

FOR PROFESSIONAL USE ONLY

Description

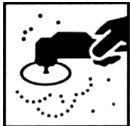
Primer Pro is a high solids urethane surfacer and sealer. Depending on the mixing ratio utilized, Primer Pro can be either used as a high build surfacer or wet-on-wet primer sealer. Primer Pro is available in white, gray and black for optimal coverage and versatility.

As A Primer Surfacers



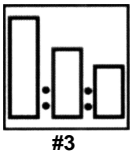
Safety Considerations

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.



Preparation for Primer Surfacers

- Polyester bodyfiller final sanded with #P180 to #P220 grit sand paper dry.
- Existing OEM finishes final sanded with #P220 to #P360 grit sand paper dry.



Mixing	Surfacers
4	Primer Pro
1	Primer Pro Hardener
1	Primer Pro Activator Fast or Medium



HVLP or Compliant Spray-Gun Set-Up:

1.7 – 2.0 mm

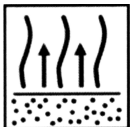
Application Air Pressure:

Consult spray gun manufacturers' specifications.
 HVLP maximum 10 psi at the air cap.



Application

2 – 3 x 1 Coats



Flash Between Coats at 70°F (21°C)

5-10 Minutes between coats.

Flash Before Force Drying at 70°F (21°C)

5-10 Minutes before curing.

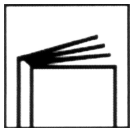


Dry to Sand – 3 Coats

- 3 Hours at 70°F (21°C)
- 30 Minutes at 140°F (60°C)

Dry to Sand – Infra-Red

- Low Power 5 Minutes
- Full Power 5 Minutes



As a Sanded Primer Surfacers Re-Coatable with:

- All Lesonal primer sealers
- All Lesonal topcoats

Read complete TDS for detailed product information.

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Description

Primer Pro is a high solids urethane surfacer and sealer. Depending on the mixing ratio utilized, Primer Pro can be either used as a high build surfacer or wet-on-wet primer sealer. Primer Pro is available in white, gray and black for optimal coverage and versatility.

As A Primer Sealer



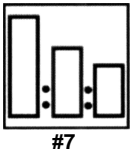
Safety Considerations

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.

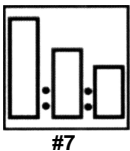


Preparation for Primer Sealer

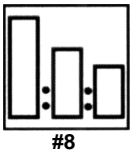
- OEM factory E-Coat thoroughly cleaned requires no sanding except for defects.
- Aftermarket primed bumpers should be carefully prepped by slightly scuffing with 1000 grit paper
- Existing finishes final sanded with #P320 to #P400 dry or #P500 to #P600 wet sand paper.



- | | |
|----------------------------------|---|
| 3
1
1 | Standard Sealer Mixture (Temperature range 70F-85F)
Primer Pro
Primer Pro Hardener
Primer Pro Sealer Reducer |
|----------------------------------|---|



- | | |
|----------------------------------|--|
| 3
1
1 | Sealer Mixture in Cold Temperatures (Temperature range 60F-75F)
Primer Pro
Primer Pro Hardener
Primer Pro Sealer Fast Activator |
|----------------------------------|--|



- | | |
|--------------------------------------|---|
| 100
25
35 | Sealer Mixture in High Temperature (Temperature range 85F-110F)
Primer Pro
Primer Pro Sealer Hardener Slow
Primer Pro Sealer Reducer |
|--------------------------------------|---|



HVLP or Compliant Spray-Gun Set-Up:

1.4 – 1.5 mm

Application Air Pressure:

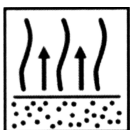
Consult spray gun manufacturers' specifications.
 HVLP maximum 10 psi at the air cap.



Application

1 x 1 Coats

On areas that have been sanded through, apply one thin coat and allow 5-10 minutes at 70°F (21°C) followed by a wet coat of sealer.

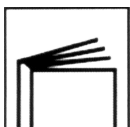


Flash before Top-Coat at 70°F (21°C)

15 Minutes minimum

Maximum Re-Coat Window at 70°F (21°C)

4 Hours maximum



As a Wet-On-Wet Primer Sealer Re-Coatable with:

- All Lesonal topcoats



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Suitable Substrates

- Existing finishes
- Steel
- Aluminum
- Galvanized steel
- OEM E-Coat (electro-coat)
- AutoPrep Wipes or AutoPrep Pen
- Glass reinforced laminates (GRP) with intact and un-broken surface
- Polyester body filler
- Polysurfacer
- Properly prepared plastic parts

- 1) For many applications, Primer Pro can be used as a direct-to-metal primer.
- 2) Although Primer Pro provides adequate adhesion to bare metal, repairs which require extensive metal priming such as whole panels or panels that have had the existing paint system completely removed should be pre-treated with AutoPrep Pre-Treatment Wipes.
- 3) Before painting plastic refer to the All Plastic Primer Technical Data Sheet for specific information about painting plastics.
- 4) Primer Pro may be used on rigid OEM e-coat parts. For edging of OEM e-coated parts, including exterior surfaces, utilize the sealer ratio.

Products and Additives

Product	Lesonal Primer Pro (White)	Item# 527657
	Lesonal Primer Pro (Black)	Item# 527658
	Lesonal Primer Pro (Gray)	Item# 527659
Hardeners	Lesonal Primer Pro Hardener	Item# 527660
	Lesonal Primer Pro Sealer Hardener Slow	Item #544595
Activators / Reducers	Lesonal Primer Pro Activator	Item# 527661
	Lesonal Primer Pro Fast Activator	Item# 527662
	Lesonal Primer Pro Sealer Reducer	Item# 527663
Additives	Lesonal Accelerator	Item#397672
	LV250 Accelerator	Item #389353
	Lesonal Flex Additive	Item#396027

Basic Raw Materials

- Primer Pro Primer - Acrylic resins
- Primer Pro Hardeners - Polyisocyanate resins
- Primer Pro Activators - Activated solvents

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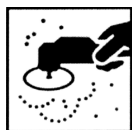
Substrate Preparation



Pre-Cleaning

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with Lesonal Surface Cleaner, AutoPrep Ultra Prep or Anti-Static surface cleaners.
- Avoid saturating body filler with water or cleaners while washing the repair.

Sanding Preparation



	Primer Pro Surfer		Primer Pro Sealer	
	Dry Sanding	Dry Sanding	Wet Sanding	
Existing Finishes	#P220 to #P360	#P320 – #P400	#P500 – #P600	
OEM E-Coat	Not Required	Not Required	Not Required	
Aftermarket Primed Bumpers	N / A	Carefully sand with #P1000	N / A	
Polyester Bodyfiller	#P180 to #P220	N / A	N / A	
Steel	#P80 then #P120	#P80 then #P120	N / A	
Galvanized Steel	#P120 to #P180	#P120 – #P180	N / A	
Aluminum	#P180 or Red Scuff Pad	#P180 – Red Pad	N / A	
Gel-Coat	#P220 to #P360	#P320 – #P400	#P500 – #P600	
Polyolefin Plastic	#P320 to #P400	#P400	#P500 – #P600	
Non-Polyolefin Plastic	##P320 to #P400	#P320 – #P400	#P500 – #P600	



Surface Cleaning

- Clean with Surface Cleaner, AutoPrep Ultra Prep or Anti-Static surface cleaners prior to priming.

Pre-Treatment of Bare Substrates

Pre-Treatment

- Primer Pro provides adequate adhesion to small bare metal areas. For larger areas or for improved corrosion protection Primer Pro should be applied over a metal pre-treatment such as the AutoPrep Pre-Treatment Wipes or AutoPrep pen materials.
- Polyolefin plastics require a pre-treatment adhesion promoter. Prime polyolefin plastics with All Plastic Primer prior to the application of flexed Primer Pro. For more information about painting plastic refer to the All Plastic Primer Technical Data Sheet.

Product Agitation



Stirring

- Because Primer Pro is a high solids product it needs to be thoroughly agitated before use.
- Stir the product several times per day.
- Stir after primer formula is completed, after the addition of hardener and again after adding activator or reducer for the most complete mixing.

Mixing Primer Pro Colors

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Formulas

- A wide range of Primer Pro formulas are available to match the most popular OEM primer colors. These are available on formula swatches or in MixitPro.

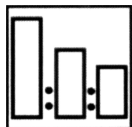
Hand Mixing Colors

- Colors can be custom mixed. However it is important to include Primer Pro White and/or Black to all colors. This includes adding a small amount of black to 100% white for increased hiding.

Please use the Lesonal Gray Shaded Primer System wall chart to decide which primer shade should be used, or use the recommendation in MIXIT Pro.

Code	Gray shade	Ratio	Gray shade
W	White	White (100%)	
W/G	Light Gray	White 50 / Gray 50	
G	Gray	Gray (100%)	
G/B	Dark Grey	Gray 50 / Black 50	
B	Black	Black (100%)	

Mixing – Primer Surfacer

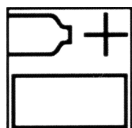


#3 Stick

- Surfacer**
- 4 Parts by volume Primer Pro
 - 1 Parts by volume Primer Pro Hardener
 - 1 Parts by volume Primer Pro Activator Fast

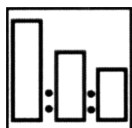
Mixing – Primer Surfacer with Accelerator

Only use accelerator in Primer Pro Surfacer. Do not add more than stated amount to maintain product quality.



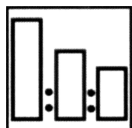
- Accelerated Surfacer**
- 1 quart Primer Pro Surfacer – Mixed ready to spray with hardener and activator.
 - + ½ ounce Lesonal Accelerator and stir thoroughly.
 - OR 1/8 – ¼ oz LV250 Accelerator and stir thoroughly.
 - (5-7 mL)

Mixing – Primer Sealer



#7

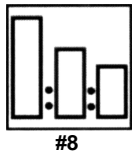
- 3 Standard Sealer Mixture (Temperature range 70F-85F)
- 1 Primer Pro
- 1 Primer Pro Hardener
- 1 Primer Pro Sealer Reducer



#7

- 3 Sealer Mixture in Cold Temperatures (Temperature range 60-75F)
- 1 Primer Pro
- 1 Primer Pro Hardener
- 1 Primer Pro Sealer Fast Activator

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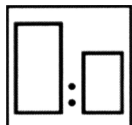


100
25
35

Sealer Mixture in High Temperatures (Temperature range 85F-110F)
 Primer Pro
 Primer Pro Sealer Hardener Slow
 Primer Pro Sealer Reducer

Mixing – Flexible Parts

If the part to be can be deformed by hand, increase the flexibility of Primer Pro as follows.

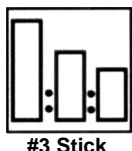


4
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Make a Mixture of
 Parts by volume Primer Pro
 Parts by volume Flex Additive

A mixture of 3:1 should be used for soft parts.

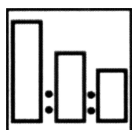
Stir the paint and Flex Additive mixture together then step #2 mix surfacer or sealer –



#3 Stick

4
1
1

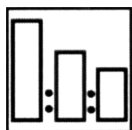
Surfacer
 Parts by volume Primer Pro / Flex Additive (Previous step)
 Parts by volume Primer Pro Hardener
 Parts by volume Primer Pro Activator



#7 Stick

3
1
1

Sealer Standard Mix (70F-85F)
 Parts by volume Primer Pro / Flex Additive mixture (Previous step)
 Parts by volume Primer Pro Hardener
 Parts by volume Primer Pro Sealer Reducer
 *Recommended mixture when painting aftermarket plastic bumpers

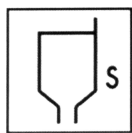


#8

100
25
35

Sealer High Temperature (85F-110F)
 Parts by volume Primer Pro / Flex Additive mixture (Previous step)
 Parts by volume Primer Pro Sealer Hardener Slow
 Parts by volume Primer Pro Sealer Reducer
 *Recommended mixture when painting aftermarket plastic bumpers

Viscosity When Mixed



DIN #4

Seconds
 18 – 22
 13 – 16

Measured with a DIN #4 viscosity cup at 70°F (21°C).
 Primer Pro Surfacer – Sanding
 Primer Pro Sealer – Non-Sanding

Pot-Life When Mixed

Product Mix	70°F (21°C)	85F (35C)
Primer Pro Primer Surfacer	50 – 60 Minutes	25-35 minutes
Primer Pro Primer Surfacer – With LV 250 Accelerator	25 - 30 Minutes	15 minutes
Primer Pro Sealer 3:1:1 using Fast Activator	50-60 Minutes	25-30 minutes
Primer Pro Sealer 3:1:1 using Primer Pro Reducer	60-90 minutes	50-60 minutes
Primer Pro Sealer 100:25:35 using Sealer Hardener Slow and Primer Pro Reducer	120-180 minutes	50-70 minutes

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Spray Gun Set-Up

Consult spray gun manufactures instructions for specific spray gun pressure specifications.



Surfacer Spray Guns	Fluid Tip	Application Pressure
HVLP Gravity Fed	1.7 – 2.0mm	29 psi at the spray gun inlet (Maxium10 psi at cap).
Compliant Gravity Fed	1.7 – 2.0mm	29 to 35 psi at the spray gun inlet.



Sealer Spray Guns	Fluid Tip	Application Pressure
HVLP Gravity Fed	1.4 – 1.5mm	29 psi at the spray gun inlet (Maxium10 psi at cap).
Compliant Gravity Fed	1.4 – 1.5mm	29 to 35 psi at the spray gun inlet.

Application

Primer Surfacer



- Apply 2-3 single wet coats. For use on repair (polyester bodyfiller) or sanded areas apply one coat over the repair, and then after a flash dry apply the second and third coats.
- Flash off between the coats until the surface becomes totally matt, this will depend on ambient temperature, applied thickness/wetness and airflow.
- Alternate application; Primer Pro mixed as a surfacer (3:1:1) may be used wet-on-wet when edging in parts. For this, apply one coat of Primer Pro. Apply topcoat after 15 minutes to a maximum of 45 minutes at 70°F (21°C).

Primer Sealer

- Apply 1 thin but flowing coat over the desired area.
 - Over any sand through areas, first apply a thin coat to make all the substrate layers uniform before continuing with a normal coat.

Film Thickness – Using Suitable Application

Primer Surfacer

- 1 Coat will achieve a thickness of 1.5 – 2.0 mils (37 - 50µm).

Primer Sealer

- 1 Coat will achieve a thickness of 0.8 – 1.2 mils (20 – 30µm).

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Drying / Curing Time – Primer Surfacer

Times are stated following recommended application method, film thickness and object temperature.

Primer Surfacer Air Dry



- 3 hours at 70°F (21°C)
- 120 Minutes 70°F (21°C) when mixed with LV250 Accelerator.

Primer Surfacer Force Dry Bake

- 30 Minutes at 140°F (60°C)
- 20 Minutes at 140°F (60°C) when mixed with LV250 Accelerator.

Primer Surfacer Infra-Red Short Wave Curing



Drying / Curing with short wave light IR equipment and a surface distance of 20 – 27 inches (50 – 70cm). The object temperature must not reach a temperature above 212°F (100°C).

- Allow 3 to 5 minute flash off before infra-red curing.
- Cure 5 minutes on low power followed directly by a 5 minute full power cure.

Drying Flash Time – Primer Sealer

Primer Sealer Flash Time



- Prior to top-coating primer sealer, allow a minimum flash off time of 15 minutes at 70°F (21°C).
- Maximum re-coat time is 4 hours 70°F (21°C).
- If the maximum flash time be exceeded, Primer Pro sealer must be sanded prior to topcoat application, with #P500 to #P600 dry or #P800 wet sand paper.

Final Preparation – For Top Coat Application

Dry Sanding – Machine



- When dry sanding, respect a maximum 200 sanding grit step or less throughout sanding.
- Initial sanding may be done with #P320 to P400.
- Final sanding should be done using #P500 to #P600 before application of Lesonal top-coats.

Wet Sanding – By Hand



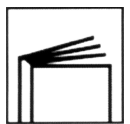
- When wet sanding, respect a maximum 200 sanding grit step or less throughout sanding.
- Initial sanding may be done with grits courser than #P600.
- Final sanding should be completed using #P800 before application of Lesonal top-coats.

Surface Cleaning



- Clean with Surface Cleaner, AutoPrep Ultra Prep or Anti-Static surface cleaners prior to top-coating.

Re-Coating



- Lesonal Primer Pro can be re-coated with all Lesonal sealers and topcoats.

Cleaning of Equipment



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Clean equipment following local and federal regulations. For national rule regions, use Lesonal Cleaning Solvent or high quality lacquer thinner.

Theoretical Coverage

Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness and application technique variables among others.

Primer Pro Primer Surfacer	- Per coat of ready to spray paint 600-630 ft ² / liter
Primer Pro Primer Sealer	- Per coat of ready to spray paint 580-610 ft ² / liter
Primer Pro Sealer with Slow Hardener	-Per coat of ready to spray paint 730-738 ft ² / liter

VOC / Regulatory Information

System	Mix Ratio	VOC
Primer Surfacer	4:1:1	<4.8 lbs/gal (575 g/L)
Primer Sealer	3:1:1	4.6 lbs/gal (550 g/L)
Primer Sealer with Slow Hardener	100:25:35	4.51 lbs/gal (540 g/L)

Product Storage

Primer Pro	2 Year
Primer Pro Hardener	6 Months
Primer Pro Activator	12 Months

AkzoNobel Address: 1845 Maxwell Street Troy Michigan 48084

Telephone: 800-618-1010

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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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