Gray Urethane Surfacer

FOR PROFESSIONAL USE ONLY

Description

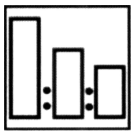
Lesonal Gray Urethane Surfacer is intended for use as a high build surfacer that offers excellent filling, easy sanding, and fast dry times. Depending upon the mixing ratio used, Lesonal Gray Urethane Surfacer can also be used as a wet-on-wet primer sealer.

As A Primer Surfacer

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 Surfacer

- 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.



#9

Mixing

3	Parts by volume Gray Urethane Surfacer
1	Parts by volume Urethane Surfacer Hardener
1	Parts by volume Lesonal Reducers
	For high build applications, reducer is optional.

Accelerated mixing – add up to 2 capfuls or ½ ounce of Lesonal Accelerator per mixed ½ quart of paint.

HVLP or Compliant Spray-Gun Set-Up:

1.8 – 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)

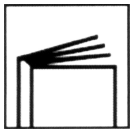
5-10 Minutes between coats.

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

5-10 Minutes before curing.

Dry to Sand – 3 Coats

- 3-4 Hours at 70°F (21°C)
- 40 Minutes at 140°F (60°C)



As a Sanded Primer Surfacer Re-Coatable with:

- All Lesonal primer sealers
- All Lesonal topcoats

Read complete TDS for detailed product information.

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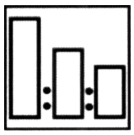
As A Primer Sealer

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.



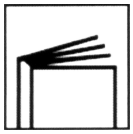
#4

2	Parts by volume Gray Urethane Surfacer
1	Parts by volume Urethane Surfacer Hardener
20%	Parts by volume Lesonal Reducer

HVLP or Compliant Spray-Gun Set-Up:	**Application Air Pressure:**
1.3 – 1.5 mm	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)	**Maximum Re-Coat Window at 70°F (21°C)**
15 Minutes minimum	4 Hours maximum



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

- All Lesonal topcoats

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Gray Urethane Surfacer

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Suitable Substrates

- Existing finishes, cleaned and sanded with #P240 to #P320 grit paper dry or #P500 to #P600 grit wet.
- Steel, cleaned and sanded with #P80 then #P180 grit dry.
- Lesonal Epoxy Sealers and Self-Etching Primer.
- Fiberglass gelcoat cleaned and sanded with #P180 grit dry
- AutoPrep Self Etching Pen
- AutoPrep Pretreatment Wipes
- Polyester bodyfiller

Note: For large areas of bare metal, one coat of Lesonal Gray Self-Etching Primer or Lesonal Epoxy Primer Sealer is recommended for maximum corrosion resistance.

Products and Additives

Product	Lesonal Gray Urethane Surfacer	Item# 392616
Hardeners	Lesonal Urethane Surfacer Hardener	Item# 395357
Activators / Reducers	Lesonal Reducer Extra Slow Lesonal Reducer Slow Lesonal Reducer Medium Lesonal Reducer Fast Lesonal Reducer Extra Fast	Item #394938 Item #394695 Item #394295 Item #394893 Item #394318
Additives	Lesonal Accelerator Lesonal Flex Additive	Item#397672 Item#396027

Basic Raw Materials

- Gray Urethane Surfacer Primer - Acrylic/polyester resins
- Lesonal Urethane Surfacer Hardeners - Polyisocyanate resins
- Lesonal Reducers - Solvent blend

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

	Gray Urethane Surfacer Surfacer	Gray Urethane Surfacer 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

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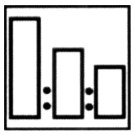
	Steel	#P80 then #P120	#P80 then #P120	N / A
	Gel-Coat	#P220 to #P360	#P320 – #P400	#P500 – #P600
	Polyolefin Plastic	#P320 to #P400	#P400	#P500 – #P600
	Non-Polyolefin Plastic	##P320 to #P400	#P320 – #P400	#P500 – #P600
	**Surface Cleaning** · Clean with Surface Cleaner, AutoPrep Ultra Prep or Anti-Static surface cleaners prior to priming.			

Pre-Treatment of Bare Substrates

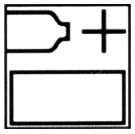
	Pre-Treatment · Gray Urethane Surfacer provides adequate adhesion to small bare metal areas. For larger areas or for improved corrosion protection Gray Urethane Surfacer should be applied over a metal pre-treatment such as the AutoPrep Pre-Treatment Wipes or AutoPrep pen materials. · Polyolefin plastics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

Mixing – Primer Surfacer

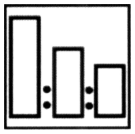
 **#9**	**Mixing** **3** **1** **1**	Surfacer Parts by volume Gray Urethane Surfacer Parts by volume Urethane Surfacer Hardener Parts by volume Lesonal Reducers For high build applications, reducer is optional. Accelerated mixing – add up to 2 capfuls or ½ ounce of Lesonal Accelerator per mixed ½ quart of paint.

Mixing – Primer Surfacer with Accelerator

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

	**1/2 quart** **+** **½ ounce** **OR** **(5 mL)**	**Accelerated Surfacer** Gray Urethane Surfacer Surfacer – Mixed ready to spray with hardener and activator. Lesonal Accelerator and stir thoroughly.

Mixing – Primer Sealer

 **#4**	**2** **1** **20%**	Parts by volume Gray Urethane Surfacer Parts by volume Urethane Surfacer Hardener Parts by volume Lesonal Reducer

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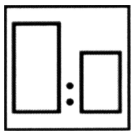
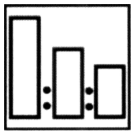
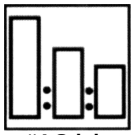
Mixing – Flexible Parts

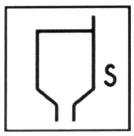
If the part to be can be deformed by hand, increase the flexibility of Gray Urethane Surfacer as follows.

	**5** **1**	**Make a Mixture of** Parts by volume Gray Urethane Surfacer 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 –

 **#9 Stick**	**3** **1** **1**	**Surfacer** Parts by volume Gray Urethane Surfacer / Flex Additive (Previous step) Parts by volume Urethane Surfacer Hardener Parts by volume Lesonal Reducers
 **#4 Stick**	**2** **1** **20%**	**Sealer** Parts by volume Gray Urethane Surfacer / Flex Additive mixture (Previous step) Parts by volume Urethane Surfacer Hardener Parts by volume Lesonal Reducers

Viscosity When Mixed

 **DIN #4**	Seconds 23-30 16-17	Measured with a DIN #4 viscosity cup at 70°F (21°C). Gray Urethane Surfacer Surfacer – Sanding Gray Urethane Surfacer Sealer – Non-Sanding

Pot-Life When Mixed

Product Mix	**70°F (21°C)**
Gray Urethane Surfacer Primer Surfacer	1 hour
Gray Urethane Surfacer Primer Surfacer – With Lesonal Accelerator	30 Minutes
Gray Urethane Surfacer Sealer	60 Minutes

Spray Gun Set-Up

	Consult spray gun manufactures instructions for specific spray gun pressure specifications.		
SURFACER 	**Surfacer Spray Guns**	**Fluid Tip**	**Application Pressure**
	HVLP Gravity Fed	1,8 – 2.0mm	29 psi at the spray gun inlet (Maxium10 psi at cap).
	Compliant Gravity Fed	1.7 –2.2mm	29 to 35 psi at the spray gun inlet.
SEALER 	**Sealer Spray Guns**	**Fluid Tip**	**Application Pressure**
	HVLP Gravity Fed	1.3 – 1.5mm	29 psi at the spray gun inlet (Maxium10 psi at cap).
	Compliant Gravity Fed	1.3 – 1.5mm	29 to 35 psi at the spray gun inlet.

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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.

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 2.0-2.5 mils (50-75µm).

Primer Sealer

- 1 Coat will achieve a thickness of 1.2-1.5 mils (30-37.5µm).

Drying / Curing Time – Primer Surfacer

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

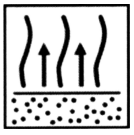
Primer Surfacer Air Dry

- 3-4 hours at 70°F (21°C)
- 2-3 Minutes 70°F (21°C) when mixed with Lesonal Accelerator.

Primer Surfacer Force Dry Bake

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

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, Gray Urethane Surfacer 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.

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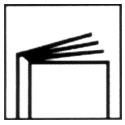
Wet Sanding – By Hand

- 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 Gray Urethane Surfacer can be re-coated with all Lesonal sealers and topcoats.

Cleaning of Equipment

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

Theoretical Coverage

By using the recommended application, the theoretical material usage for 1 mils RTS		sq.ft./liter	m²/liter
Sanding (mixture A)	RTS @ 3:1:1	659+/-5	16.2+/-2

The practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances.

VOC / Regulatory Information

System	Mix Ratio	VOC
Primer Surfacer	3:1:1	3.85 lbs/gal (462 g/L)
Primer Sealer	2:1:20%	3.93 lbs/gal (471 g/L)

Product Storage

Gray Urethane Surfacer	2 Year
Gray Urethane Surfacer Hardener	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 Safety 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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