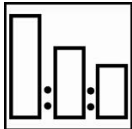


Lesonal ProAir Clear LV

FOR PROFESSIONAL USE
ONLY

Description

The **Lesonal™** ProAir Clear LV is an acrylic urethane clearcoat for use over **Lesonal™** Basecoat WB or Lesonal Basecoat SB and intended for ambient cure conditions. This Clear offers excellent resistance to surface contamination with excellent gloss, making it an ideal choice for air dry environments. It also meets the regulation requirements offered at 2.1 lb/gal VOC.



- 3 Lesonal ProAir Clear LV
- 1 Lesonal ProAir Clear LV Hardener
- 1 Lesonal ProAir Clear LV Activator Spot and Panel, Medium or Slow



Use Lesonal measuring stick

7 (purple)



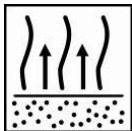
Gravity spray gun set-up:
1.3 -1.5 mm

Application pressure:
HVLP Max 10 psi at air cap

➤ Check gun manufacturer specification



2 x 1 coat



Between coats:
5 – 10 minutes at 70° F (20° C)

Before curing (forced drying):
5 – 10 minutes at 70° F (20° C)

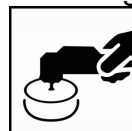


Air Drying:
Dust free;
15-20 minutes at 70°F
(20°C)

Dry to handle;
1 to 1½ hours at 70°F (20°C)
Dependant on film build



Force drying:
Dry to handle;
30 minutes at 120° F (49° C)



Polishing: (Color-sand and compound);
2 to 4 hours at 70° F (20° C)
30 minutes at 120° F (49° C)



Use suitable respiratory protection
AkzoNobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

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Suitable substrates

- Lesonal Basecoat WB
 - Allow the base coat color a minimum flash off time of 15 minutes at 77°F (25°C)
- Existing finish that is thoroughly prepared, in the case of spot repairs and blending.

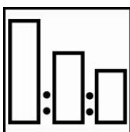
Product and additives

Products	Lesonal ProAir Clear LV.
Hardeners	Lesonal ProAir Clear LV Hardener.
Activator / Reducers	Lesonal ProAir Clear LV Spot and Panel Repair Activator. an activator to be used for application on small to medium repairs, temperatures of 65°F (18°C) to 85°F (29°C) Lesonal ProAir Clear LV Medium Activator. an activator for small to medium size repairs, temperatures of 75°F (24°C) to 90°F (32°C) Lesonal ProAir Clear LV Slow Activator.: an activator to be used for application on large repairs, temperatures of 85°F (29°C) and above
Additives	Flex Additive LV: an additive to increase the flexibility level of the clear system, for use on flexible parts.

Basic raw materials

Lesonal ProAir Clear LV:	Acrylic Polyol resins
Lesonal ProAir Clear LV Hardener:	Polyisocyanate resins
Lesonal ProAir Clear LV Activators:	Activated solvents

Mixing



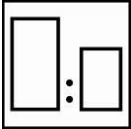
3	Parts by volume of Lesonal ProAir Clear LV.
1	Part by volume Lesonal ProAir Clear LV Hardener.
1	Part by volume Lesonal ProAir Clear LV Activator, Spot and Panel, Medium or Slow.

Use the Lesonal measuring stick #7 (purple)

Lesonal ProAir Clear LV

FOR PROFESSIONAL USE
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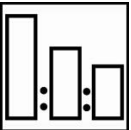
Flexible parts



To increase flexibility of Lesonal ProAir Clear LV for use on flexible parts.
Before adding Hardener and Activator, prepare the Lesonal ProAir Clear LV as follows:

- 5 Parts by volume of Lesonal ProAir Clear LV**
- 1 Part by volume of Flex Additive LV**

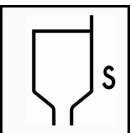
Use the Lesonal measuring stick



Further mixed as follows

- 3 Mixture of Lesonal ProAir Clear LV and Flex Additive LV**
- 1 Part by volume Lesonal ProAir Clear LV Hardener.**
- 1 Part by volume Lesonal ProAir Clear LV Activator, Spot and Panel, Medium or Slow.**

Viscosity



14 – 16 seconds DIN cup #4 at 70°F (20°C)

Spray gun set-up / application pressure



Spray gun:	Fluid tip-set-up:	Application pressure:
Siphon feed	1.3-1.6 mm	40 to 50 psi at the spray gun air inlet
HP Gravity	1.3-1.5 mm	40 to 50 psi at the spray gun air inlet
RP Gravity	1.3-1.5 mm	35 psi at the spray gun air inlet
HVLP Gravity	1.3-1.5 mm	29 psi at the spray gun air inlet
		➤ HVLP max 10 psi at the air cap.
		➤ Check gun manufacturer specification

Pot-life

With:	At 70°F (20°C)	At 95°F (35°C)
Lesonal ProAir Clear LV Spot and Panel Repair Activator	45 minutes	15 – 20 minutes
Lesonal ProAir Clear LV Medium Activator	1 hours	25 – 35 minutes
Lesonal ProAir Clear LV Slow Activator	2 hours	35 – 45 minutes

Lesonal ProAir Clear LV

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Application



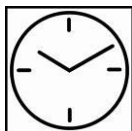
Apply 2 single flowing coats.

Allow a flash off time of 5 to 10 minutes between the coats, this will depend on ambient temperature, applied layer thickness and airflow.

Film thickness when using the recommended application

2 coats 2.4 -- 3.0 mils (60 - 75µm)

Drying time



at 70°F (20°C) At 120°F (49°C)

Dust free	15 minutes	5 minutes
Dry to handle	1 to 1½ hours	25 minutes
Dry to polish	2 to 3 hours	30 minutes

Drying times relate to recommended application (film thickness) and object temperature



Distance between short wave IR unit and object. 20- 27inches (50-70 cm)

Allow 3 to 5 minutes flash off before Infra red curing

Cure 5 minutes low power setting followed by 10 minutes high power setting.

> The panel must not reach a temperature above 100°C while curing.

Recoatable and blending

Recoatable with itself after full drying cycle. Sanding becomes necessary if there are defects or after 24 hours..

For blending (spot repairs and panel blends), Please see TDS Spot Repairs with Lesonal WB or Lesonal SB basecoat data sheet.

Theoretical coverage

per coat of unmixed paint; 743 sq.ft/liter (18.2 sq. m/liter)

> *The practical coverage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.*

Lesonal ProAir Clear LV

FOR PROFESSIONAL USE
ONLY**Polishability**

Dust and minor damage can be polished out after the stated air-dry times have been reached, or after a full bake at 120°F (49°C) object temperature, followed by approximately 1 hour cool down of the object to ambient temperature.

Carefully sand out dust particles and restore the surface according to the polishing recommendations. Sand out dust particles with #1500 then #2000 grit paper wet or finish with the 3M Perfect-It™ Paint Finishing System.

1. Trizact foam disc P3000 followed with Perfect-It™ Rubbing Compound (PN 06085/06086) using the Superbuff™ III Wool Pad (PN 05703).
2. Remove compounding swirls by using Perfect-It™ Machine Polish (PN 06064 / 06065) using Perfect-It™ Plus Foam Polish Pad (PN 05738).
Complete the system, if necessary with;
3. Perfect-It™ Ultrafine Machine Polish (PN 06068 / 06069) using the Ultrafine Foam Polishing Pad (PN 05733)

Cleaning of equipment

Cleaning Solvent or solvent borne gun cleaner

VOC

(3:1:1 Ratio; ready to spray) Lesonal ProAir Clear LV:	1.87 lb/gal (224 g/Liter)
5:1 Lesonal ProAir Clear LV: / Flex Additive LV; then 3:1:1 Ratio:	2.1 lb/gal (250 g/Liter)

Product storage

Store products unopened, and used products with closed lids preferably between 40°F-95°F (5°C-35°C) Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C) ;wa/

Lesonal ProAir Clear LV:	1 year	Lesonal ProAir Clear LV	1 year
Lesonal ProAir Clear LV	6 months	Activators:	
Hardener:			

AkzoNobel Car Refinishes Inc. North America
Address: 5555 Spalding Drive, Norcross. GA 30092 USA
Tel: 770-662-8464

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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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Head Office

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com www.lesonal.com