
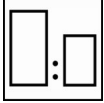






ProAir Clear 2 Pack™

Programmed System Technique (PST)
Clearcoat
11/06/2019

DESCRIPTION

Lesonal Pro Air Clear 2 Pack Fast or Slow is an acrylic urethane clearcoat for use over Lesonal Basecoat SB or Lesonal WB and intended for applications in cross flow and air-dry conditions. Pro Air Clear 2 Pack Fast or Slow offers a built-in flex package and excellent resistance to surface contamination with great gloss, making it an ideal choice for air dry environments.

Safety Considerations	<ul style="list-style-type: none"> • 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	Mixing 2 Lesonal Pro Air Clear 2 Pack Fast or Lesonal Pro Air Clear 2 Pack Slow 1 Lesonal Pro Air Clear 2 Pack Hardener	
		
STICK #4		
Equipment	HVLP or Compliant Spray-Gun Set-Up: 1.3-1.5 mm	Application Air Pressure: Consult spray gun manufacturer specifications. HVLP – 10 psi at the air cap maximum.
		
Application	Apply 2 medium wet coats allowing for flash between coats.	
		
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 time	Air Drying at 70°F (21°C) Dry to Handle 3 hours – Pro Air Clear 2 Pack Fast 8 hours – Pro Air Clear 2 Pack Slow	Force Drying at 120°F (49°C) ambient Dry to Handle 20 minutes – Pro Air Clear 2 Pack Fast 30 minutes – Pro Air Clear 2 Pack Slow
		
*Do not exceed 120°F ambient as you may experience coating defects.		

Read complete TDS for detailed product information

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DESCRIPTION

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PRODUCT AND ADDITIVES

Product	Pro Air Clear 2 Pack Fast	Item #555887
	Pro Air Clear 2 Pack Slow	Item #555886
Hardeners	Pro Air Clear 2 Pack Hardener General purpose hardener for all repair sizes	Item #539540
Additives	EZ Matte	Item #510528
	Lesonal Accelerator	Item #397672
	Lesonal Flex Additive (For soft parts only)	Item #396027

METHOD OF USE

- Suitable substrates**
- Lesonal WB Basecoat- after a flash off time of 15-20 minutes at 70°F (21°C)
 - Lesonal SB Basecoat - after a flash off time of 15-20 minutes at 70°F (21°C)
 - Existing finishes that have been sanded and degreased in the case of spot repairs and blending.

- Basic Raw Materials**
- Pro Air Clear 2 Pack Fast and Slow – Acrylic polyol resins
 - Pro Air Clear 2 Pack Hardener - Polyisocyanate resins
 - Additives - Refer to the individual TDS for information.

Substrate Preparation

Surface Cleaning – Prior to Paint Application

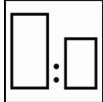
- Clean with Surface Cleaner, Autoprep Ultra Prep, or Plastic Surface Cleaner.



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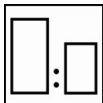
Mixing – Standard Ratio **2** Parts by volume Pro Air Clear 2 Pack Fast or Slow
 1 Parts by volume Pro Air Clear 2 Pack Hardener



STICK #4

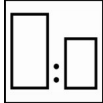
Pro Air Clear 2 Pack Fast and Slow Clearcoats can be blended to accommodate spraying conditions

Mixing – Accelerator Ratio **2** Parts by volume Pro Air Clear 2 Pack Fast or Slow
 1 Parts by volume Pro Air Clear 2 Pack Hardener
Ratio **1 ounce per** Parts by volume Lesonal Accelerator
 RTS quart



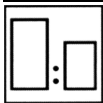
STICK #4

Mixing – Soft Parts Lesonal Pro Air Clear 2 Pac does not require flex additive when being applied over plastic substrates. However, Lesonal Flex Additive is needed when soft foam parts are being painted.



100 Parts by volume Pro Air 2 Pack Fast or Slow Clearcoat
10-15% Parts by volume Lesonal Flex Additive

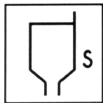
Stir the paint with Flex Additive together THEN –



STICK #4

2 Parts by volume Pro Air Clear 2 Pack Fast or Slow with Flex Additive
1 Parts by volume Pro Air Clear 2 Pack Hardener

Viscosity When Mixed **14-17 seconds** Measured with a DIN #4 viscosity cup at 70°F (21°C).



DIN #4

Potlife when Mixed	Product Mix	70°F (21°C)
	Pro Air Clear 2 Pack Fast	2 hours
	Pro Air Clear 2 Pack Fast Accelerated	1.5 hours
	Pro Air Clear 2 Pack Slow	4 hours
	Pro Air Clear 2 Pack Slow Accelerated	2 hours

Spray Gun Set-Up	Spray Gun	Fluid Tip	Application Pressure
	HVLP Gravity Fed	1.3-1.5 mm	<10 psi at air cap < 0.7 bar at air cap
	Compliant Gravity Fed	1.3-1.5 mm	Consult equipment manufacturer recommendations.

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Application



Apply 2 single flowing coats. If heavy sanding and polishing is required, a third coat may be applied after the stated flash off 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 (30-38 µm).

DRYING / CURING TIME

Drying / Curing Time



Below is a table showing the drying times of Pro Air Clear 2 Pack Fast or Slow with Pro Air Clear 2 Pack Hardener. The air-dry times stated may increase with insufficient airflow.

Dry times were measured under the following conditions:

- Testing was done at 70°F (21°C).
- Temperatures are reported as metal temperature.
- Accelerated dry times were measured when 1 ounce of Lesonal Accelerator is added per ready to spray quart or clearcoat.

	Slow	Slow / Fast (75% / 25%)	Slow / Fast (50% / 50%)	Slow / Fast (25% / 75%)	Fast
Standard Mix Dust Free	20 minutes	15 minutes	15 minutes	15 minutes	10 minutes
Accelerated Mix Dust Free	10 minutes	10 minutes	5 minutes	5 minutes	5 minutes
Standard Mix Dry	8 hours	7-1/2 hours	4 hours	3-1/2 hours	3 hours
Accelerated Mix Dry	4 hours	3 hours	2-1/2 hours	2 hours	2 hours

Dry times were also measured at a low bake ambient temperature of 120°F (49°C).

Note: Do not exceed 120°F ambient as you may experience coating defects.

Do not bake an accelerated system.

	Slow	Slow / Fast (75% / 25%)	Slow / Fast (50% / 50%)	Slow / Fast (25% / 75%)	Fast
Standard Mix Dry to Handle	30 minutes	30 minutes	25 minutes	20 minutes	20 minutes

ProAir Clear 2 Pack[™]

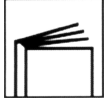
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- Drying / Curing with shortwave infrared equipment is not recommended.

POST-APPLICATION

Recoating



Pro Air Clear 2 Pack Fast or Slow Clearcoat can be recoated with itself at any stage. Sanding will become necessary after 24 hours.

Polishing, Decals and Lettering



Polishing

Dust and minor damage can be polished out after the stated air-dry times have been reached. Carefully sand out dust particles with #P1500 or finer grit paper and then polish the area mechanically.

Note: When heavy color sanding and polishing are required, it may be necessary to apply one extra coat of Pro Air Clear 2 Pack Fast or Slow Clear. When completed, a minimum of 2.4 mils of clearcoat is required for adequate durability.

Decals

Decals can be applied after 48 hours at 70°F (21°C)

Lettering

Painted striping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a gray scuffing pad.

ADDITIONAL INFORMATION

Cleaning of Equipment



Clean equipment following local and federal regulations. In compliant localities, use Sikkens LV Cleaning Solvent or high-quality solvent borne gun cleaner. For national rule regions, use Sikkens Cleaning Solvent or high-quality lacquer thinner.

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. Coverage is given at 1 mil of applied ready to spray paint with 100% transfer efficiency.

- 586 Sq ft / gallon
- 14.5 m² / liter

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**VOC /
Regulatory
Information**



Ready to Spray VOC at 2:1 mixture

Pro Air Clear 2 Pack Fast or Slow yields a VOC content of: 4.13 lb/gal 496 g/liter

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



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).

Pro Air Clear 2 Pack Fast	2 years
Pro Air Clear 2 Pack Slow	2 years
Pro Air Clear 2 Pack Hardener	6 months

AkzoNobel Inc., North America

Address: 1845 Maxwell Street – Troy, MI 48084 USA

Telephone: 800.618.1010

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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