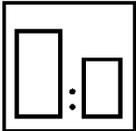
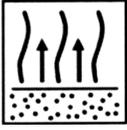
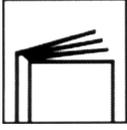


	North America	Technical Data Sheet
	Basecoat SB™	Basecoat
		09/16/2015
<b>FOR PROFESSIONAL USE ONLY</b>		

**Description**

Basecoat SB is the color for the Lesonal™ two-stage paint system. It provides color accuracy and ease of application. Basecoat SB is easily blended to provide the “invisible repair.” When used with the Lesonal™ clearcoat system a glossy and durable surface is achieved.

	<b>Safety Considerations</b> Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.	
	Agitate by shaking Basecoat SB toners prior to use.	
	2 1	Basecoat SB Color Lesonal Reducer  Stir color thoroughly prior to adding Lesonal Reducer
	Use Lesonal measuring stick #4	
	<b>HVLP or Compliant Spray-Gun Set-Up:</b> 1.3-1.5 mm	<b>Application Air Pressure:</b> Consult spray gun manufacturers' specifications. HVLP – 10 psi at the air cap maximum.
	<b>Application-Metallic Colors</b> 3 x 1 Coats	<b>Application – Solid Colors</b> 2-3 x 1 coats
	<b>Flash Between Coats at 70°F (20°C)</b> 2-5 minutes	<b>Flash Before Clearcoat at 70°F (20°C)</b> 15-20 minutes
	<b>Re-Coatable With:</b> <ul style="list-style-type: none"> <li>Lesonal Clearcoats</li> </ul>	

Read complete TDS for detailed product information.

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### Suitable Substrates

#### SUITABLE SURFACES

- All existing OEM finishes degreased and sanded
- Lesonal preparatory products

#### CANNOT BE APPLIED OVER

- AutoPrep Pretreatment wipes
- Acid containing wash primers
- Airbag covers
- Thermoplastic acrylic lacquers

### Products and Additives

**Product** Basecoat SB MM (Mixing Machine) toners

**Hardeners** Lesonal Clear Hardener Item #395734

- Hardener may be added to extend clearcoat time of Basecoat SB Solid colors.
- 5% of Hardener can be added to Basecoat SB color prior to the addition of Lesonal Reducer when spraying soft, foam spoilers.
- To meet National Rule VOC levels for 3 stage colors, 10% hardener must be added to the foundation color.

**Activators** Lesonal Reducer Extra Fast Item #394318  
-Spot and panel repairs, temperature range 50°F – 60°F (10°C – 16°C)

Lesonal Reducer Fast Item #394893  
-Spot and panel repairs, temperature range 60°F – 70°F (16°C – 20°C)

Lesonal Reducer Medium Item #394295  
-Panel repairs and large areas temperature range 70°F – 80°F (20°C – 27°C)

Lesonal Reducer Slow Item #394695  
-Larger areas and complete jobs temperature range 80°F – 90°F (27°C – 32°C)

Lesonal Reducer Extra Slow Item #394938  
-A specially designed reducer which can be used at extremely hot temperatures above 90°F (32°C)

\*Item numbers are provided for 1 gallon containers. Additional container sizes are available.

**Additives** Lesonal Basecoat SB Blending Additive Item #390166  
-A special blending additive that may be used while making spot repairs or fading out Basecoat SB

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### Basic Raw Materials

- Basecoat SB – Physically drying binders
- Lesonal Reducers – Special solvent blends
- Hardeners – Polyisocyanate resin

### Substrate Preparation

	<p>Dry sanding</p> <ul style="list-style-type: none"> <li>• Initial sanding steps may be executed with a coarser sanding grit; for example, <ul style="list-style-type: none"> <li>○ #P360 - #P400</li> </ul> </li> <li>• Final sanding step #P500 to #P600</li> </ul> <p><b>Note:</b> Respect a maximum 100 sanding grit step difference or less throughout the taken sanding steps.</p>
	<p>Wet sanding</p> <ul style="list-style-type: none"> <li>• Initial sanding steps may be executed with a coarser sanding grit #P500</li> <li>• Final sanding step #P600 to #P800</li> </ul> <p>Note: Respect a maximum 200 sanding grit step difference or less throughout the sanding steps.</p>
	<p>Surface Cleaning</p> <ul style="list-style-type: none"> <li>• AutoPrep UltraPrep</li> <li>• Surface Cleaner</li> </ul>

### Product Agitation

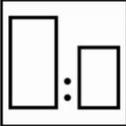
	<p>Basecoat SB MM toners must be stirred on a mixing machine for 15 minutes prior to use or agitate new toner on a shaker 10 minutes prior to use.</p>
	<p>Basecoat SB MM colors must be stirred thoroughly before and after reduction.</p>

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### Mixing Colors

	<p><b>Formulas</b></p> <ul style="list-style-type: none"> <li>A wide range formulas are available to match the most popular colors. These are available in MixitPro.</li> </ul> <p><b>Hand Mixing Colors</b></p> <ul style="list-style-type: none"> <li>Colors can be custom mixed.</li> </ul>
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### Basecoat SB Reduction

	<p>Basecoat SB solid or metallic colors are mixed as follows:  2 parts by volume of Basecoat SB Color with  1 part by volume of Lesonal Reducer</p> <p>For easy and accurate mixing, use the Lesonal Measuring Stick #4.  For example: pour Basecoat SB to the #1 in the first column and then pour Lesonal Reducer to the #1 in the second column</p> <p>Note: As an option for fading or applying the Basecoat SB in cold or poor airflow environments, Basecoat SB can be over-reduced with an additional 10% of Lesonal Reducer. This will aid in easier application and faster flash times. Use the centimeter side of the Lesonal measuring stick for over reduction.</p>
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### Viscosity When Mixed

	DIN Cup #4 70°F (20°C)	2:1 ratio – 14-16 seconds
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### Pot-Life When Mixed

Basecoat SB Mixed Colors	70°F (20°C)
Basecoat SB solid, metallic and pearl mixed colors	6 months
Basecoat SB 3 stage pearl colors	24 hours
Basecoat SB Mixed Colors containing Hardener	4 hours

### Spray Gun Set-Up

	Consult spray gun manufactures instructions for specific spray gun pressure specifications.		
	<b>HVLP Gravity</b> <b>Compliant Gravity</b>	1.3-1.5 mm 1.2-1.4 mm	Max 10 psi at cap Per manufacturer

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### Application Process

	<p><b>Basecoat SB Solid Colors</b></p> <ul style="list-style-type: none"> <li>Apply 3 single coats or until opacity is achieved. Primed areas and over areas where extra coverage is required, first apply a single thin coat.</li> <li>Flash off 2-5 minutes between coats</li> </ul>
	<p><b>Basecoat SB Metallic Colors</b></p> <ul style="list-style-type: none"> <li>Spray 3 single coats, at 4–6 inches from the panel allow approximately 2–5 minutes flash off between each coat.</li> <li>If necessary even out the metallic pattern with a metallic orientation coat after the third coat has flashed off completely. This is achieved by pulling the gun an additional two to four inches from the panel and applying a lighter orientation coat (drop coat). Do not make this coat too wet. With HVLP equipment, it is not necessary to lower the pressure, although this may be done in order to control the color.</li> </ul>
	<p><b>Basecoat SB Three Step Pearls</b></p> <ul style="list-style-type: none"> <li>Basecoat SB Solid Color (foundation coat): Spray 3 single coats, allowing approximately 2–5 minutes flash-off between each coat. Over primed areas and areas where extra coverage is required, apply first a single thin coat. Allow the foundation coat to dry for 15–20 minutes.</li> <li>Basecoat SB Pearl Color: Spray three to four even thin coats, allowing 2–5 minutes flash-off between coats. Do not lower the air pressure for the final coat.</li> </ul>
	<p><b>Basecoat SB Three Step Metallic</b></p> <ul style="list-style-type: none"> <li>Basecoat SB Metallic (foundation color): Mix as any metallic color; 2 parts by volume of Metallic foundation color with 1 part by volume of Lesonal Reducer. Spray 2–3 single coats (until covered), allowing 2–5 minutes flash-off between coats. If necessary, even out the metallic pattern by spraying an additional lighter orientation coat (drop coat).</li> <li>Mid-Coat Color: Mix the transparent mid-coat color; 2 parts by volume of Basecoat SB color with 1 part by volume of Lesonal Reducer. Spray 3–4 single wet coats, allowing a flash-off time of 5 to 10 minutes between coats.</li> </ul> <p>NOTE: To meet National Rule VOC levels for three-stage colors. The addition of 10% Lesonal Clear Hardener must be added to the “foundation color.” Use the centimeter side of the Lesonal measuring stick for the 10% addition of hardener.</p>

### Film Thickness – Using Suitable Application

Basecoat SB solid, metallic and pearl colors: 0.3-0.4 mils

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### Drying / Curing

Drying times are stated a recommended application method, film thickness and object temperature.

	<p>Allow Basecoat SB to dry for 15 to 20 minutes at 70°F (20°C) before applying the clearcoat. The maximum time Basecoat SB may be left before clear:</p> <ul style="list-style-type: none"> <li>-Basecoat SB Metallic Color: 48 hours</li> <li>-Basecoat SB Solid Color: 5 hours</li> </ul> <p>To extend the re-coat time of solid colors to 48 hours add 10% Lesonal Clear Hardener prior to the addition of Lesonal Reducer</p>
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### Recoating

	<p>Lesonal has a selection for clearcoats for application over Basecoat SB. The selection is based on many considerations including environment, VOC regulations and size of repair.</p>
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### Two Tone Application

	<p>Basecoat SB Solid or Metallic colors can be taped off with fine line masking tape after 20 minutes flash-off at 70°F (20°C) and a second color of Basecoat SB can then be applied.</p>
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### Second Repair

	<p>If during the application of Basecoat SB Solid or Metallic color, some damage occurs such as dust impregnation or perspiration spots, allow the Basecoat SB to flash off for 20 minutes at 70°F (20°C). Lightly sand the damaged area with #P600 to #P800 grit paper wet. As there is no clearcoat to protect the base coat at this stage, care must be taken to clean up all sanding residue.</p>
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### What to do

	<p>In the case of lifting; some substrates are not original or are unknown. Then it is reasonable to apply 2-3 coats of sanding primer surfacer, prior to Basecoat SB, over the whole panel. A pigmented sealer may also be used as a wet-on-wet process.</p> <p>In the case of fisheyes; caused by silicones, apply 2 mist coats of Basecoat SB over the contaminated area and proceed with the repair allowing longer flash times. If severe, it may be necessary to allow a dry time of 20-30 minutes, sand, and continue to spray Basecoat SB. Adding Anti-Silicone to Lesonal SB is not recommended, as this may lead to risk of poor clearcoat adhesion.</p>
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### Cleaning of Equipment

	Clean and rinse the spray gun thoroughly after use.
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### Theoretical Coverage

	<p>Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others.</p> <ul style="list-style-type: none"> <li>• 150 sq. ft./liter of unmixed paint per single coat</li> </ul>
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### VOC / Regulatory Information

	<p>Ready to spray VOC:          Basecoat SB 2:1 with Reducers: 6.7 lbs./gal. ≤800 g/liter          Basecoat SB 2:1 plus 10% additional Reducer: 6.7 lbs./gal. ≤805 g/liter</p> <p>Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.</p>
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### Product Storage

	<p>Product shelf-life is determined when products are stored unopened at 70°F (20 °C). Please reference the Lesonal Shelf Life TDS for the shelf life limits for each Basecoat SB component</p>
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AkzoNobel

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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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