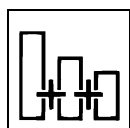
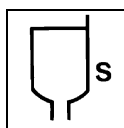


LS204 (29204) IS FILLER HBF

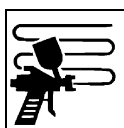


1000 ml +
250 ml +
150-200 ml

Pot life at 20°C:
from 30 min. to 3,5 h ca.



20-25" FC 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 refinish and industry paint works in 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 cathodic coated surfaces, PRFG:

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

APPLICATION

By spray.

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
Pot life at 20 °C	ca. 2 h	ca. 3,5 h	ca. 30 min.

Spray viscosity at 20 °C: 20÷25" FORD Cup 4
Ø Air cap: 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.
Recommended film thickness: high build filler 120-180 µ; sealer 60÷90 µ;
Theoretical coverage: 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	8 h	10 h	3 h	recommended
Low bake at 60 °C (Object temperature):						
Sanding after	30 min.		45 min.		15 min.	

SANDING

One-coat finishes:

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

Two-coat finishes:

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

OVERCOAT WITH

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

NOTES

The product is chrome-free. When creating formulations DO NOT add the tinters 29011, 29012 and 29026 in order to maintain the chrome-free characteristics of the final product.
Search the formulation to produce under "SOTTOTINTE-UNDERCOATS on the Lechler MAP® or Explorer® and choose the colour in the respective colour fan.

TECHNICAL DATA SHEET N° 0581-GB
UPDATED 06/2017

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