

Basecoat SB Interior Converter

Programmed System Technique (PST)
Basecoat
5/22/2017

DESCRIPTION

When mixed with Basecoat SB, Lesonal Interior Converter Gloss and Mat is a low gloss Specialty Coating designed for application over existing and new interior automotive parts. The Gloss and Mat Interior Converters provide consistent performance in a wide range of colors. Those colors are specifically matched to both the color and gloss of OEM standards.

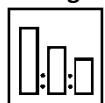
Safety

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.

Mixing



STICK #4

Mixing

- 2 Parts by volume Lesonal SB Interior color
- 1 Parts by volume Lesonal Reducer

Equipment



HVLP or Compliant Spray-Gun Set-Up:

1.3 mm

Application Air Pressure:

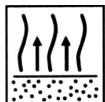
Consult spray gun manufacturer specifications.
HVLP – 10 psi at the air cap maximum.

Application



Apply 2 coats of color or until hiding is achieved.

Flash-off



Flash Between Coats at 70°F (21°C)

3-5 minutes

Drying



Air Drying at 70°F (21°C)

Parts will be ready to handle in 15-20 minutes.

Read complete TDS for detailed product information

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PRODUCT AND ADDITIVES

Product	Lesonal Interior Converter Gloss	Item #390132
	Lesonal Interior Converter Mat	Item #390136
Hardeners	Lesonal Clear Hardener	Item #395734
Reducers	Lesonal Reducer Extra Slow	Item #394938
	Lesonal Reducer Slow	Item #394695
	Lesonal Reducer Medium	Item #394295
	Lesonal Reducer Fast	Item #394893
	Lesonal Reducer Extra Fast	Item #394318

METHOD OF USE

Suitable Substrates

- Existing interior parts
- New OEM interior parts (ABS, RIM)
- Lesonal All Plastic Primer (any polyolefin type plastic, ie. PP, PE)

Note: Do not paint air bag covers.

Basic Raw Materials

Contains vinyl / polyester resins and other ingredients. When mixed, may also contain isocyanates.

Substrate Preparation

Degrease existing finishes and new parts with Lesonal Surface Cleaner or compliant surface cleaner. Removal of owner applied waxes is crucial for adhesion.

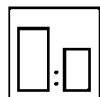


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Mixing Colors If a desired color is not available in the color documentation, use the color map to pick the Lesonal SB formula closest to the original. Then mix 2 parts by volume of Lesonal SB Basecoat color to 1 part by volume Lesonal Interior Converter 08 Gloss or 09 Mat to achieve the desired gloss level. Use Lesonal mixing stick #4. Stir thoroughly, reduce and apply as normal.

**Mixing –
General**



STICK #4

Mixing

- 2** Parts by volume Lesonal SB Interior color
- 1** Parts by volume Lesonal Reducer

**Mixing –
Gloss Levels**

The amount of Lesonal Interior Converter mixed or blended will change the desired sheen depending on the ratio of Gloss Converter 08 or Mat Converter 09 intermixed. The total of Lesonal Interior Converter should not exceed 2 parts Lesonal SB color to 1 part Lesonal Interior Converter. Below is a chart describing the gloss level.

	Gloss 08	Mat 09
Semi Gloss	100	0
Low Gloss	50	50
Mat	0	100

**Mixing –
Hardener
Selection**

10% Lesonal Clear Hardener can be added to the interior coating prior to reduction. The hardener will improve resistance to harsh solvents. Use of hardener is optional. Hardener will increase the gloss level of the coating. The balance of Gloss and Mat Interior Converter should be adjusted accordingly.

**Viscosity
When Mixed**

13-15 seconds

Measured with a DIN #4 viscosity cup at 70°F (21°C).



DIN #4

**Pot-life When
Mixed**

Product Mix

- Lesonal SB mixed color with interior converter
- Lesonal SB mixed color with interior converter and 10% hardener

70°F (21°C)

- 3-5 days
- 4-6 hours

**Spray Gun
Set-Up**



Consult spray gun manufactures instructions for specific spray gun pressure specifications.

Spray Gun

- HVLP Gravity Fed**
- Compliant Gravity Fed**

Fluid Tip

- 1.3-1.5 mm
- 1.3-1.5 mm

Application Pressure

- Max 0.7 bar at the spray gun inlet (<10 psi at cap).
- Max 0.7 bar at the spray gun inlet (<10 psi at cap)

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Application



Apply 1 single closed coat. Allow a flash off time between coats of 3-5 minutes or completely flashed. Apply a second closed coat as necessary for coverage.

Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.

DRYING / CURING TIME

Drying / Curing Time



Drying times are stated a recommended application method, film thickness and object temperature.
Dry to Handle 15-20 minutes at 70°F (21°C)

POST-APPLICATION

Recoating



Lesonal SB Interior coating can be recoated with itself at any stage.

VOC / Regulatory Information



Lesonal Interior Converter – 4.8-5.3 lbs/gal (576-638 g/L)

Using the Lesonal Interior Converter mixed with Lesonal Reducer will yield a ready to spray VOC of 6.2-6.5 lbs/gal (744-780 g/L)

Product Storage



Stock 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).

Lesonal Interior Converter 1 year

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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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