
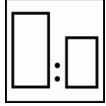


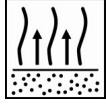





ProAir Clear LV 2 Pack™

Programmed System Technique (PST)
Clearcoat
03/24/2020

DESCRIPTION

Lesonal Pro Air Clear LV 2 Pack is an acrylic urethane clearcoat for use over Lesonal WB or SB basecoat and intended for ambient cure conditions. This clearcoat offers excellent resistance to surface contamination and with a built-in flexibility package & excellent gloss, it's an ideal choice for air dry environments. It also meets the regulation requirements offered at 250 gm/liter VOC.

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	Mixing 2 ProAir Clear LV 2 Pack Fast / Slow Clear 1 ProAir Clear LV 2 Pack Hardener	
 STICK #4		
Equipment	HVLP or Compliant Spray-Gun Set-Up: HVLP Gravity 1.3-1.5 mm Compliant Gravity 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	2 flowing coats	
		
Flash-off	Flash Between Coats at 70°F (21°C) Pro Air Clear LV 2 Pack Fast / Slow 5-10 minutes	Flash Before Force Drying at 70°F (21°C) Pro Air Clear LV 2 Pack Fast / Slow 5-10 minutes
		
Drying time	Air Drying at 70°F (21°C) Dust Free Pro Air Clear LV 2 Pack Fast: 20 minutes Pro Air Clear LV 2 Pack Slow: 20 minutes	Dry to Handle Pro Air Clear LV 2 Pack Fast: 80 minutes Pro Air Clear LV 2 Pack Slow: 110 minutes <i>Dependent on film weight.</i>
		
Drying time	Force Drying at 120°F (49°C) Dust Free Pro Air Clear LV 2 Pack Fast: 10 minutes Pro Air Clear LV 2 Pack Slow: 10 minutes	Dry to Handle Pro Air Clear LV 2 Pack Fast: 30 minutes Pro Air Clear LV 2 Pack Slow: 40 minutes
		
Recoatable With	<ul style="list-style-type: none"> • Infrared drying is <u>not</u> recommended • Recoatable with itself within 24 hours without sanding. 	
		

Read complete TDS for detailed product information

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PRODUCT AND ADDITIVES

Product	Pro Air Clear LV 2PK (Fast)	Item #516534
	Pro Air Clear LV 2PK (Slow)	Item #516533

Hardeners Pro Air Clear LV 2PK Hardener: Item #516522
General purpose hardener for all repair sizes.

Additives	EZ Matte	Item #510528
	Please reference the Lesonal EZ Matte TDS for mixing recommendations.	
	LV250 Accelerator	Item #389353

Add ¼ -½ ounce per RTS liter

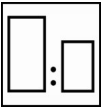
METHOD OF USE

Suitable substrates

- Lesonal WB Basecoat
- Lesonal SB Basecoat
- Existing finishes that have been sanded and scuffed (grey pad)

Basic Raw Materials

Pro Air Clear LV 2PK Fast: acrylic polyol
Pro Air Clear LV 2PK Slow: acrylic polyol
Pro Air Clear LV 2PK Hardener: polyisocyanate resins

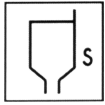
Mixing – General		<u>Standard Ratio:</u>
	2	Pro Air Clear LV 2PK Fast or Slow to accommodate spraying conditions
	1	Pro Air Clear LV 2PK Hardener
		<u>Accelerated Ratio:</u>
STICK #4	2	Pro Air Clear LV 2PK Fast or Slow to accommodate spraying conditions
	1	Pro Air Clear LV 2PK Hardener
	¼-½ oz	LV250 Accelerator

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Mixing – Flexible Parts On plastic parts, no flex agent is required due to built-in flexibility package

Viscosity When Mixed **14-16 seconds** Measured with a DIN #4 viscosity cup at 70°F (21°C).



DIN #4

Pot-life when Mixed 	Product Mix	70°F (21°C)
	ProAir Clear LV 2 Pack Fast Clear	1 hour
	ProAir Clear LV 2 Pack Fast / Slow Clear 50/50	1.5 hours
	ProAir Clear LV 2 Pack Slow Clear	2 hours

Spray Gun Set-Up



Consult spray gun manufacturer instructions for spray gun pressure specifications.

Spray Gun	Fluid Tip	Application Pressure
HVLP Gravity Fed	1.3-1.5 mm	8-10 psi (<0.6-0.7 bar) at the cap
Compliant Gravity Fed	1.3-1.5 mm	8-10 psi (<0.6-0.7 bar) at the cap

Application



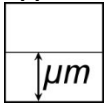
Apply 2 single flowing coats.

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.

If heavy sanding and buffing is required, a third coat may be applied after the stated flash off time.

Film Thickness – Using Suitable Application 1 Coat will achieve a thickness of 1.2-1.5 mils

Application



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DRYING / CURING TIME

Drying / Curing Time



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

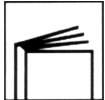
Clearcoat Mixtures	70°F (21°C) Metal Temp		120°F (49°C) Metal Temp	
	Dust Free	Dry	Dust Free	Dry
Fast Clear	15-20 min	60-80 min	5-10 min	20-30 min
Slow Clear	15-20 min	80-110 min	5-10 min	30-40 min
75 / 25 ratio of Fast / Slow Clear	15-20 min	70-90 min	5-10 min	25-35 min
50 / 50 ratio of Fast / Slow Clear	15-20 min	75-95 min	5-10 min	25-35 min
25 / 75 ratio of Fast / Slow Clear	15-20 min	60-90 min	5-10 min	30-40 min

Drying times – Accelerated Mixtures at ½ oz per RTS liter

Clearcoat Mixtures	70°F (21°C) Metal Temp		120°F (49°C) Metal Temp	
	Dust Free	Dry	Dust Free	Dry
Fast Clear Accelerated	15 min	40-60 min	5 min	10-15 min
Slow Clear Accelerated	15 min	60-80 min	5 min	15-20 min
75 / 25 ratio of Fast / Slow Clear Accelerated	15 min	45-55 min	5 min	10-15 min
50 / 50 ratio of Fast / Slow Clear Accelerated	15 min	45-55 min	5 min	10-15 min
25 / 75 ratio of Fast / Slow Clear Accelerated	15 min	50-60 min	5 min	10-15 min

POST-APPLICATION

Recoating



Recoat with itself after full drying cycle. Sanding becomes necessary if there are defects or after 24 hours.

Polishing



Dust and minor damage can be polished out after the stated air-dry times or a full bake at 120°F (49°C) have been reached. Carefully sand out dust particles with #10 micron (#1500) grit paper wet, and then polish the area manually or mechanically.

Note: When heavy color sanding and buffing is required, it may be necessary to apply one extra coat of Pro Air Clear LV 2PK.

Decals

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

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Lettering Hand 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.



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 at 1 mil film thickness and 100% transfer efficiency 650-700 sq. ft / gallon or 16-17 m²/liter

VOC / Regulatory Information

Ready to Spray VOC (2:1)

When mixed ready to spray

Pro Air Clear LV 2PK yields a VOC content of: 2.0 lb/gal 237 g/liter



Notice: Do not handle until the Material 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 (20°C).



ProAir Clear LV 2 Pack Clear Fast / Slow 1 year
ProAir Clear LV 2 Pack Hardener 6 months

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AkzoNobel Inc., North America

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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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