

2K Commercial White







Topcoat

24/10/2019

L5.01.03 AUS

DESCRIPTION

A two-pack, medium solid acrylic topcoat (WHITE) for larger surfaces on new work and refinishing systems of light commercial vehicles.

Mixing ratio		2 1 +10%	2K Commercial White 2K Hardener 720 (any) Multi Thinner (any)
Equipment		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		2-3 x 1 coat Apply two or three coats (depending on opacity), allow to become touch dry between each coat.	
Flash-off		Between coats 5-10 minutes at 20°C	
Drying times		With 2K Hardener 720	20°C 9 hours 60°C 25 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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A two-pack, medium solid acrylic topcoat (WHITE) for larger surfaces on new work and refinishing systems of light commercial vehicles.

PRODUCT AND ADDITIVES

Product	2K Commercial White	
	Hardener	Lesonal 2K Hardener 720 (any)
	Thinner	Lesonal Multi Thinner (any)

Basic raw materials	Lesonal 2K Topcoat MM 320; Acrylic Resins Lesonal 2K 720 (any); Polyisocyanate resins Lesonal Multi Thinner 810 (any); A blend of organic solvents
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METHOD OF USE

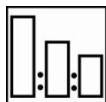
Suitable substrates	Original finishes, polyester laminates Lesonal 2K Primer 480 Lesonal 2K Primer 540 Lesonal EP Primer Grey 440
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Substrate preparation	Prior to commencing any sanding work, thoroughly cleanse the surface of any grease or wax with Lesonal Degreaser 910. Apply using two clean clothes in a wipe-on, wipe-off process.
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Sand with P800 – P1000 wet or Sand with P400 – P500 dry.

After sanding work is completed, and just prior to the application of 2K Commercial White, degrease again thoroughly with Lesonal Degreaser 910.

Mixing	2	2K Commercial White
	1	2K Hardener 720 (any)
	+10%	Multi Thinner (any)



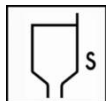
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Viscosity 15-16 sec DIN cup 4 at 20°C.



Spray gun set-up / application pressure	Spray gun Gravity feed	Fluid tip-set-up 1.3-1.5 mm	Application pressure 1.7-2.2 bar at the spray gun air inlet HVLP max 0.7 bar at the air cap
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APPLICATION TECHNIQUE

Application process & blending Apply 2 coats. Allow to become touch dry between each coat, generally this will take around 5-10 minutes flash off time between coats.
 Lettering:
 To be applied within 48 hours. After 48 hours, scuff with a grey scuffing pad.



Pot-life 2K Commercial White 4 hours at 20°C

Drying times



	2K Hardener 720-B	2K Hardener 720	2K Hardener HT 720-CC
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20°C	Dust dry	20 mins	30 mins	NA
	Dry to handle	4 hrs	9 hrs	NA
	Hard dry	9 hrs	12 hrs	NA
60°C	Dust dry	5 mins	5 mins	8 mins
	Dry to handle	15 mins	25 mins	35 mins
	Hard dry	20 mins	50 mins	60 mins

Cleaning of equipment Use Lesonal Multi Thinner 810 (any)

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Helpful tips

Application on thermoplastic acrylic finishes:
These types of finishes can be very sensitive to attack from solvents in the paint that you are applying. This can result in poor gloss and in extreme cases, contour mapping, and/or sanding scratch swelling. When applying Lesonal 2K Topcoat 320, the following could be done to avoid problems:

- 1) Extend the flash off time between coats.
- 2) Don't apply excessively heavy or double coats.

Similar attention should be paid when applying primers or surfacers.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.
Product shelf life data see TDS L9.01.02

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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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