

Primer Pro – As a Surfacer

Programmed System Technique (PST)
Primers
04/28/2020

DESCRIPTION

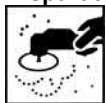
Primer Pro is a high-solids urethane surfacer and sealer. Depending on the mixing ratio used, Primer Pro can be either used as a high build sanding surfacer or wet-on-wet primer sealer. Primer Pro is available in white, gray and black for fast topcoat coverage and versatility. Used as a primer surfacer Primer Pro provides the high build needed along with fast drying and easy sanding.

Safety Considerations



- Use suitable personal protection
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator

Surface Preparation



- Existing Finishes
 - #P240 to #P360 sandpaper dry
- Body Filler
 - #P150 to #P220 sandpaper dry
- Bare Steel
 - #P80 then #P120 sandpaper dry

Surface Cleaning



- Use suitable surface cleaners and technique to ensure a clean surface.

Mixing



STICK # 3

- | Mix | Standard Mix |
|-----|--|
| 4 | Parts Primer Pro |
| 1 | Parts Primer Pro Hardener |
| 1 | Parts Primer Pro Activator, Fast or Medium |

Equipment



Spray-Gun Set-Up:

- 1.7 – 2.0mm HVLP Gravity

Application Air Pressure:

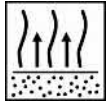
- HVLP – 10 psi (0.68 bar) at cap maximum.
- Consult manufacturers' specifications.

Application



- Apply 2 to 3 single (medium wet) coats.
 - Flash dry between coats.

Flash-off



Flash Between Coats at 70°F (21°C)

- 5 to 10 minutes

Flash Before Force Curing at 140°F (60°C)

- 5 to 10 minutes

Drying



Drying at 70°F (21°C)

- 3 hours for 3 coats

Force Dry Curing

- 30 minutes at 140°F (60°C)
- Shortwave Infra-Red, 5 minutes low power then 5 minutes high power.

Recoatable With



Recoatability

- All Lesonal primer sealers
- All Lesonal basecoats
- Reference the Technical Data sheet for the product to be applied for sanding instructions.

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information

Primer Pro – As a Primer Sealer

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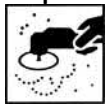
As a sealer Primer Pro provides good build, exceptional leveling, coverage and holdout for a top-rate appearance.

Safety Considerations



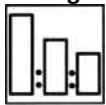
- Use suitable personal protection
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator

Surface Preparation



- Existing Finishes
 - #P320 to #P400 sandpaper dry
- Bare Steel
 - #P80 then #P120 sandpaper dry

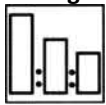
Mixing



STICK # 7

- | | |
|---------------|--|
| Mixing | Standard Mix |
| 3 | Parts Primer Pro |
| 1 | Parts Primer Pro Hardener |
| 1 | Parts Primer Pro Sealer Reducer or Primer Pro Fast Activator |

Mixing



STICK # 8

- | | |
|---------------|---------------------------------------|
| Mixing | High Temperature Mix |
| 100 | Parts Primer Pro |
| 25 | Parts Primer Pro Sealer Hardener Slow |
| 35 | Parts Primer Pro Sealer Reducer |

Equipment



Spray-Gun Set-Up:

- 1.4 – 1.5 mm HVLP Gravity
- 1.4 – 1.5 mm Compliant

Application Air Pressure:

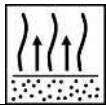
- HVLP – 10 psi (<0.7 bar) at cap maximum.
- Consult manufacturer specifications.

Application



- Apply 1 to 2 thin but flowing coat over the desired area.

Flash-off



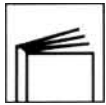
Flash Between Coats at 70°F (21°C)

- 5 minutes

Flash at 70°F (21°C) Before Topcoating

- 15 minutes
 - Maximum of 4 hours.

Recoatable With



- After flash drying may be recoated with Lesonal basecoats.

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information

Primer Pro

Technical Data Sheet
Primers
04/28/2020
Page 3 of 10

DESCRIPTION

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

PRODUCT AND ADDITIVES

Product	• Lesonal Primer Pro (White)	– Item #527657
	• Lesonal Primer Pro (Black)	– Item #527658
	• Lesonal Primer Pro (Gray)	– Item #527659

Hardeners	• Lesonal Primer Pro Hardener	– Item #527660
	• Lesonal Primer Pro Sealer Hardener Slow	– Item #544595

Activators / Reducers	• Lesonal Primer Pro Activator	– Item #527661
	• Lesonal Primer Pro Fast Activator	– Item #527662
	• Lesonal Primer Pro Sealer Reducer	– Item #527663

Additives	• Lesonal Accelerator	– Item #397672
	• LV250 Accelerator	– Item #389353
	• Lesonal Flex Additive	– Item #396027

SDS and TDS for products available online at – <http://my.anaac.net/>

METHOD OF USE

Suitable substrates	• Steel	• Fiberglass gelcoat (Unbroken)
	• Galvanized steel	• Polyester body filler
	• Aluminum	• OEM E-Coat
	• AutoPrep Pretreatment	• Existing finishes (Except acrylic lacquers)
	• Properly prepared plastics	

Primer Pro

Technical Data Sheet
Primers

04/28/2020
Page 4 of 10

Basic Raw Materials



- Primer Pro Primer
 - Primer Pro Hardeners
 - Primer Pro Activators
- Acrylic resins
 - Polyisocyanate resins
 - Activated solvents

Substrate preparation



Pre-cleaning

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with Lesonal Surface Cleaner, AutoPrep Ultra-Prep (VOC compliant) or Plastic Surface Cleaner.



Sanding Preparation

	For Surfacer	For 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 or Red Pad	N / A
Gel-Coat	#P220 to #P360	#P320 – #P400	#P500 – #P600
Non-OEM Primed Plastic	N / A	#P1000	N / A
Polyolefin Plastic	#P320 to #P400	#P400	#P500 – #P600
Non-Polyolefin Plastic	##P320 to #P400	#P320 – #P400	#P500 – #P600



- Primer Pro Surfacer will provide adequate adhesion on small bare metal areas. Repairs that require extensive metal priming such as panels that have had the existing paint system removed require Autoprep Pretreatment Wipe application prior to coating with Primer Pro.
- Polyolefin plastics require a pre-treatment adhesion promoter. Prime polyolefin plastics with All Plastic Primer prior to the application of flexed Primer Pro. For more information about painting plastic refer to the All Plastic Primer Technical Data Sheet.

Surface Cleaning – Prior to Paint Application



- Clean with Lesonal Surface Cleaner, Autoprep UltraPrep (VOC compliant) or Plastic Surface Cleaner.

Primer Pro

Technical Data Sheet
Primers
04/28/2020
Page 5 of 10

Product Agitation



Stirring

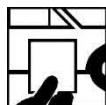
- Because Primer Pro is a high solids product it needs to be thoroughly agitated before use.
- Stir the product several times per day.
- Stir after primer formula is completed, after the addition of hardener and again after adding activator or reducer for the most complete mixing.

Mixing Color Formulas and Products



Formulas

- A wide range of Primer Pro formulas are available to match the most popular OEM primer shades. These are available in MixitPro.
 - Ensure when a specified primer color is suggested to use that shade of undercoat primer.
- For easy mixing of color formulas or products, final mixing including hardening, reduction and the addition of additives can be done through the Color Manager program.



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%)	

Hand Mixing Colors

- Colors can be custom mixed. However, it is important to include Primer Pro White and/or Black to all colors. This includes adding a small amount of black to 100% white for increased hiding.

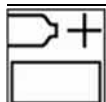
Mixing – Surfacers



STICK #3

Mix

- 4** Parts Primer Pro
1 Parts Primer Pro Hardener
1 Parts Primer Pro Activator, Fast or Medium



Mix Adding Accelerator to Surfacers

To 1 quart of ready to spray surfacer stir in one of the following.

- ½ oz.** – Lesonal Accelerator or
⅓ - ¼ oz. – LV250 Accelerator

Primer Pro

Technical Data Sheet
Primers

04/28/2020
Page 6 of 10

Mixing – Primer Sealer



STICK #7

Mix

3

1

1

Standard Mix

Parts Primer Pro

Parts Primer Pro Hardener

Parts Primer Pro Sealer Reducer or Primer Pro Fast Activator

- Use Primer Pro Sealer Reducer for 70°F-85°F applications.
- Primer Pro Fast Activator is suitable for temperatures of 60-75°F.



STICK #8

Mix

100

25

35

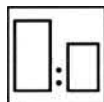
High Temperature Mix (85-110°F)

Parts Primer Pro

Parts Primer Pro Sealer Hardener Slow

Parts Primer Pro Sealer Reducer

Mixing – Flexible Parts



STICK #3

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

Make a Mixture of

4

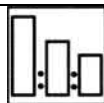
Parts by volume Primer Pro

1

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 –



STICK #3

Surfacer

4

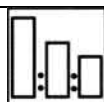
Parts by volume Primer Pro / Flex Additive (Previous step)

1

Parts by volume Primer Pro Hardener

1

Parts by volume Primer Pro Activator



STICK #7

Sealer Standard Mix

3

Parts by volume Primer Pro / Flex Additive mixture (Previous step)

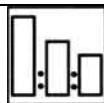
1

Parts by volume Primer Pro Hardener

1

Parts by volume Primer Pro Sealer Reducer

*Recommended mixture when painting aftermarket plastic bumpers



STICK #8

Sealer High Temperature

100

Parts by volume Primer Pro / Flex Additive mixture (Previous step)

25

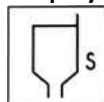
Parts by volume Primer Pro Sealer Hardener Slow

35

Parts by volume Primer Pro Sealer Reducer

*Recommended mixture when painting aftermarket plastic bumpers

Viscosity – Ready to Spray






- Primer Pro Surfacer – Sanding mixture
- Primer Pro Sealer – Non-Sanding mixture

DIN #4 at 70°F (21°C)

- 18 – 22 Seconds
- 13 – 16 Seconds

Primer Pro

Technical Data Sheet
Primers
04/28/2020
Page 7 of 10

Pot-life when Mixed	Product Mix	70°F (21°C)	85°F (35°C)
	Primer Pro Primer Surfacer Primer Pro Primer Surfacer – With LV 250 Accelerator Primer Pro Sealer 3:1:1 using Fast Activator Primer Pro Sealer 3:1:1 using Primer Pro Reducer Primer Pro Sealer 100:25:35 using Sealer Hardener Slow and Primer Pro Reducer	50-60 min. 25-30 min. 50-60 min. 60-90 min. 120-180 min.	25-35 min. 15 min. 25-30 min. 50-60 min. 50-70 min.
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 Fed	1.7 – 2.0mm	29 psi at the spray gun inlet (Maxium10 psi at cap).
	Compliant Gravity Fed	1.7 – 2.0mm	29 to 35 psi at the spray gun inlet.
Spray Gun Set-Up	Sealer Spray Guns	Fluid Tip	Application Pressure
SEALER 	HVLP Gravity Fed	1.4 – 1.5mm	29 psi at the spray gun inlet (Maxium10 psi at cap).
	Compliant Gravity Fed	1.4 – 1.5mm	29 to 35 psi at the spray gun inlet.
Application	Primer Surfacer	<ul style="list-style-type: none"> 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. <ul style="list-style-type: none"> Flash off between the coats until the surface becomes totally matt (about 5-10 minutes), this will depend on ambient temperature, applied thickness/wetness and airflow. 	
	Primer Sealer	<ul style="list-style-type: none"> Apply 1 to 2 thin but flowing coat over the desired area. Flash 5 minutes between coats. <ul style="list-style-type: none"> Over any sand through areas, first apply a thin coat to make all the substrate layers uniform before continuing with a normal coat. 	

Primer Pro

Technical Data Sheet
Primers
04/28/2020
Page 8 of 10

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.

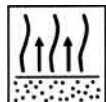


Primer Surfacer Infra-Red Short-Wave Curing

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 minutes flash off before infra-red curing.
- Cure 5 minutes on low power followed directly by a 5-minute full power cure.

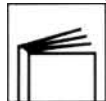
Drying Flash Time – Primer Sealer



- Prior to top-coating primer sealer, allow a minimum flash off time of 15 minutes at 70°F (21°C).
 - Maximum re-coat time is 4 hours 70°F (21°C).
 - ✓ If the maximum flash time be exceeded, Primer Pro sealer must be sanded prior to topcoat application. Sand following the sanding instructions for the product to be applied before basecoat application.

POST-APPLICATION

Recoating



- Lesonal Primer Pro can be re-coated with all Lesonal sealers and topcoats.
 - Refer to the technical data sheet for the product you will be applying for information.

ADDITIONAL INFORMATION

Cleaning of Equipment



- Clean equipment and dispose of waste following local and federal regulations. In compliant localities, use a VOC compliant high-quality solvent borne gun cleaner. For national rule regions, a use high quality lacquer thinner.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

Primer Pro

Technical Data Sheet
Primers

04/28/2020
Page 9 of 10

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).

Theoretical Coverage



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

Ready to Spray –

- | | |
|--|-----------------------------------|
| • Primer Pro Primer Surfacer | – 600-630 ft ² / liter |
| • Primer Pro Primer Sealer | – 580-610 ft ² / liter |
| • Primer Pro Sealer with Slow Hardener | – 730-738 ft ² / liter |

VOC / Regulatory Information



Primer Pro Product

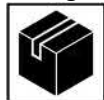
VOC Pounds per Gallon

VOC Grams per Liter

- | | | |
|--|---------|-------|
| • Primer Surfacer (4:1:1) | – <4.80 | – 575 |
| • Primer Sealer (3:1:1) | – 4.60 | – 550 |
| • Primer Sealer with Slow Hardener (100:25:35) | – 4.51 | – 540 |

- Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on 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.

Product Storage



Item unopened or used products in approved closed containers with 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)

- | | |
|-----------------------------------|-------------|
| • Primer Pro | – 2 years |
| • Primer Pro Hardeners | – 6 months |
| • Primer Pro Activator or Reducer | – 12 months |

Primer Pro

Technical Data Sheet
Primers
04/28/2020
Page 10 of 10

AkzoNobel Inc., North America

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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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