

# 2K Filler 540

# LESONAL

Technical Data Sheet

July 2017

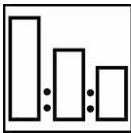



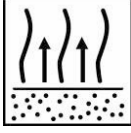




L2.02.04 UK & Ireland

Primers/Surfacers

## Description

Two component, VOC compliant dual purpose filler, for general use in refinishing cars, and light commercial vehicles. By using a different mixing ratio Lesonal 2K Filler 540 can be used as medium build sanding primer, or as lower build non-sand filler. Available in a white, grey and black version, for optimal coverage.

## Sanding version

<b>Mixing ratio</b>		5 Lesonal 2K Filler 540 1 Lesonal Universal Hardener 1 Lesonal Multi Thinners
<b>Mixing stick</b>		<b>G</b>
<b>Equipment</b>		Spray gun set-up: 1.6 - 1.8 mm Application pressure: 2.0 – 2.2 bar at air inlet* <small>*refer to user manual spraygun</small>
<b>Application</b>		2 - 3 x 1 coat
<b>Flash-off</b>		Between coats 5 - 10 minutes at 20°C Before curing 5 - 10 minutes at 20°C
<b>Drying</b>		20°C 3 hours 60°C 25-30 minutes
<b>Sanding</b>		Final sanding step:P400-P500
<b>Recoatibility</b>		Topcoat HS 420 Basecoat WB
<b>Protection</b>		

# 2K Filler 540

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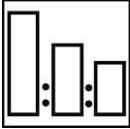



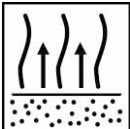


L2.02.04 UK & Ireland

Primers/Surfacers

## Description

Two component, VOC compliant dual purpose filler, for general use in refinishing cars, and light commercial vehicles. By using a different mixing ratio Lesonal 2K Filler 540 can be used as medium build sanding primer, or as lower build non-sand filler. Available in a white, grey and black version, for optimal coverage.

## VOC Compliant Non Sanding version

<b>Mixing ratio</b>		6 1 3	Lesonal 2K Filler 540 Lesonal HS Hardener 420 Lesonal Thinner 540 Non Sanding
<b>Mixing stick</b>		<b>R</b>	
<b>Equipment</b>		Spray gun set-up: 1.2-1.5 mm	Application pressure: 2 – 4 bar at air inlet* <small>*refer to user manual spraygun</small>
<b>Application</b>		1 x 1 coat	
<b>Flash-off</b>		Flash off time before topcoat 15 - 20 minutes at 20°C	Recoat within: 6 hours at 20°C
<b>Recoatability</b>		Topcoat HS 420	Basecoat WB
<b>Protection</b>			

Read complete technical data sheet for detailed product information

## Description

VOC compliant two component, dual purpose filler, for general use in refinishing cars, and also light commercial vehicles. By using a different mixing ratio Lesonal 2K Filler 540 can be used as medium build sanding primer, or as lower build non-sand filler. Available in a white, grey and black version, for optimal coverage.

## Product and additives

Lesonal 2K Filler 540

Lesonal Universal Hardeners  
Lesonal HS Hardener 420


Lesonal Thinner 540 Non Sanding

## Chemical Basis

Lesonal 2K Filler 540	– Acrylic resins
Lesonal Universal Hardener	– Polyisocyanate resins
Lesonal HS Hardener 420	– Polyisocyanate resins
Lesonal Multi Thinners / Thinner 540 NS	– A blend of organic solvents

## Method of use

**GreyShades** Please use the Lesonal Grey Shad Primer System wall chart to decide which primer shade should be used, or use the recommendation in Mixit:

Code	GreyShade	Ratio	GreyShade
W	White	White 100	
W/G	Light Grey	White 50 / Grey 50	
G	Grey	Grey 100	
G/B	Dark Grey	Grey 50 / Black 50	
B	Black	Black 100	

If the code is followed by "ADV" the use of the Grey Shade is strongly recommended

## Substrates

Sound original finishes, including thermoplastic acrylics  
OEM Electrocoat - Sanded  
Bare steel  
Aluminum, galvanized steel (first apply 1K Etch Primer)  
Lesonal 1K Etch Primer  
Lesonal Polyester Body Fillers  
Lesonal Polyester Spraying Filler  
Lesonal 1K Multi Plastic Primer  
Lesonal 2K Epoxy Primer

## Substrate preparation

Prior to commencing any sanding work, thoroughly cleanse the surface with Lesonal Degreaser.

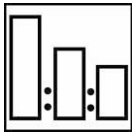
Original finishes and polyester laminates - Sand with P180 - P280 grit dry, or P280 - P400 wet.

Steel - Remove all traces of rust and abrade thoroughly until a clean surface is achieved (see Helpful tips below). Any mill scale should be removed by shot blasting.

Lesonal Polyester Body Filler - Finish sand with P180 / P280 grit dry.

After sanding work is completed, again degrease thoroughly with Lesonal Degreasers.

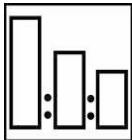
## Mixing Ratio



### Sanding

5 volumes - Lesonal 2K Filler 540  
1 volume - Lesonal Universal Hardener  
1 volume - Lesonal Multi Thinner

Mixing stick G

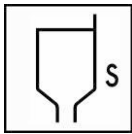


### Non sanding VOC Compliant

6 volumes - Lesonal 2K Filler 540  
1 volume - Lesonal HS Hardener 420  
3 volume - Lesonal Thinner 540

Mixing stick R

## Spraying Viscosity



Sanding: 23 - 25 sec. DIN Cup 4 at 20°C.

Non sanding: 15 - 17 sec. DIN Cup 4 at 20°C.

## Spraying pressure



### Sanding

#### Spraygun

HVLP Gravity

LVL/HR Gravity

#### Fluid opening

1.6 - 1.8 mm

1.6 - 1.8 mm

#### Spraying pressure

0.7 bar (at air cap)\*

2 - 2.2 bar (at air inlet)\*

### Non sanding

#### Spraygun

HVLP Gravity

LVL/HR Gravity

#### Fluid opening

1.2 - 1.4 mm

1.2 - 1.4 mm

#### Spraying pressure

0.7 bar (at air cap)\*

2 - 2.2 bar (at air inlet)\*

\*Please refer to user manual spraygun used

## Application



### Sanding

Apply two or three single coats, allow to dry until mat after each coat (5 - 10 minutes)

### Non Sanding

Apply one to two single coats, allow to dry until mat after each coat (5 - 10 minutes)

(Drying times will be very much influenced by factors such as temperature and air movement at the time of application).

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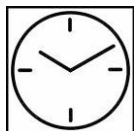
L2.02.04 UK &amp; Ireland

Primers/Surfacers

## Pot life

1 hour at 20°C

## Drying Times



<i>Sanding</i>	<b>at 20° C</b>	<b>at 60° C</b>
Dry to sand	3 hrs	25 min.
<i>Non Sanding</i>		
Dry to recoat with topcoat	15-20 min.	N/A
Must be recoated within	6 hrs	N/A
Dry to sand	6 hrs	1 hour

<b>Infra red short wave equipment</b>	<b>Half power</b>	<b>Full power</b>
	4 min.	8 min.

## Layer Thickness

Sanding: 50 - 60 microns

Non sanding: 15 - 20 microns

## Theoretical coverage

**Recoatability** Lesonal Topcoat HS 420  
Lesonal Basecoat WB

<b>Recommended sandpaper grades</b>	<b>Method</b>	<b>Initial sanding</b>	<b>Final sanding</b>
	Wet sanding	P600	P800-P1000
	Dry sanding	P320	P400-P500

Ready for use mixture at 1 micron layer thickness with ready for use mix:

Sanding: 400 m<sup>2</sup>/lNon sanding: 366 m<sup>2</sup>/l

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

## Cleaning Equipment

Lesonal Multi Thinners or nitro cellulose thinner.

## Helpful Tips

To ensure maximum adhesion and corrosion resistance on steel Lesonal 1K Etch Primer should be applied first. If the non sanding version is allowed to dry for longer than 6 hours, it should be thoroughly sanded before a topcoat is applied. As is usual when refinishing thermoplastic acrylic finishes, extra care should be taken and flash-off times should be extended.

Please use the Lesonal Grey Shaded Primer System wall chart to decide which primer shade should be used.

# 2K Filler 540

**LESONAL**

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**Colour**White, Grey, Black**Shelflife**2 years**VOC**

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/litre VOC. The VOC content of this product in ready to use form is max. 540 g/litre. (Sanding version and VOC Non sanding version with HS 420 hardener, using the mixing ratio 5:1:2 with the Lesonal Universal hardener the VOC content is 576 g/litre)

**Ancillaries**

Texture Additive, TDS L1.08.03  
Flexible Additive, TDS L1.08.02

**Akzo Nobel Coatings LTD**

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