
HS SURFACER/SEALER

DESCRIPTION: The HS Surfacers/Sealer is a High Solids urethane surfacer/sealer. Depending on the mixing ratio utilized, HS Surfacers/Sealer can be used as either a high build primer surfacer or wet-on-wet primer sealer. Available in a white, gray and black version, for optimal coverage

PRODUCT & ADDITIVES:

PRODUCTS:

- HS Surfacers/Sealer (white)
- HS Surfacers/Sealer (gray)
- HS Surfacers/Sealer (black)

HARDENERS:

- HS Surfacers/Sealer Hardener
- HS Surfacers/Sealer Hardener Slow for application as a sealer on large areas (overall refinishing) at temperatures from 90°F (32°C) and above.
- HS Surfacers Activator

REDUCERS:

- Lesonal Reducer Medium: a medium temperature reducer for larger areas and overall refinishing. Temperature ranges from 70°–85°F (20°–30°C).
- Lesonal Reducer Slow: mainly used for overall refinishing. Temperatures of 80°F (27°C) and above.
- Lesonal Reducer Extra Slow: a very slow reducer for large areas and overall refinishing in very warm weather. Temperature of 90°F (32°C) and above.

ADDITIVES: For application over plastic parts that have been treated, the use of Lesonal Flex Additive in HS Surfacers/Sealer is recommended. See information in this TDS.

BASIC RAW MATERIALS:

- HS Surfacers/Sealer: acrylic resins
- HS Surfacers/Sealer Hardener: polyisocyanate resin
- HS Surfacers Activator: activated solvents

SUITABLE SURFACES

(MIXTURE A SURFACER):

HS Surfacers/Sealer can be applied over:

- Existing finishes, degreased and sanded with #P240 to #P320 grit paper dry.
- Any premium polyester bodyfiller sanded with #P180 to #P220 grit dry.
- Steel, degreased and sanded with #P80 then #P120 grit dry.
- Lesonal Epoxy Sealers and Gray Self-Etching Primer.
- Fiberglass gelcoat cleaned and sanded with #P180 grit dry.

UNSANDED OEM

E-COAT PANELS: Lesonal HS Surfacers/Sealer may be used on rigid OEM e-coats parts. For edging of OEM e-coated parts, including exterior surfaces, utilize the sealer ratio. For edging in parts you have the option to utilize the primer surfacer ratio. Do not use this non-sanding process on “after market” parts, flexible or soft plastic parts.

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.



HS SURFACER/SEALER

SUITABLE SURFACES (MIXTURE B WET-ON-WET):

HS Surfacers/Sealer:



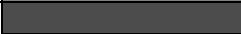
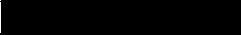

- Existing finishes, degreased and sanded with #P360 to #P400 grit paper dry or #P500 to #P600 grit wet.
- Steel, degreased and sanded with #P80 then #P120 grit dry.
- Fiberglass gelcoat, free of release coat, degreased and sanded with #P360 grit dry.
- Grey Urethane Surfacers sanded with #P320 to #P400 grit dry or #P500 to #P600 grit wet.
- Lesonal Epoxy Sealer and Gray Self-Etching Primer.

NOTE:

Although HS Surfacers/Sealer will provide adequate adhesion and protection when applied directly over bare metal, for large areas of bare metal, one coat of Lesonal Gray Self-Etching Primer is recommended for maximum corrosion resistance.

GRAY SHADES:

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

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%)	

- If the car color code is followed by "ADV" the use of the grey shade is strongly advised

APPLICATION:

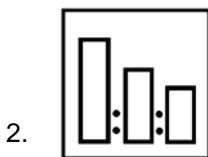
Mixture A: As a primer surfacer



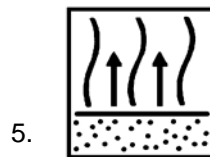
Contains acrylic resins and other ingredients. When mixed, also contains isocyanates.



1–3x1
HVLP Siphon 1.8–2.2 mm
HVLP Gravity 1.9–2.2 mm
Max 10 psi (at the air cap)



3:1:1
HS Surfacers/Sealer
HS Surfacers/Sealer
Hardener
HS Surfacers Activator



5–10 minutes at 70°F (20°C)



Use The Lesonal Measuring Stick #9 (3:1:1).



3 hours at 70°F (20°C)
30 minutes at 140°F (60°C)

- **Stir thoroughly**



HS SURFACER/SEALER

MIXING RATIO: **Mixture A: As a surfacer**
 3 parts by volume of HS Surfacers/Sealer
 1 part by volume of HS Surfacers/Sealer Hardener
 1 part by volume of HS Surfacers Activator

FLEXIBLE PARTS: As a primer surfacer for flexible parts, mix 4 parts of HS Surfacers/Sealer to 1 part of Flex Additive first, (3:1 for soft parts) then add the appropriate hardener and reducer at a 3:1:1 ratio.

NOTE: *Do not* use Lesonal Accelerator in HS Surfacers/Sealer.

SPRAYING VISCOSITY: Mixture A: 15–16 sec. DIN cup #4 at 70°F (20°C).

POT LIFE: Mixture A: When mixed, 1-1/2 hours at 70°F (20°C)
 1 hour at 80°F (27°C)

APPLICATION METHOD: Mixture A: Spray one, two or three single wet coats, allowing for a flash-off time of 5–10 minutes between coats (depending on temperature and film thickness applied).

DRYING TIME: Dry to Sand

	70°F (20°C)	140°F (60°C)
Three coats	3 hours	30 minutes

NOTE: When using short-wave infrared for drying, the best method is to allow 5 minutes flash after the last coat. Then apply the infrared, 5 minutes at half power and then 8 to 12 minutes at full power, depending on film thickness and lamp type.





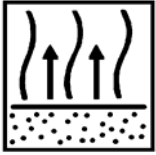

FILM THICKNESS: 2.2–2.5 mils per single wet coat.

SANDING:
 Dry sand: Pre-sand with #P320 grit paper dry, final sand with #P500 to #P600 grit dry.
 Wet sand: Pre-sand with #P500 grit paper wet, final sand with #P600 to #P800 grit wet.

UNSANDED OEM E-COAT PANELS: Lesonal HS Surfacers/Sealer may be used on rigid OEM e-coats parts. For edging of OEM e-coated parts, including exterior surfaces, utilize the sealer ratio. For edging in parts you have the option to utilize the primer surfacer ratio. Do not use this non-sanding process on “after market” parts or flexible or soft plastic parts.

HS SURFACER/SEALER

APPLICATION: Mixture B: For wet-on-wet application

1.  Contains acrylic resins and other ingredients. When mixed, also contains isocyanates.
2.  2:1:20%
HS Surfacers/Sealer
HS Surfacers/Sealer Hardener or
HS Surfacers/Sealer Slow
Lesonal Reducer, Medium, Slow or
Extra Slow
3.  Use The Lesonal Measuring
Stick #4 (2:1:20%).
 - o **Stir thoroughly**
4.  1x1
HVLP Siphon 1.8–2.2 mm
HVLP Gravity 1.3–1.5 mm
Max 10 psi (at air cap)
5.  15 – 20 minutes at 70°F (20°C)
6.  (Wet-on-Wet)
15 minutes at 70°F (20°C)
(Non-Sanding)
Maximum 2-1/2 hours at
70°F (20°C)

MIXING RATIO: Mixture B: For wet-on-wet application:
2 parts by volume of HS Surfacers/Sealer
1 part by volume of HS Surfacers/Sealer Hardener/HS Surfacers/Sealer Hardener Slow
20% by volume of Lesonal Reducer Medium, Slow or Extra Slow

FLEXIBLE PARTS: As a flexible primer sealer, mix HS Surfacers/Sealer with Lesonal Flex Additive:
Flexible Parts: 4:1 **Soft Parts: 3:1**
Then mix this mixture 2:1:20% with HS Surfacers/Sealer Hardener and Lesonal Reducer Medium or Slow. Lesonal Fast Reducer may also be used for small areas such as bumpers.

SPRAYING VISCOSITY: Mixture B: 14–15 sec. DIN cup #4) at 70°F (20°C).

POT LIFE: Mixture B: When mixed, 1 hour at 70°F (20°C) with HS Surfacers/Sealer Hardener.
3 hours at 70°F (20°C) with Hardener Slow.

APPLICATION METHOD: Mixture B (wet-on-wet): Spray one single wet coat. On sanded through areas, first apply one thin coat, flash for 5-10 minutes, then apply one single wet coat, allowing for a flash-off time of 15 minutes prior to topcoat (depending on temperature and film thickness applied).

DRYING TIME: When Mixture B is used (wet-on-wet), HS Surfacers/Sealer can be recoated wet-on-wet after 15 - 20 minutes.



HS SURFACER/SEALER

FILM

THICKNESS: 1.2–1.5 mils per single wet coat.

DE-NIB:

20 minutes at 70°F (20°C) using HS Surfacers/Sealers Hardener
45 minutes at 70°F (20°C) using HS Surfacers/Sealers Hardener Slow

NOTE:

If heavy sanding becomes necessary, this may be done after 12 hours at 70°F (20°C) or 45 minutes at 140°F (60°C).

SPRAY GUN & PRESSURE MIXTURE A:

PRIMER SURFACER:

	Fluid Tip	Spraying Pressure	Fluid Pressure
Siphon Feed	1.8–2.0 mm	40–50 psi	
Gravity Feed	1.8 – 2.0mm	40–50 psi	
Pressure Feed	1.0–1.2 mm	40–50 psi	8–10 psi
HVLP Siphon	1.8–2.2 mm	max. 10 psi (at air cap)	
HVLP Gravity	1.9 – 2.2mm	max. 10 psi (at air cap)	

SPRAY GUN & PRESSURE MIXTURE B:

PRIMER SEALER:

	Fluid Tip	Spraying Pressure	Fluid Pressure
Siphon Feed	1.4–1.7 mm	40–50 psi	
Gravity Feed	1.3–1.4 mm	40–50 psi	
Pressure Feed	1.0–1.2 mm	40–50 psi	8–10 psi
HVLP Siphon	1.8–2.2 mm	max. 10 psi (at air cap)	
HVLP Gravity	1.3–1.5 mm	max. 10 psi (at air cap)	

RECOATABILITY: Mixture B: As a wet-on-wet primer sealer, at 70°F (20°C) HS Surfacers/Sealers can be recoated with Lesonal Basecoat SB up to 1-1/2 hours using HS Surfacers/Sealers Hardener and up to 4 hours using HS Surfacers/Sealers Hardener Slow. After these stated dry times, sanding is necessary before application of topcoat.

COVER RATE:

Mixture A: 75–85 sq. ft./liter (7.3–8.3 sq. meter/liter) per coat for unmixed paint.
Mixture B: 170–185 sq. ft./liter (17–18 sq. meter/liter) per coat for unmixed paint.

HS SURFACER/SEALER

STOCK KEEPING:**CONTAINER****SIZE:** 1 gallon (3.785 lt)**SHELF LIFE:**

HS Surfacers/Sealer:	24 months at 70°F (20°C) if stored unopened.
HS Surfacers/Sealer Hardener:	6 months at 70°F (20°C) if stored unopened.
HS Surfacers/Sealer Hardener Slow:	6 months at 70°F (20°C) if stored unopened.
HS Surfacers Activator:	24 months at 70°F (20°C) if stored unopened.

SAFETY ASPECTS:**READY TO****SPRAY VOC:**

Mixing Ratio:			
3:1:1	4.3 lb/gal	490 g/liter	
2:1:20%	4.5 lb/gal	540 g/liter	

NOTICE:

Do not handle until the Material 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.

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Tel: 770-662-8464

FOR PROFESSIONAL USE ONLY

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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