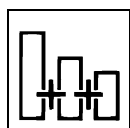
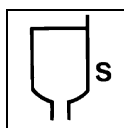


LS204 (29204) IS FILLER HBF



1000 ml +
250 ml +
150-200 ml

Pot life at 20°C:
from 30' to 4 h



20-25° DIN 4
at 20° C



Ø 1,5-1,7 mm
2-2.5 Atm

N° of coats: 2-3



Sealer: 60-90 µ
High build filler:
120-180 µ



Sanding after:
3-8 h at 20° C
or
15-30 min. at 60° C

DESCRIPTION

Two-pack HS polyacrylic filler with high build.

USE

Sealer - filler for all truck refinishing and industry, for dry-on-dry process.

CHARACTERISTICS

- Fast drying
- Very good sanding
- Very good filling power
- Good sealing power
- Low absorption of the topcoat
- High solid content

SUBSTRATE PREPARATION

Knifing polyester putties:

Sand with P120-180-240 dry grit paper then degrease with 00695 SILICONE REMOVER SLOW.

Steel, galvanised or zinc coated steel, aluminium:

Apply 1-2 coats of 1K FAST PRIMER.

Old coatings, new surfaces treated with cataphoresis, PRFG:

Sand and degrease with 00695 SILICONE REMOVER SLOW. The application on solvent-sensitive films is not recommended.

APPLICATION

Spray application.

Mixing ratio:

LS204 IS FILLER HBF (derived from binder 29204)

29355-29356 (Fast)-29357 (Slow) LECHSYS ACRITOP HARDENERS

00824 (Slow) -00825 (Standard) LECHSYS UNIVERSAL THINNERS

volume	weight
1000 ml	1000 g
250 ml	160 g
150-200 ml	100-200 g

	29355	29357	29356
USE	T: 15-30°C	T: >30°C	T: 5-20°C
Pot-life at 20 °C	4 h	4 h	30 min.

Spray viscosity at 20 °C: 20÷25" DIN 4
Air cap Ø: 1,5÷1,7 mm
Air pressure: 2÷2,5 Atm (at the gun's butt)
Number of coats: high build filler 2-3 coats ; sealer 2 coats
Interval between the coats: 5÷8 min.
Suggested film thickness: high build primer 120-180 µ; sealer 60÷90 µ;
Coverage (theoretic value): 1 kg mixture = 5,9 m² at 50 µ; 1 l mixture = 7,5 m² at 50 µ

DIR 2004/42/CE: Primer IIB/c – VOC ready for use 540 g/l
This product ready for use contains at most 490 g/l VOC

DRYING TIME

	29355		29357		29356	
Air drying at 20°C (Object temperature):	Sealer	Filler	Sealer	Filler	Sealer	Filler
Tack-free	40 min.		40 min.		20 min.	Not
Sanding after	6 h	8 h	6 h	8 h	3 h	recommended
Low bake at 60 °C (Object temperature):						
Sanding after	30 min.		30 min.		15 min.	

SANDING

One-coat finishes:

Dry sanding with P320 (sanding machine)
Wet sanding with P500

Two-coat finishes:

Dry sanding with P400 (sanding machine)
Wet sanding with P600-800

OVERCOATINGS

- LECHSYS polyurethane enamels like ISOLACK and polyacrylic enamels like ACRITOP, LS190 (29190) BASECOAT, MATT BASECOAT of LECHSYS EFFECT system.

NOTES

The product is chrome- and lead-free. By the formulations try not to add the base colours 29011, 29012 and 29026 in order to maintain the chrome- and lead-free characteristics of the final product.
The formulations of the coloured undercoats are listed under "SOTT" on the Data Box.
Choose the colour in the relevant colour-card.

TECHNICAL DATA SHEET N°581-GB
UPDATED 12/2013

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