



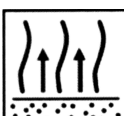


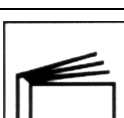

	North America	Technical Data Sheet
	Universal Clear	Clearcoat
		6.01.2016
FOR PROFESSIONAL USE ONLY		

Description

The Lesonal™ Universal Clear is an acrylic urethane clearcoat for use over Lesonal™ Basecoat SB or Lesonal™ Basecoat WB and intended for applications in cross flow and air dry conditions. Universal Clear offers excellent resistance to surface contamination with excellent gloss, making it an ideal choice for air-dry environments.

	Safety Considerations 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.	
	Mixing 3 1 1 - 1.5	Lesonal Universal Clear Lesonal Clear Hardener Lesonal Clear Extra Slow, Slow or Fast Activator
	HVLP or Compliant Spray-Gun Set-Up: 1.3-1.5 mm	Application Air Pressure: Consult spray gun manufacturers' specifications. HVLP – 10 psi at the air cap maximum.
	Application Apply 2 single wet coats. If heavy sanding and polishing is required, a third coat may be applied after the stated flash time.	
	Flash Between Coats at 70°F (21°C) 5-10 minutes	Flash Before Force Drying at 70°F (21°C) 5-10 minutes
	Air Drying at 70°F (21°C) Dust Free – Slow Activator 60 minutes	Dry to Handle – Slow Activator 10 hours <i>Dependent of film weight.</i>
	Force Drying at 140°F (60°C) Dry to Handle – Slow Activator 35 minutes	Infra-Red Not recommended
	Re-Coatable With: Lesonal Universal Clear can be recoated with itself at any stage. Sanding will become necessary after 12 hours.	

Read complete TDS for detailed product information.

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Suitable Substrates

- Lesonal SB Solid, Metallic and Pearl Colors after a flash off time of 15-20 minutes at 70°F (21°C)
- Lesonal WB Solid, Metallic and Pearl colors after a flash off time of 15-20 minutes at 70°F (21°C)
- Existing finishes that have been sanded and degreased.


Products and Additives

Product	Lesonal Universal Clear	Item #398547
Hardeners	Lesonal Clear Hardener	Item #395734
Activators	Lesonal Clear Extra Slow Activator	Item #391001
	Lesonal Clear Slow Activator	Item #398548
	Lesonal Clear Fast Activator	Item #398549
Additives	Lesonal Flex Additive	Item #396027
	Lesonal Accelerator	Item #397672
	Add 0.5 oz per ready to spray quart	
	Lesonal EZ Matte	Item #510528

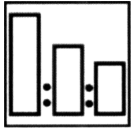
Basic Raw Materials


- Lesonal Universal Clear – Hydroxyl Acrylic resins
- Lesonal Clear Hardener – Poly-isocyanate resins
- Lesonal Clear Slow and Extra Slow Activators – Special activated solvent blends
- Lesonal Clear Fast Activator – Activated reducer containing special solvent blends and catalyst

Substrate Preparation

	Cleaning
	<ul style="list-style-type: none"> • If needed pre-wash the repair with warm soap and water. Rinse completely with clean water. • Clean with Surface Cleaner or Autoprep Ultra Prep Surface Cleaner. • Avoid saturating body filler with water or cleaners while washing the repair.


Mixing – General

 <p>#7 Stick</p>	<p>3 1 1 – 1.5</p>	<p>Parts by volume Universal Clear Parts by volume Lesonal Clear Hardener Parts by volume Lesonal Clear Activator</p> <p>Use the Lesonal #7 measuring stick when mixing by hand.</p>
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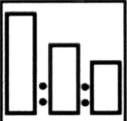
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Mixing – Flexible Parts

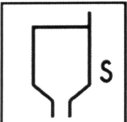
If the part to be painted can be deformed by hand, increase the flexibility of Universal Clear as follows.

	100 30	Parts by volume Lesonal Universal Clear Parts by volume Lesonal Flex Additive
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Stir the paint with Flex Additive together THEN –

 #7 Stick	3 1 1-1.5	Parts by volume Universal Clear Parts by volume Lesonal Clear Hardener Parts by volume Lesonal Clear Activator Use the Lesonal #7 measuring stick when mixing by hand.
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Viscosity When Mixed

 DIN #4	13-15 SECONDS	Measured with a DIN #4 viscosity cup at 70°F (21°C).
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Pot-Life When Mixed

Product Mix	70°F (21°C)
Using Lesonal Clear Extra Slow or Slow Activator	4 hours
Using Clear Fast Activator	2 hours

Spray Gun Set-Up


	Consult spray gun manufactures instructions for specific spray gun pressure specifications.		
	Spray Gun	Fluid Tip	Application Pressure
	HVLP Gravity Fed	1.3-1.5 mm	<10 psi at cap
	Compliant Gravity Fed	1.3-1.5 mm	<10 psi at cap

Application

	Apply 2 single wet coats. If heavy sanding and polishing is required, a third coat may be applied after the stated flash time. Allow a flash off time between coats of 5-10 minutes. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.
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Film Thickness – Using Suitable Application

1 coat will achieve a thickness of 1.2-1.5 mils (30 – 38µm).

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Drying / Curing Time


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

	70°F (21°C)		140°F (60°C)	
	Dust Free	Dry to Handle	Dust Free	Dry to Handle
Lesonal Clear Extra Slow Activator	90 min.	12 hours	25 min.	40 min.
Lesonal Clear Slow Activator	60 min.	10 hours	25 min.	35 min.
Lesonal Clear Fast Activator	30 min.	5 hours	10 min.	20 min.

Lesonal Universal Clear Accelerated

Lesonal Clear Extra Slow Activator	40 min.	9 hours	15 min.	30 min.
Lesonal Clear Slow Activator	20 min.	7 hours	10 min.	25 min.
Lesonal Clear Fast Activator	Not recommended	Not recommended	Not recommended	Not recommended


Recoating

	Lesonal Universal Clear can be recoated with itself at any stage. Sanding will become necessary after 12 hours.
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Decals / Lettering


	Decals can be applied after 48 hours at 70°F (21°C). Hand striping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a gray scuff pad.
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Cleaning of Equipment

	Clean equipment following local and federal regulations.
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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"> • Ready to spray mixture at 1.0 mil, 100% TE – 700 sq ft/L (17 m²/L)
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VOC / Regulatory Information

When mixed ready to spray, Lesonal Universal Clear yields a VOC content of: 3.8 lb/gal 464 g/liter

Product Storage

Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).	
Lesonal Universal Clear	12 months
Lesonal Clear Hardener	6 months
Lesonal Clear Activator Extra Slow, Slow and Fast	12 months

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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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