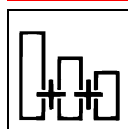
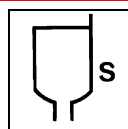


LS105 (29105) HI-BUILD FILLER



1000 ml +
200 ml +
200-250 ml

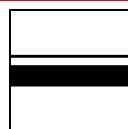
Pot-life at 20° C:
1,5-3 hours



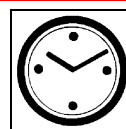
20-25" DIN 4
at 20° C



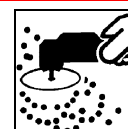
Ø 1.4-1.9 mm
4 Atm
HVLP:
Ø 1.4-1.8 mm
2-2,5 Atm
N° coats: 2-3



60-80 µ
180-200 µ



Air drying at 20° C
Handling: 1-2 h
Sanding after: 2-4 h
Low bake at 60°C:
20-30 min.



P 240-280 +
P360-400

DESCRIPTION

Two-pack polyacrylic HS filler with high filling properties.

USE

Suitable for all paintworks in industrial Truck Refinish and Industry as a filling/sealer in dry-on-dry system (with sanding).

CHARACTERISTICS

- Very good filling power
- Fast drying
- Easy dry sanding
- High solid content
- Easy application
- Very good coverage

SUBSTRATE PREPARATION

Knifing polyester putties: 04469 POLYDUR CART WHITE, 05323 MULTIGRIP SPACHTELMASSE, after drying and sanding with P120-150 and degreasing with 00695 SILICONE REMOVER SLOW.

Anticorrosive Wash Primers: 1K FAST PRIMER, after 30 min. at 20°C without sanding.

Epoxy primers: EPOXY PRIMER, EPOFAN PRIMER R-EC, ACRIPUR PRIMER, after flash-off or after sanding.

Old thermohardening coatings or fibreglass: after dry sanding with P180-240 and degreasing with 00695 SILICONE REMOVER SLOW. On solvent sensitive films it is recommended to make a preliminary test in order to avoid the risk of lifting.

Cataphoresis: after dry sanding with P320 grit paper and degreasing with 00695 SILICONE REMOVER SLOW.

APPLICATION

Spraying.

Mixing ratio:

	weight	volume
LS105 HI-BUILD FILLER (derived from binder 29105)	1000 g	1000 ml
29355-29356 (Fast) LECHSYS ACRITOP HARDENER	130 g	200 ml
00824(Slow)-00825 (Standard) LECHSYS UNIVERSAL THINNER	150-200 g	200-250 ml

Pot-life at 20 °C: 1,5 h (29356), 3 h (29355)

Spray viscosity at 20 °C: 20 - 25" DIN 4

Ø Air cap: conventional 1.4-1.9 mm; HVLP 1.4 – 1.8 mm
Pressure: conventional 4 Atm; HVLP 2 - 2,5 Atm
N° coats: 2-3
Suggested thickness: 60-80 µ (sealer) o 180-200 µ (filling)
Theoretical coverage: 1 l of mixture = 4,2-4,5 m² at 100 µ
1 kg of mixture = 3-3,3 m² at 100 µ

DIR 2004/42/CE: Primer IIB/c – VOC ready for use 540 g/l
This product ready for use contains at most 515 g/l VOC

DRYING

Use in dry-on-dry system:

Air drying at 20 °C

Dust-free: 10-15 min.

Tack-free, handling: 1-2 hours

Sanding: after 4 hours (2 hours with 29356)

Through-drying: 24 hours

Low bake at 60°C

20-30 min.

SANDING

Dry: with P280-320 paper

Wet: with P400 paper

OVERCOAT WITH

· Topcoats of the LECHSYS range: ISOLACK – ACRITOP – BASECOAT – LECHSYS EFFECT
BASECOATS

NOTES

This product is chromate- and lead-free. It is recommended to avoid adding the base colours 29011, 29012 and 29026 in the formulations, as they contain lead and would make the final product lose its non-toxic characteristics.

Search the formulation to produce under “SOTT” on the Data Box and choose the colour in the respective colour fan.

TECHNICAL DATA SHEET N° 0484-GB
UPDATED 11/2008

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