






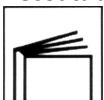


Universal Clear

Programmed System Technique (PST)
Clearcoat
06/05/2020

DESCRIPTION

Lesonal Universal Clear is an acrylic urethane clearcoat for use over Lesonal Basecoat SB or Lesonal Basecoat WB and intended for applications in cross flow and air-dry conditions. Universal Clear offers excellent resistance to surface contamination with excellent gloss, making it an ideal choice for air-dry environments.

Safety Considerations 	Use suitable personal protection AkzoNobel recommends the use of fresh air supply respirator Refer to the product Safety Data Sheet (SDS) for more complete safety information.	
Mixing 	Mixing 3 Lesonal Universal Clear 1 Lesonal Clear Hardener 1 - 1.5 Lesonal Clear Extra Slow, Slow or Fast Activator	
Equipment 	HVLP or Compliant Spray-Gun Set-Up: 1.3-1.5 mm	Application Air Pressure: Consult spray gun manufacturer specifications. HVLP – 10 psi (<0.7 bar) at the air cap maximum.
Application 	Apply 2 single wet coats. If heavy sanding and polishing is required, a third coat may be applied after the stated flash time.	
Flash-off 	Flash Between Coats at 70°F (21°C) 5-10 minutes	Flash at 70°F (21°C) Before Force Drying 5-10 minutes
Drying 	Air Drying at 70°F (21°C) Dust Free – Slow Activator 60 minutes	Dry to Handle – Slow Activator 10 hours <i>Dependent on film weight.</i>
Drying 	Force Drying at 140°F (60°C) Dry to Handle – Slow Activator 35 minutes	Infrared Not recommended
Recoatable With 	Lesonal Universal Clear can be recoated with itself at any stage. Sanding will become necessary after 12 hours.	

Read complete TDS for detailed product information

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PRODUCT AND ADDITIVES

Product	Lesonal Universal Clear	Item #398547
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Hardeners	Lesonal Clear Hardener	Item #395734
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Activators	Lesonal Clear Extra Slow Activator	Item #391001
	Lesonal Clear Slow Activator	Item #398548
	Lesonal Clear Fast Activator	Item #398549

Additives	Lesonal Flex Additive	Item #573777
	Lesonal Accelerator (Add 0.5 oz per ready to spray quart)	Item #397672
	Lesonal EZ Matte	Item #510528

METHOD OF USE

Suitable substrates	<ul style="list-style-type: none">• Lesonal SB Solid, Metallic and Pearl Colors after a flash off time of 15-20 minutes at 70°F (21°C)• Lesonal WB Solid, Metallic and Pearl colors after a flash off time of 15-20 minutes at 70°F (21°C)• Existing finishes that have been sanded and degreased.
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Basic Raw Materials	<ul style="list-style-type: none">• Lesonal Universal Clear – Hydroxyl Acrylic resins• Lesonal Clear Hardener – Polyisocyanate resins• Lesonal Clear Slow and Extra Slow Activators – Special activated solvent blends• Lesonal Clear Fast Activator – Activated reducer containing special solvent blends and catalyst
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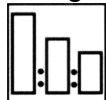
Substrate Preparation



Cleaning

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

Mixing -General

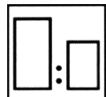


#7 Stick

- 3** Parts by volume Universal Clear
1 Parts by volume Lesonal Clear Hardener
1 – 1.5 Parts by volume Lesonal Clear Activator

Use the Lesonal #7 measuring stick when mixing by hand.

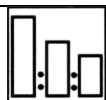
Mixing – Flexible Parts



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

- 100** Parts by volume Lesonal Universal Clear
10 Parts by volume Lesonal Flex Additive

Stir the paint with Flex Additive together THEN –



#7 Stick

- 3** Parts by volume Universal Clear
1 Parts by volume Lesonal Clear Hardener
1-1.5 Parts by volume Lesonal Clear Activator

Use the Lesonal #7 measuring stick when mixing by hand.

Viscosity When Mixed



DIN #4

13-15 SECONDS

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

Pot-Life When Mixed

Product Mix

Using Lesonal Clear Extra Slow or Slow Activator
Using Clear Fast Activator

70°F (21°C)

4 hours
2 hours

Spray Gun Set-Up



Consult spray gun manufacturer instructions for spray gun pressure specifications.

Spray Gun

HVLP Gravity Fed

Compliant Gravity Fed

Fluid Tip

1.3 – 1.5mm

1.2 – 1.4mm

Application Pressure

<10 psi (<0.7 bar) at cap

<10 psi (<0.7 bar) at cap

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APPLICATION TECHNIQUE

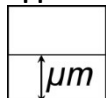
Application



Apply 2 single wet coats. If heavy sanding and polishing is required, a third coat may be applied after the stated flash time.

Allow a flash off time between coats of 5-10 minutes. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.

Film Thickness – Using Suitable Application



1 coat will achieve a thickness of 1.2-1.5 mils (30 – 38μm).

DRYING / CURING TIME

Drying / Curing Time



Drying times are stated a recommended application method, film thickness and object temperature.

	70°F (21°C)		140°F (60°C)	
	Dust Free	Dry to Handle	Dust Free	Dry to Handle
Lesonal Clear Extra Slow Activator	90 min.	12 hours	25 min.	40 min.
Lesonal Clear Slow Activator	60 min.	10 hours	25 min.	35 min.
Lesonal Clear Fast Activator	30 min.	5 hours	10 min.	20 min.

Lesonal Universal Clear Accelerated

Lesonal Clear Extra Slow Activator	40 min.	9 hours	15 min.	30 min.
Lesonal Clear Slow Activator	20 min.	7 hours	10 min.	25 min.
Lesonal Clear Fast Activator	Not recommended	Not recommended	Not recommended	Not recommended

POST-APPLICATION

Recoating



Lesonal Universal Clear can be recoated with itself at any stage. Sanding will become necessary after 12 hours.

Decals / Lettering

Decals can be applied after 48 hours at 70°F (21°C).
Hand striping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a gray scuff pad.

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ADDITIONAL INFORMATION

Cleaning of Equipment



Clean equipment following local and federal regulations.

Theoretical Coverage



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

- Ready to spray mixture at 1.0 mil, 100% TE – 700 sq ft/L (17 m²/L)

VOC / Regulatory Information



When mixed ready to spray, Lesonal Universal Clear yields a VOC content of:
3.8 lb/gal 464 g/liter

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 Universal Clear	12 months
Lesonal Clear Hardener	6 months
Lesonal Clear Activator Extra Slow, Slow and Fast	12 months

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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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