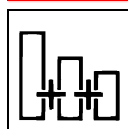
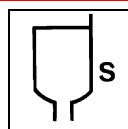


# LS105 (29105) HI-BUILD FILLER



1000 ml +  
200 ml +  
200-250 ml

Pot-life at 20° C:  
1,5-3 hours



20-25" DIN 4  
at 20° C



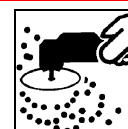
Ø 1.4-1.9 mm  
4 Atm  
HVLP:  
Ø 1.4-1.8 mm  
2-2,5 Atm  
N° coats: 2-3



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 SPACHELMASSE, 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 m<sup>2</sup> at 100 µ  
1 kg of mixture = 3-3,3 m<sup>2</sup> 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**

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## **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.

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## **SANDING**

**Dry:** with P280-320 paper

**Wet:** with P400 paper

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## **OVERCOAT WITH**

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

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## **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 "SOTTOTINTE-UNDERCOATS on the LECHLER EXPLORER / MAP and choose the colour in the respective colour fan.

**TECHNICAL DATA SHEET N° 0484-GB**  
**UPDATED 04/2016**

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