

Epoxy Primer Sealer

Programmed System Technique (PST)
Primer
05/26/2021

DESCRIPTION

Lesonal Epoxy Primer Sealer provides excellent corrosion resistance as a primer sealer over multiple substrates. As a sealer, this product provides excellent leveling with superior gloss retention to the topcoat. As a primer, it can be used as a pre-treatment and will provide a fast recoat time with other primers or topcoats. Available in white, gray and black versions, for optimal coverage

Safety

Considerations



- Use suitable personal protection.
- Contains epoxy resins. When mixed with hardener, also contains polyamides

Mixing



STICK #4

4.6 lb/gal VOC Mixture

2:1+20%

- Lesonal Epoxy Primer Sealer
- Lesonal Fast/Slow Epoxy Hardener
- Lesonal Reducers

Mixing



STICK #5

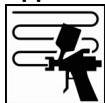
2.8 lb/gal VOC Mixture

3:1:10%

- Lesonal Epoxy Primer Sealer
- Lesonal Fast Epoxy Hardener LV
- Lesonal Reducer LV

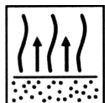
Note: In regulated VOC markets, Epoxy Primer Sealer (2.8 lb/gal VOC Mixture) is only compliant in Canada.

Application



1 coat as a sealer
2 – 3 coats as a primer surfacer
Siphon Feed: 1.6 – 1.8mm
Gravity HVLP: 1.3–1.5mm
Max. 10psi at air cap

Flash-off



10 minutes at 70°F (21°C)

Drying



Wet on Wet

15 – 30 minutes at 70°F (21°C)

Sanding

Overnight at 70°F (21°C)

45- 50 minutes at 140°F (60°C)

Read complete TDS for detailed product information

Epoxy Primer Sealer

Technical Data Sheet
Primer
05/26/2021
Page 2 of 5

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PRODUCT AND ADDITIVES

Product	Lesonal Gray Epoxy Primer Sealer	Item #392438
	Lesonal Black Epoxy Primer Sealer	Item #392494
	Lesonal White Epoxy Sealer	Item #392372
Hardeners	Lesonal Fast Epoxy Hardener	Item #391042 (Gallon) #395360 (Quart)
	Lesonal Slow Epoxy Hardener	Item #395369
	Fast Epoxy Hardener LV	Item #484377 (Gallon) #395978 (Quart)
Reducers	Lesonal Reducer	Item #394295
	Lesonal Reducer LV	Item #394517

METHOD OF USE

Basic raw materials

- Lesonal Epoxy Primer Sealer: epoxy resins
- Lesonal Epoxy Hardeners: polyamide resins
- Lesonal Reducers: Specialty solvent blend

Suitable surfaces

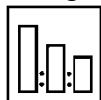
Lesonal Epoxy Primer Sealer can be applied over the following surfaces:

- 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 #P120 grit dry.
- Galvanized steel, cleaned and sand with #P120 grit dry or scuff with a red scuffing pad.
- Aluminum, clean and sand with #P150 to #P180 grit dry or scuff with a red scuffing pad.
- Fiberglass and SMC, clean and sand with #P180 to #280 grit dry.
- RIM, clean and scuffed.
- OEM e-coat parts that have been thoroughly cleaned.

Epoxy Primer Sealer

Technical Data Sheet
Primer
05/26/2021
Page 3 of 5

Mixing ratio



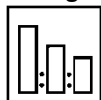
STICK #4

4.6 lb/gal VOC Mixture

2:1+20%

- Lesonal Epoxy Primer Sealer
- Lesonal Fast/Slow Epoxy Hardener
- Lesonal Reducers

Mixing ratio



STICK #5

2.8 lb/gal VOC Mixture

3:1:10%

- Lesonal Epoxy Primer Sealer
- Lesonal Fast Epoxy Hardener LV
- Lesonal Reducer LV

Note: Mix the Epoxy material and the hardener thoroughly and then add reducer.
Always stir thoroughly prior to application.

Note: In regulated VOC markets, Epoxy Primer Sealer (2.8 lb/gal VOC Mixture) is only compliant in Canada.

Spraying viscosity

12–16 seconds DIN cup #4 at 70°F (21°C).

Pot-life



After the components have been mixed, the pot life is:

12 hours with Epoxy Fast Hardener at 70°F (21°C).

12 hours with Epoxy Slow Hardener at 70°F (21°C).

12 hours with Epoxy Fast Epoxy Hardener LV 70°F (21°C).

Spray Gun & pressure



Gravity HVLP
Siphon HVLP

Fluid Tip

1.3–1.5 mm

1.6–1.8 mm

Spraying Pressure

max. 10 psi (at air cap)

max. 10 psi (at air cap)

Application method




-As a Wet-On-Wet primer sealer: Apply one single flowing coat. On sanded through areas, it is advised to first apply a thin coat over these areas to reduce the risk of contour mapping. Allow to flash off for 5 to 10 minutes before proceeding with the final coat.

-As a substrate for polyester products: apply one single coat over the damaged areas. Allow this to dry thoroughly overnight at 70°F (20°C) or 45-50 minutes at 140°F before applying a polyester filler.

Epoxy Primer Sealer

Technical Data Sheet
Primer
05/26/2021
Page 4 of 5

DRYING / CURING TIME

Drying / Time 	The product can be recoated when dry to an even mat finish. Typical dry times are listed below.		
		Fast Hardener	Slow Hardener
		Fast Hardener LV	
	Recoatable wet-on-wet with top coat	15 minutes	30 minutes
	Sanding at 70°F(21°C)	12 hours	24 hours
	Sanding at 140°F(60°C)	45 minutes	50 minutes

POST-APPLICATION

Recoating



Lesonal Epoxy Primer Sealer can be recoated without sanding with Lesonal primers and basecoats after the stated drying times and up to 7 days. After this time sanding is required to ensure intercoat adhesion.

Sanding

If sanding is required, allow a dry time of 12 hours for Fast Hardener, Fast Hardener LV or 24 hours for Slow Hardener at 70°F (21°C). After this dry to sand time, Lesonal Epoxy Primer Sealer can be denibbed or sanded with #P400 grit paper dry or #P500 to #P600 grit wet before topcoating.

Film thickness

Approximately 1.0-1.4 mils per single coat.

Coverage rate

Coverage rate is provided as ready to spray product with 100% Transfer Efficiency at 1 mil

4.6 lb/gal Mix 510 +/- 10 ft²/liter 12.0 +/- 1 m²/liter

2.8 lb/gal Mix 580 +/- 10 ft²/liter 14.0 +/- 1 m²/liter

Shelf life

	If stored unopened at room temperature
Epoxy Primer Sealer:	2 years
Fast Epoxy Hardener, Fast Epoxy Hardener LV and	1 year
Slow Epoxy Hardener:	

Safety aspects

Ready to Spray VOC

Lesonal Epoxy Primer Sealer 2:1+20% ratio 4.6 lb/gal (552 g/liter)

Lesonal Epoxy Primer Sealer 3:1:10% ratio 2.8 lb/gal (336 g/liter)

Note: In regulated VOC markets, Epoxy Primer Sealer (2.8 lb/gal VOC Mixture) is only compliant in Canada.

Epoxy Primer Sealer

Technical Data Sheet
Primer
05/26/2021
Page 5 of 5

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FOR PROFESSIONAL USE WITH SUITABLE HSE 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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