing in warm weather. Temperatures of 90°F (32°C) and above.
 - Lesonal Clear Slow Activator: a general-purpose activated slow reducer for larger areas and overall refinishing. Temperatures of 60°F-105°F (16°-38°C).
 - Lesonal Clear Fast Activator: an activated fast reducer for medium and spot and panel repairs Temperatures of 60°F-90°F (16°-32°C).
- ADDITIVES**
- Lesonal Flex Additive: additive to increase flexibility for use on flexible parts.
 - Lesonal Accelerator: a catalyst additive, providing faster hardening of Lesonal Universal Clear.
 - Lesonal Mat Clear: a special clearcoat with a mat finish. The gloss of Lesonal Universal Clear can be reduced with blending of Lesonal Mat Clear.
- BASIC RAW MATERIALS:**
- Lesonal Universal Clear: hydroxyl acrylic resins
 - Lesonal Clear Hardener: polyisocyanate resins
 - Lesonal Clear Extra Slow / Slow Activator: special activated solvent blends
 - Lesonal Clear Fast Activator: activated reducers containing special solvent blends and catalyst.

APPLICATION:

- | | | | | | |
|----|---|--|----|--|--|
| 1. |  | Contains acrylic resins and other ingredients. When mixed, also contains isocyanates. | 4. |  | 2 x 1
HVLV Siphon
0.071"-0.087 (1.8-2.2mm)
HVLV Gravity
0.055"-0.059 (1.4-1.5mm)
Max 10 psi (max 0.8 bar) |
| 2. |  | 3:1:1
Lesonal Universal Clear
Lesonal Clear Hardener
Lesonal Clear Slow Activator | 5. |  | 5 - 10 minutes at 70°F (20°C) |
| 3. |  | Use the Lesonal measuring Stick # 7. | 6. |  | Lesonal Clear Slow Activator
10 hours at 70°F (20°C)
35 minutes at 140°F (60°C) |

UNIVERSAL CLEAR

SUITABLE SURFACES:

- Lesonal Basecoat SB Solid, Metallic and Pearl Colors: after a flash-off time of 15–20 minutes at 70°F (20°C).
- Existing finishes that have been sanded and degreased. In the case of spot repairs and blending, see TDS “Spot Repairs with Lesonal Basecoat SB”.

MIXING RATIO:

Mix: 3 parts by volume of Lesonal Universal Clear
1 part by volume of Lesonal Clear Hardener
1 part by volume of Lesonal Clear Extra Slow, Slow or Fast Activator

For easy and accurate mixing, use the Lesonal Measuring Stick #7.

Note: Lesonal Clear Extra Slow and Slow or Lesonal Clear Slow and Fast Activators may be blended together at a ratio of one to one. This makes Lesonal Universal Clear even more universal for different application circumstances. Please see information under “Drying Times”.

Alternatively Lesonal Universal Clear can be mixed as follows for colder or poor airflow environments:

Mix: 3 parts by volume of Lesonal Universal Clear
1 part by volume of Lesonal Clear Hardener
1½ parts by volume of Lesonal Clear Slow or Clear Fast Activator

For easy and accurate mixing, use the Lesonal Measuring Stick #7.

SPRAYING VISCOSITY:

13-15 seconds. DIN cup #4, 70°F (20°C)

POTLIFE:

4 hours at 70°F (20°C) using Lesonal Clear Extra Slow or Slow Activator
3 hours at 70°F (20°C) using a blend of Slow and Fast Activator
2 hours at 70°F (20°C) using Lesonal Clear Fast Activator

SPRAY GUN & PRESSURE:

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

APPLICATION METHOD:

Apply 2 single wet coats. If heavy sanding and polishing is required, a third coat may be applied after the stated flash off time.



UNIVERSAL CLEAR

FLASH TIME: 10–14 minutes at 70°F (20°C) with Lesonal Clear Extra Slow Activator
5–10 minutes at 70°F (20°C) with Lesonal Clear Slow Activator
5 minutes at 70°F (20°C) with Lesonal Clear Fast Activator

DRYING TIMES: Below is a table showing the drying times of Lesonal Universal Clearcoat. The air-dry times stated may vary with insufficient airflow.

Metal Temp.	Drying	Clear Extra Slow Activator	Clear Slow Activator	Clear Fast Activator
70°F (20°C)	Dust Free	90 min	1 hour	30 min
	Dry	12 hr	10 hr	5 hr
140°F (60°C)	Dust Free	25 min	25 min	10 min
	Dry	40 min	35 min	20 min

**DRYING TIMES:
(Lesonal Accelerator)**

Below is a table showing the drying times of Lesonal Universal Clear and the addition of two caps per sprayable quart of Lesonal Accelerator. The air-dry times stated may vary with insufficient airflow.

Metal Temp.	Drying	Clear Extra Slow Activator	Clear Slow Activator	Clear Fast Activator
70°F (20°C)	Dust Free	40 min	20 min	N/A
	Dry	9 hr	7 hr	N/A
140°F (60°C)	Dust Free	15 min	10 min	N/A
	Dry	30 min	25 min	N/A

RECOATABILITY: Lesonal Universal Clear can be re-coated with itself at any stage. Sanding will become necessary after 12 hours.

FILM

THICKNESS: 1.2–1.5 mils per single coat

**COVERAGE
RATE:**

Approximately 103 sq. ft./liter of unmixed paint at a film thickness of 2.5 mils

DECALS:

Decals can be applied after 48 hours at 70°F (20°C)

LETTERING:

Hand striping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a gray scuffing pad.



UNIVERSAL CLEAR

STOCK KEEPING:

COLOR: Clear

SHELF LIFE:

- Lesonal Universal Clear: One year if stored unopened at room temperature.
- Lesonal Clear Hardener: Six months if stored unopened at room temperature.
- Lesonal Clear Extra Slow, Slow and Fast Activator: One year if stored unopened at room temperature.

SAFETY ASPECTS:

**READY TO
SPRAY VOC:**

(3:1:1)

When mixed ready to spray,
Lesonal Universal Clear yields a VOC content of: 3.8 lb/gal 456 g/liter

(3:1:1½)

When mixed ready to spray,
Lesonal Universal Clear yields a VOC content of: 4.0 lb/gal 480 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.