

# Basecoat SB MM 120



Technical Data Sheet



August 2006

INL 5.1.04

**Description** One component, mixing machine based, basecoat system. Available in a wide variety of colours including metallics, pearls and solids. Based on the latest refinish technology and providing easy application and an excellent colour match. Designed for the refinishing of passenger cars, but also suitable for refinishing of light commercial vehicles. Full range of ancillary products that enable the product to be used successfully on a wide variety of jobs, in most types of application.

	<p>INL 5.1.04</p>	<p>2:1 Basecoat SB Multi Thinner 810 (any)</p>	<p>D</p>	<p>1.3 – 1.5 mm 3 - 4 bar</p>	<p>2x1</p>
<p>Between layers: 5 - 10 mins Before Clearcoat: 15 - 20 mins 20°C max 48 hrs 20°C</p>	<p>Clearcoat 210/230/260</p>				

## Product & ancillary items

**Product** Lesonal Basecoat SB 120 – Mixed to formulae (by weight) using Lesonal Basecoat SB 120 MM toners.

### Thinners

- Lesonal Multi Thinner Fast 810-B For faster flash off times on smaller repairs, or in cooler or less well ventilated conditions.
- Lesonal Multi Thinner 810-C For use on larger repairs, or in warmer conditions.
- Lesonal Multi Thinner HT 810-CC For use on large repairs in warm conditions (>30°C).

**Chemical Basis** Basecoat SB 120 – Physical drying binders  
Multi Thinner 810 (any) – A blend of organic solvents

### Method of use

<b>Substrates</b>	Original finishes, with the exception of thermoplastic acrylic. Lesonal Fast Dry Primer 410 2K Primer 480 EP Primer 440
<b>Substrate preparation:</b>	Prior to any sanding work, thoroughly clean the surface of with Akzo Nobel Wax and Grease Remover. Apply using two clean cloths in a wipe on, wipe off process.  Sand with P1000 wet or P400-P500 dry.  After sanding work is completed, and just prior to the application of Basecoat SB 120,

# Basecoat SB MM 120



Technical Data Sheet



August 2006

INL 5.1.04

degrease again thoroughly with Akzo Nobel Wax and Grease Remover.

**Mixing Ratio:**  
(Use mixing stick D for this purpose)

2 volumes – Basecoat SB 120  
1 volumes – Multi Thinner 810 (any)

Mix in a parallel-sided mixing vessel, and stir well before use.

**Spraying Viscosity:**

14-16 secs DIN Cup 4 at 20°C

**Theoretical usage per m2**

12-14 m2 per liter for one single coat. The practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances.

**Pot Life:**

After mixing the product must be used within 24 hrs at 20°C. After extended or long storage paint requires thorough stirring and mixing before use.

**Application Equipment & Spraying Pressure**

Spraygun	Fluid opening	Spraying pressure
Gravity Feed	1.3 - 1.5 mm	3 -4 bar at air inlet
HVLP Gravity	1.3 - 1.5 mm	0.7 bar at air cap
LVLP (HR) Gravity	1.3 - 1.5 mm	2-3 bar at air inlet

**Application Technique:**

Apply two coats; allow to become touch dry between each coat. In general this will take 3-6 minutes at 20°C. However this time can be greatly influenced by the conditions at the time of application. For some metallic colours it is necessary to apply a third mist coat at a spraying pressure of 2 bar. Solid colours can be applied in two to three normal coats until coverage.  
After a flash off time of 15-20 minutes Basecoat SB 120 can be recoated with Lesonal clearcoats.

**Equipment Cleaning:**

Use Lesonal Multi Thinner 810 (any) or Lesonal NC Thinner 820.

**Spot repairs / Fade out areas:**  
**Preparation -**

First degrease thoroughly with Akzo Nobel Wax and Grease Remover. Abrade the area to be repaired with grey scuff pad (grey) and then degrease again before basecoat application.

**Application -**

Apply Basecoat SB in thin coats at a spraying pressure of 1.5 – 2 bar until opacity is achieved. Allow flash off until matt between coats, then fade out twice into remaining area (only metallic colours), again using a spraying pressure of 1.5 – 2 bar.

**Helpful Tips:**

After 20 minutes at 20°C Lesonal Basecoat SB may be masked upon and a second colour can be applied.

If Lesonal Basecoat SB is to be left longer than 24 hours (5 hours for solid colours), before applying a Lesonal clearcoat, 10% of Lesonal Hardener (720) should be added into the basecoat.

# Basecoat SB MM 120

**LESONAL**

Technical Data Sheet



August 2006

INL 5.1.04

If there is a risk of cratering due to the presence of contamination, it is advisable to apply the basecoat in thin layers only, and to extend the normal flash off time between each coat.

New cans of toners should be placed 20 minutes on the mixing machine or 10 minutes in the paint shaker before use.

NOTE: As an option when fading out or applying in cold/poor airflow environments, an additional 10% of Lesonal Multi Thinner 810 maybe added in to Lesonal Basecoat SB 120. This will make the application easier and faster flash off time.

**Denib:** Dust particles can be denibbed with P1000 grit wet paper after 20 minutes at 20°C. Then proceed with the application of Lesonal Basecoat SB 120.

<b>Shelflife</b>	Solid and metallic toners	– 48 months
	Pearl toners	– 24 months
	Toner 120-23	– 24 months

**Health & Safety Data:** These products are intended for professional use only. Please refer to can labels and Safety Data Sheets concerned for more specific information. The user of these products is required to comply with the national laws pertaining to Health & Safety disposal. *The above information is given in good faith, but without warranty, as the final results are also dependent upon factors of use which are outside our control.*