

2K PU Primer 488

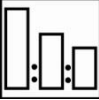





Primer Filler

01/08/2019

L2.02.12

DESCRIPTION

Lesonal 2K PU Primer 488 is a two component primer for general use in Automotive refinishing cars. By using a different mixing ratio, Lesonal 2K PU Primer 488 can be used as Non Sanding version. To achieve colors resembling to the most popular basecoat colors, different shades of primer can be achieved by mixing the primer with Lesonal Single Stage Topcoat toners.

Mixing ratio		Sanding Application 4 2K PU Primer 488 1 2K Hardener 728 (any) 1 Multi Thinner 810	Non Sanding Application 100 2K PU Primer 488 50 2K Hardener 728 (any) 30 Multi Thinner 810
Equipment		Sanding Application Spray gun set-up: 1.8-2.0 mm Non Sanding Spray gun set-up: 1.3-1.5 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.7 bar at the air cap Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.7 bar at the air cap
Application		Sanding 2-3 x 1 coat Spray one, two or three wet coats, allowing for a flash-off time of 5 -10 minutes between coats depending on temperature and film thickness applied. Non Sanding 1 x 1 coat Optional application; apply one thin coat, followed by a full wet coat	
Flash-off		Sanding Between coats 5-15 minutes at 20°C	Non Sanding Allow for a minimum flash off time of 15 minutes at 20°C prior to topcoat application. Apply topcoat within 24 hours at 20-30°C. 5-10 minutes at 20°C
Drying time		Sanding Drying: 2K PU Primer 488	30°C 1.5 hours 60°C 30 minutes
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	

Read complete TDS for detailed product information

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PRODUCT AND ADDITIVES

Product	2K PU Primer 488	
	Hardener	Lesonal 2K Hardener 728 B Lesonal 2K Hardener 728 C Lesonal 2K Hardener 728 CC
	Thinner	Lesonal Multi Thinner Fast 810-B Lesonal Multi Thinner 810-C Lesonal Multi Thinner HT 810-CC
	Colour	Light Grey

Basic raw materials	2K PU Primer 488: Acrylic resins 728 Hardener; Poly-isocyanate resins Multi Thinner 810; A blend of organic solvents
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METHOD OF USE

Suitable substrates	Original finishes, including thermoplastic acrylics Steel Polyester laminates Lesonal 1 Multi Plastic Primer	Lesonal EP Primer Grey 440 Lesonal 2K Putty 522 Washprimer 1K CF applied Galvanized steel, Zinc coated steel and alminuim
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Substrate preparation	Prior to any sanding work, thoroughly cleans the surface of any grease or wax with Lesonal Degreaser 910, using two clean cloths in a wipe-on wipe-off process. Original finishes– Sand with P220-P320 grit dry. Steel – Sand with P80-P180 grit dry 2K Putty 522 – Finish sand with P120-P220 grit dry. After sanding work is completed and just prior to application of 2K PU Primer 488, degrease again thoroughly with Lesonal Degreaser 910.
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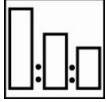
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Mixing



Sanding Application

- 4 2K PU Primer 488
- 1 2K Hardener 728 (any)
- 1 Multi Thinner 810

Non Sanding Application

- 100 2K PU Primer 488
- 50 2K Hardener 728 (any)
- 30 Multi Thinner 810

Spray gun set-up / application pressure



Sanding

- Spray gun Fluid tip-set-up 1.8-2.0 mm
- Gravity feed

- Application pressure 1.7-2.2 bar at the spray gun air inlet
- HVLP max 0.7 bar at the air cap

Non Sanding

- Spray gun Fluid tip-set-up 1.3-1.5 mm
- Gravity feed

- Application pressure 1.7-2.2 bar at the spray gun air inlet
- HVLP max 0.7 bar at the air cap

APPLICATION TECHNIQUE

Application process & blending



Sanding Application

Spray one, two or three wet coats, allowing for a flash-off time of 5 -15 minutes between coats depending on temperature and film thickness applied.

Non Sanding Application

Apply one to two single coats, allow to dry until mat between each coat, generally this will take 5 - 10 minutes.

Pot-life

- Sanding: 45 min to 1hour at 20°C
- Non Sanding : 1hour at 20°C

Film thickness

By using the recommended application: 50 – 60 µm per coat

Drying times



	Sanding	Non Sanding
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30°C	Recoat time		24 hours at 30°C
	Dry to sand	1½ hour	15 mins
60°C		30 mins	N/A

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Allow 5 minutes flash off prior to infra red curing
 Half Power IR: 5 minutes
 Full Power IR: 10 minutes
 The panel must not reach a temperature above 100°C while curing.
 For additional infra red drying information; see TDS S9.01.01

Theoretical Coverage 7 m²/l unthinned paint at 50 µm (the practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances).

Recoatability Recoatable with Topcoat MM 320 and Basecoat SB 120

Cleaning of equipment Use Lesonal Multi Thinner 810 (any)

Product Storage Product shelf-life is determined when products are stored unopened at 20°C.
 Avoid extreme temperature fluctuation.
 Product shelf life: 2 years

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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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