
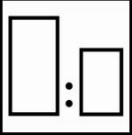





	North America	Technical Data Sheet
	ProAir Clear 2 Pack™	
	Clearcoat 06.02.2016	
FOR PROFESSIONAL USE ONLY		

Description

The **Lesonal™** ProAir Clear 2 Pack Fast or Slow Clear is an acrylic urethane clearcoat for use over **Lesonal™** Basecoat SB or Lesonal WB and intended for applications in cross flow and air-dry conditions. ProAir Clear 2 Pack Fast or Slow Clear offers a **built in flex package** and 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.	
 #4 Stick	Mixing 2 1	Lesonal ProAir Clear 2 Pack Fast or Lesonal ProAir Clear 2 Pack Slow Lesonal ProAir Clear Hardener
	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 medium wet coats allowing for flash in between.	
	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) Dry to Handle 3 hours – ProAir Clear 2 Pack Fast 8 hours – ProAir Clear 2 Pack Slow	Force Drying at 120°F (49°C) Dry to Handle 20 minutes – ProAir Clear 2 Pack Fast 30 minutes – ProAir Clear 2 Pack Slow *Do not exceed 120°F as you may experience coating defects.

Read complete TDS for detailed product information.

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Suitable Substrates

- Lesonal WB Basecoat- after a flash off time of 15-20 minutes at 70°F (21°C)
- Lesonal SB Basecoat – after a flash off time of 15-20 minutes at 70°F (21°C)
- Existing finishes that have been sanded and degreased in the case of spot repairs and blending.

Products and Additives

Product	ProAir Clear 2 Pack Fast	Item #539485
	ProAir Clear 2 Pack Slow	Item #539486
Hardeners	ProAir Clear Hardener	Item #539540
	General purpose hardener for all repair sizes	
Additives	EZ Matte	Item #510528
	Lesonal Accelerator	Item #397672
	Lesonal Flex Additive (For soft parts only)	Item #396027

Basic Raw Materials

- ProAir Clear 2 Pack Fast and Slow – Acrylic polyol resins
- ProAir Clear Hardener - Polyisocyanate resins
- Additives - Refer to the individual TDS for information.

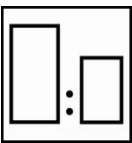
Substrate Preparation




Surface Cleaning – Prior to Paint Application

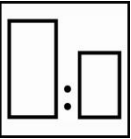
- Clean with Sikkens M600, Autoclean or Anti-Static surface cleaners.

Mixing – Standard Ratio

 #4 Stick	2 1	Parts by volume ProAir Clear 2 Pack Fast or Slow Parts by volume ProAir Clear Hardener
	ProAir Clear 2 Pack Fast and Slow Clearcoats can be blended to accommodate spraying conditions	

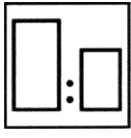
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Mixing – Accelerated Ratio

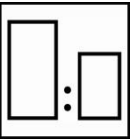
 #4 Stick	2 1 1 ounce to RTS quart	Parts by volume ProAir Clear 2 Pack Fast or Slow Parts by volume ProAir Clear Hardener Parts by volume Lesonal Accelerator
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Mixing – Soft Parts


Lesonal ProAir Clear 2 Pac does not require flex additive when being applied over plastic substrates. However, Lesonal Flex Additive is needed when soft foam parts are being painted.

	100 10-15%	Parts by volume ProAir 2 Pack Fast or Slow Clearcoat Parts by volume Lesonal Flex Additive
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Stir the paint with Flex Additive together THEN –

 #4 Stick	2 1	Parts by volume ProAir Clear 2 Pack Fast or Slow with Flex Additive Parts by volume ProAir Clear Hardener
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Viscosity When Mixed

 DIN #4	14-17 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)
ProAir Clear 2 Pack Fast	2 hours
ProAir Clear 2 Pack Fast Accelerated	1.5 hours
ProAir Clear 2 Pack Slow	4 hours
ProAir Clear 2 Pack Slow Accelerated	2 hours

Spray Gun Set-Up

	Spray Gun	Fluid Tip	Application Pressure
	HVLP Gravity Fed	1.3-1.5 mm 0.055"-0.059"	8-10 psi at air cap 0.65-0.8 bar at air cap
	Compliant Gravity Fed	1.3-1.5 mm 0.055"-0.059"	Consult equipment manufacturer's recommendations.

Application

	<p>Apply 2 single flowing coats. If heavy sanding and polishing is required, a third coat may be applied after the stated flash off time.</p> <p>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.</p>
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Film Thickness – Using Suitable Application

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

Drying / Curing Time

Below is a table showing the drying times of Pro Air Clear 2 Pack Fast or Slow with Pro Air Clear Hardener. The air-dry times stated may increase with insufficient airflow.

Drytimes were measured under the following conditions:

- Testing was done at 70°F (21°C).
- Temperatures are reported as metal temperature.
- Accelerated drytimes were measured when 1 ounce of Lesonal Accelerator is added per ready to spray quart or clearcoat.




	Slow	Slow / Fast (75% / 25%)	Slow / Fast (50% / 50%)	Slow / Fast (25% / 75%)	Fast
Standard Mix Dust Free	20 minutes	15 minutes	15 minutes	15 minutes	10 minutes
Accelerated Mix Dust Free	10 minutes	10 minutes	5 minutes	5 minutes	5 minutes
Standard Mix Dry	8 hours	7-1/2 hours	4 hours	3-1/2 hours	3 hours
Accelerated Mix Dry	4 hours	3 hours	2-1/2 hours	2 hours	2 hours

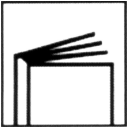
Drytimes were also measured at a low bake temperature of 120°F (49°C).

Note: Do not exceed 120°F as you may experience coating defects.
Do not bake an accelerated system.

	Slow	Slow / Fast (75% / 25%)	Slow / Fast (50% / 50%)	Slow / Fast (25% / 75%)	Fast
Standard Mix Dry to Handle	30 minutes	30 minutes	25 minutes	20 minutes	20 minutes

	Drying / Curing with short wave light IR equipment is not recommended.
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Recoating


	ProAir Clear 2 Pack Fast or Slow Clearcoat can be re-coated with itself at any stage. Sanding will become necessary after 24 hours.
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Polishing, Decals and Lettering

	<p>Polishing Dust and minor damage can be polished out after the stated air-dry times have been reached. Carefully sand out dust particles with #10 micron (#1500) grit paper wet, and then polish the area mechanically.</p> <p>Note: When heavy color sanding and polishing are required, it may be necessary to apply one extra coat of Pro Air Clear 2 Pack Fast or Slow Clear. When completed, a minimum of 2.4 mils of clearcoat is required for adequate durability.</p> <p>Decals Decals can be applied after 48 hours at 70°F (21°C)</p> <p>Lettering Painted striping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a gray scuffing pad.</p>
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Cleaning of Equipment

	Clean equipment following local and federal regulations. In compliant localities, use Sikkens LV Cleaning Solvent or high quality solvent borne gun cleaner. For national rule regions, use Sikkens Cleaning Solvent or high quality lacquer thinner.
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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. Coverage is given at 1 mil of applied ready to spray paint with 100% transfer efficiency.</p> <ul style="list-style-type: none"> • 586 Sq ft / gallon • 14.5 m² / liter
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VOC / Regulatory Information

	<p>Ready to Spray VOC at 2:1 mixture Pro Air Clear 2 Pack Fast or Slow yields a VOC content of: 3.66 lb/gal 440 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 Material 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

	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).	
	ProAir Clear 2 Pack Fast	2 years
	ProAir Clear 2 Pack Slow	2 years
	ProAir Clear Hardener	6 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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