

Primer Pro LV™

Programmed System Technique (PST)
Primers
05/07/2025

DESCRIPTION

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

As A Primer Surfacers

Safety Considerations



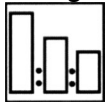
- Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.

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



STICK #3

- | | |
|---------------|--------------------------------------|
| Mixing | Surfacer |
| 4 | Primer Pro LV |
| 1 | Primer Pro LV Hardener |
| 1 | Primer Pro LV Fast or Slow Activator |

Equipment



HVLP or Compliant Spray-Gun Set-Up:

- 1.7 – 2.0 mm

Application Air Pressure:

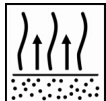
- Consult spray gun manufacturer specifications.
- HVLP maximum 10 psi at the air cap.

Application



- 2 – 3 x 1 Coats

Flash-off



Flash Between Coats at 70°F (21°C)

- 5-10 minutes between coats.

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

- 5-10 minutes before curing.

Drying time



Dry to Sand – 3 Coats

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

Dry to Sand – Infrared

- Low Power 5 Minutes
- Full Power 5 Minutes

Recoatable With



As a Sanded Primer Surfacers Recoatable with:

- All Lesonal primer sealers
- All Lesonal topcoats

Read complete TDS for detailed product information

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DESCRIPTION

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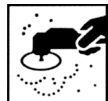
As A Primer Sealer

Safety Considerations



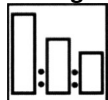
- Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.

Preparation for Primer Surfacers



- OEM factory e-coat thoroughly cleaned requires no sanding except for defects.
- Existing finishes final sanded with #P320 to #P400 dry or #P500 to #P600 wet sand paper.

Mixing



STICK #7

- | | |
|---------------|------------------------------|
| Mixing | Sealer |
| 3 | Primer Pro LV |
| 1 | Primer Pro LV Hardener |
| 1 | Primer Pro LV Slow Activator |

Equipment



HVLP or Compliant Spray-Gun Set-Up:

- 1.3 – 1.5 mm

Application Air Pressure:

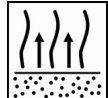
Consult spray gun manufacturer specifications.
HVLP maximum 10 psi at the air cap.

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-off



Flash before Topcoat at 70°F (21°C)

- 15 minutes minimum

Maximum Recoat Window at 70°F (21°C)

- 4 Hours maximum

Recoatable With



As a Wet-On-Wet Primer Sealer Recoatable with:

- All Lesonal topcoats

Read complete TDS for detailed product information

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PRODUCT AND ADDITIVES

Product	Lesonal Primer Pro LV (White)	Item# 515311
	Lesonal Primer Pro LV (Black)	Item# 515313
	Lesonal Primer Pro LV (Gray)	Item# 515312
Hardeners	Lesonal Primer Pro LV Hardener	Item# 515310
Activators	Lesonal Primer Pro LV Fast Activator	Item# 516961
	Lesonal Primer Pro LV Slow Activator	Item# 516962
Additives	LV250 Accelerator	Item #389353
	Lesonal Flex Additive	Item#573777

METHOD OF USE

Suitable substrates	- Existing finishes - Steel - Aluminum - Galvanized steel - OEM e-coat (electro-coat) - Autoprep Pretreatment Wipes or Autoprep Pen	- Glass reinforced laminates (GRP) with intact and un-broken surface - Polyester body filler - Polysurfacer - Properly prepared plastic parts
	- For many applications, Primer Pro LV can be used as a direct-to-metal primer. - Although Primer Pro LV 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. - Before painting plastic refer to the All Plastic Technical Data Sheet for specific information about painting plastics. - Primer Pro LV may be used on rigid OEM e-coat parts. For edging of OEM e-coated parts, including exterior surfaces, utilize the sealer ratio.	

Basic Raw Materials	Primer Pro LV Primer	- Acrylic resins
	Primer Pro LV Hardeners	- Polyisocyanate resins
	Primer Pro LV Activators	- Activated solvents

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Substrate preparation

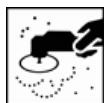


Pre-Cleaning

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with Surface Cleaner, Autoprep Ultraprep or Plastic surface cleaners.
- Avoid saturating body filler with water or cleaners while washing the repair.

Sanding Preparation

	Primer Pro LV Surfacer	Primer Pro LV 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
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 Ultraprep or Plastic surface cleaners prior to priming.

Pre-Treatment

- Primer Pro LV provides adequate adhesion to small bare metal areas. For larger areas or for improved corrosion protection Primer Pro LV should be applied over a metal pre-treatment such as the Autoprep Pretreatment 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 LV. For more information about painting plastic refer to the All Plastic Primer Technical Data Sheet.

Stirring

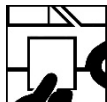


- Because Primer Pro LV is a high-solids product it needs to be thoroughly agitated before use.
- Stir the product several times per day.
- Stir after primer formula is completed, after the addition of hardener, and again after adding activator or reducer for the most complete mixing.

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Mixing Primer Pro LV Colors



Formulas

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

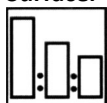
Hand Mixing Colors

- Colors can be custom mixed. However, it is important to include Primer Pro LV 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 Shades 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%)	

Mixing – Primer Surfacer



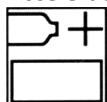
STICK #3

Mixing

- 4** Parts by volume Primer Pro LV
1 Parts by volume Primer Pro LV Hardener
1 Parts by volume Primer Pro LV Fast or Slow Activator

Surfacer

Mixing – Primer Surfacer with Accelerator

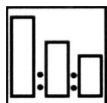


Only use accelerator in Primer Pro LV Surfacer. Do not add more than stated amount to maintain product quality

Accelerated Surfacer

- 1 quart** Primer Pro LV Surfacer – Mixed ready to spray with hardener and activator.
+
1/8 – 1/4 oz LV250 Accelerator and stir thoroughly.
(5-7 mL)

Mixing – Primer Sealer



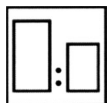
STICK #7

Mixing

- 3** Parts by volume Primer Pro LV
1 Parts by volume Primer Pro LV Hardener
1 Parts by volume Primer Pro LV Slow Activator

Sealer

Mixing – Flexible Parts



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

Make a Mixture of

- 100** Parts by volume Primer Pro LV
15 Parts by volume Flex Additive

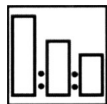
A mixture of 3:1 should be used for soft parts.

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

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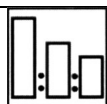
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- Continued from previous page – STEP #2



STICK #3

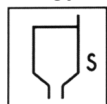
- 4 Surfacers**
1 Parts by volume Primer Pro LV / Flex Additive mixture (Previous step)
1 Parts by volume Primer Pro LV Hardener
1 Parts by volume Primer Pro LV Fast or Slow Activator



STICK #7

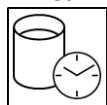
- 3 Sealers**
3 Parts by volume Primer Pro LV / Flex Additive mixture (Previous step)
1 Parts by volume Primer Pro LV Hardener
1 Parts by volume Primer Pro LV Slow Activator

Viscosity When Mixed	Seconds	Measured with a DIN #4 viscosity cup at 70°F (21°C).
	18 – 22	Primer Pro LV Surfacers – Sanding
	13 – 16	Primer Pro LV Sealers – Non-Sanding



DIN #4

Pot-life when Mixed	Product Mix	70°F (21°C)
	Primer Pro LV Primer Surfacers	50 – 60 Minutes
	Primer Pro LV Primer Surfacers – With LV 250 Accelerator	25 - 30 Minutes
	Primer Pro LV Primer Sealers	60 - 90 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 Feed	1.7 – 2.0mm	29 psi at the spray gun inlet (Maximum 10 psi at cap).
	Compliant Gravity Feed	1.7 – 2.0mm	Per manufacturer recommendations.



SEALER	Sealer Spray Guns	Fluid Tip	Application Pressure
	HVLP Gravity Feed	1.3 – 1.5mm	29 psi at the spray gun inlet (Maximum 10 psi at cap).
	Compliant Gravity Feed	1.3 – 1.5mm	Per manufacturer recommendations.



Application	Primer Surfacers
	- 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. <u>Alternate application:</u> Primer Pro LV 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 LV. Apply topcoat after 15 minutes to a



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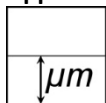
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maximum of 45 minutes at 70°F (20°C).

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).

DRYING / CURING TIME

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.

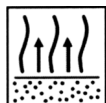
Primer Surfacer Infrared Short Wave Curing



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 infrared 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

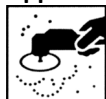
- Prior to topcoating primer sealer, allow a minimum flash off time of 15 minutes at 70°F (21°C).
- Maximum recoat time is 4 hours 70°F (21°C).
- If the maximum flash time is exceeded, Primer Pro LV sealer must be sanded prior to topcoat application, with #P500 to #P600 dry or #P800 wet sand paper.

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Final Preparation Dry Sanding – Machine

– For Top Coat Application



- When dry sanding, respect a maximum 100 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 topcoats.

Surface Cleaning



- Clean with Surface Cleaner, Autoprep Ultraprep or Plastic Surface Cleaner prior to top-coating.

POST-APPLICATION

Recoating



- Lesonal Primer Pro LV can be recoated with all Lesonal sealers and topcoats.

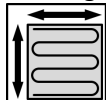
ADDITIONAL INFORMATION

Cleaning of Equipment



- Clean equipment following local and federal regulations.

Theoretical Coverage



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

- | | |
|-------------------------------|--|
| Primer Pro LV Primer Surfacer | - Per coat of ready to spray paint 405-480 ft ² / liter |
| Primer Pro LV Primer Sealer | - Per coat of ready to spray paint 450-550 ft ² / liter (14m ² /liter) |

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VOC / Regulatory Information	System	Mix Ratio	VOC
	Primer Surfacer	4:1:1	2.1 lb/gal (250 g/liter)
	Primer Sealer	3:1:1	2.1 lb/gal (250 g/liter)
	Store unopened, or products in use with approved closed containers and proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).		
	Refer to the <i>Lesonal Product Shelf-Life</i> TDS or the current price list for the most up-to-date shelf-life information		

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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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