LV HS Surfacer/Sealer

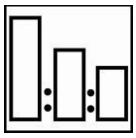
Technical Data Sheet November 18. 2009 L2.02.07

North America

Description LV HS Surfacer/Sealer is a Low VOC, High Solids urethane surfacer/sealer. Depending on the mixing ratio utilized, LV HS Surfacer/Sealer can be used as either a high build primer surfacer or wet-on-wet primer sealer.
Available in a white, gray and black version, for optimal coverage

Sanding primer surfacer

Mixing ratio



4 LV HS Surfacer/Sealer
1 LV HS Surfacer/Sealer Hardener
1 LV HS Surfacer Activator

Measuring stick

3

Equipment

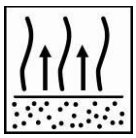
HVLP Spray gun set-up:
Siphon: 1.8-2.2 mm
Gravity: 1.7-1.9 mm

Application pressure:
HVLP max.10 psi at air cap

Application

3 -4 x 1 coat

Flash-off



Between coats

5 - 10 minutes at 70°F (20°C)

Drying

3 hours at 70°F (20°C)

30 minutes140°F (60°C)

Sanding

Final sanding step: #P400 to #P500 grit dry

Recoatability

Lesonal polyurethane top coats
Lesonal 1K
Basecoat SB
Basecoat WB

Protection

Read complete technical data sheet for detailed product information

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Available in a white, gray and black version, for optimal coverage

Non sanding primer sealer

Mixing ratio

MiXit Addit
Scale mixing only

Stir thoroughly

Equipment

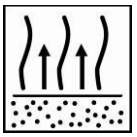
HVLP Spray gun set-up:
1.3-1.5 mm

Application pressure:
HVLP max.10 psi at air cap

Application

1 x 1 coat

Flash-off



Before top coat
15 - 20 minutes at 70°F (20°C)

Max. Recoat time, non sanding
1½ hours at 70°F (20°C)

Recoatability

Lesonal polyurethane top coats
Lesonal 1K
Basecoat SB
Basecoat WB

Protection

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Product and additives

LV HS Surfacer/Sealer (white)
LV HS Surfacer/Sealer (grey)
LV HS Surfacer/Sealer (black)

Hardeners LV HS Surfacer/Sealer Hardener

Reducers / Activators LV HS Surfacer Activator
LV HS Sealer Activator 2.1

Additives Lesonal Flex Additive: For application of LV HS Surfacer/Sealer over plastic parts. See information in this data sheet.
Note; Do not use Lesoanal Accelerator in LV HS Surfacer/Sealer.

Basic raw materials

LV HS Surfacer/Sealer:	acrylic resins
LV HS Surfacer/Sealer Hardener:	polyisocyanate resin
LV HS Surfacer Activator:	activated solvents
LV HS Sealer Activator 2.1	polyester resin, solvents and activator

Method of use

GreyShades Please use the Lesonal GreyShade Primer System wall chart to decide which primer shade should be used, or use the recommendation in MiXit:

Code	*Grey Shade*	*Ratio*	*GreyShade*
W	White	White 100 %	
W/G	Light Grey	White 50 / Grey 50	
G	Grey	Grey 100 %	
G/B	Dark Grey	Grey 50 / Black 50	
B	Black	Black 100 %	

If the car color code is followed by “ADV” the use of the GreyShade is strongly recommended

Suitable surfaces

Prior to commencing any work, thoroughly clean the surface with the appropriate Lesonal cleaner

Existing finishes, degreased and sanded with #P240 to #P320 grit paper dry.
Any premium polyester bodyfiller sanded with #P180 to #P220 grit dry. (note:*use the sanding surfacer)*
Steel, degreased and sanded with #P80 then #P120 grit dry.
Lesonal Epoxy Sealers and Gray Self-Etching Primer.
Fiberglass gelcoat cleaned and sanded with #P180 grit dry.

Note: For large areas of bare metal, one coat of Lesonal Gray Self-Etching Primer or Lesonal Epoxy Primer Sealer is recommended for maximum corrosion resistance.

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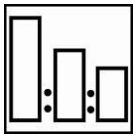
Suitable surfaces

Unsanded OEM E-Coat panels
Lesonal LV HS Surfacer/Sealer may be used on rigid OEM e-coats parts.
For edging of OEM e-coated parts, including exterior surfaces, utilize the sealer ratio. For edging in parts you have the option to utilize the primer surfacer ratio. Do not use this non-sanding process on "after market" parts, flexible or soft plastic parts.

Mixing Ratio



Sanding primer surfacer

4 parts by volume Lesonal LV HS Surfacer/Sealer
1 part by volume LV HS surfacer/Sealer Hardener
1 part by volume LV HS Surfacer Activator
Use the Lesonal measuring stick #3.

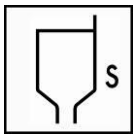
Non Sanding primer sealer

Please use the Addit feature on MiXit

- There is no measuring stick available

Components to be used:
– Lesonal LV HS Surfacer/Sealer
– LV HS surfacer/Sealer Hardener
–LV HS Sealer Activator 2.1

Spraying Viscosity



Sanding primer surfacer
15 - 16 sec. DIN Cup 4 at 70°F (20°C).

Non Sanding primer sealer
14 - 15 sec. DIN Cup 4 at 70°F (20°C).

Pot life

Sanding primer surfacer
45 minutes at 70°F (20°C)
30 minutes at 80°F (27°C)

Non Sanding primer sealer
1 hour at 70°F (20°C)
40 minutes at 80°F (27°C)

Spraying pressure

Spraygun	**Fluid opening**	**Spraying pressure**
Sanding primer surfacer		
High transfer Gravity	1.7-1.9 mm	Check gun manufacturer specification
HVLP Gravity	1.7-1.9 mm	Max. 10 psi at air cap

Non Sanding primer sealer		
High transfer Gravity	1.3-1.5 mm	Check gun manufacturer specification
HVLP Gravity	1.3-1.5 mm	Max. 10 psi at air cap

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Application

Sanding primer surfacer
Apply two, three or four single wet coats, allow to dry until mat (flash off time) between each coat, generally this will take 5 - 10 minutes.

Non sanding primer sealer
Apply one single wet coat. On sanded through areas, first apply one thin coat, flash for 5-10 minutes, then apply one single wet coat, allowing for a flash-off time of 15 to 20 minutes prior to topcoat.

(Flash off times will be very much influenced by factors such as temperature and air movement at the time of application).

Drying Times

Sanding primer surfacer	**At 70°F (20° C)**	**at 140°F (60° C)**
Dry to sand	3 hrs.	30 minutes.

Infra red short wave equipment		
Dry to sand	**Half power:**	4 minutes.
And then	**Full power:**	8 minutes.

Non sanding primer sealer	**at 70°F (20° C)**	**at 140°F (60° C)**
Dry to recoat with topcoat	15-20 min.	N/A
Must be recoated within	1 ½ hours	N/A
De-nib	20 minutes	N/A
Dry to sand	6 hours	45 minutes

Recommended sandpaper grades

Method	**Initial sanding**	**Final sanding**
Wet sanding	P600	P800
Dry sanding	P320	P400 to P500

Recoatability

Lesonal polyurethane top coats
Lesonal 1K
Basecoat SB
Basecoat WB

Film thickness

Sanding primer surfacer 1.5 – 1.8 mils (38 – 46 µm)
Non sanding primer sealer 1.2 – 1.4 mils (30 – 36 µm)
Note: The practical film build depends on many factors i.e. fluid tip size, air pressure at spray gun, application method and application circumstances.

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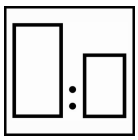
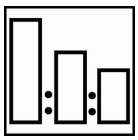
Flexible parts

As a primer for flexible parts:



For flexible parts; First mix
4 Parts by volume of LV HS Surfacer/Sealer
1 Part by volume of Lesonal Flex Additive

For soft parts: First mix
3 Parts by volume of LV HS Surfacer/Sealer
1 Part by volume of Lesonal Flex Additive



Further preparation:
To one of the above mixes, continue to mix as a Sanding Primer Surfacer or a Non Sanding Primer Sealer

Theoretical coverage rate

Sanding primer surfacer
75–85 sq. ft./liter (7.3–8.3 sq. meter/liter) per coat for unmixed paint.
Non sanding primer sealer
170–185 sq. ft./liter (17–18 sq. meter/liter) per coat for unmixed paint.

Note: The practical coverage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Cleaning Equipment

Clean equipment with solvent borne gun cleaners

Color

White, Grey, Black

Shelf life

Store products unopened, and used products with closed lids preferably between 50°F-95°F (10°C-35°C)
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

LV HS Surfacer/Sealer:	24 months at 70°F (20°C)	if stored unopened
LV HS Surfacer/Sealer Hardener:	6 months at 70°F (20°C)	if stored unopened
LV HS Surfacer Activator:	12 months at 70°F (20°C)	if stored unopened
LV HS Sealer Activator 2.1:	24 months at 70°F (20°C)	if stored unopened.

VOC

The VOC content of this product in ready to use form is:

Sanding primer surfacer: *(4:1:1)*	2.1 lb/gal	250 g/liter
Non sanding primer sealer : *(mixing by scale)*	2.1 lb/gal	250 g/liter

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