

2K Topcoat MM 320

Topcoat

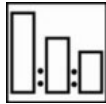
14/11/2019

L5.01.03 APAC

DESCRIPTION

2K Topcoat MM 320 is a two component, mixing machine based, acrylic topcoat. Available in a wide variety of direct gloss/solid colors, including both RAL and British Standard colors. Specifically designed for the refinishing of passenger cars, light commercial vehicles, and industrial machinery. For both new work and repairs.

Mixing ratio



2 2K Topcoat MM 320
 1 2K Hardener 720 or 728 (any)
 +10% Multi Thinner 810 (any)

Equipment



Spray gun set-up:
 1.2-1.5 mm

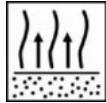
Application pressure:
 1.7-2.2 bar at the air inlet
 HVLP max 0.7 bar at the air cap

Application



2 x 1 coat
 Apply three coats, allow to become touch dry between each coat.

Flash-off



Between coats
 5-10 minutes at 20°C

Drying times



	20°C	60°C
With 2K Hardener 720	9 hours	50 minutes
With 2K Hardener 728 B	2 hours	60 minutes
With 2K Hardener 728 C	10 hours	2-3 hours
With 2k Hardener 728 CC	12 hours	4 hours

Protection



Use suitable respiratory protection
 Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator

Read complete TDS for detailed product information

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PRODUCT AND ADDITIVES

Product	2K Topcoat MM 320	
	Hardener	Lesonal 2K Hardener 720 or 728 (any)
	Thinner	Lesonal Multi Thinner (any)

Basic raw materials	Lesonal 2K Topcoat MM 320; Acrylic Resins Lesonal 2K 720 (any); Polyisocyanate resins Lesonal Multi Thinner 810 (any); A blend of organic solvents
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METHOD OF USE

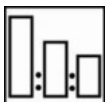
Suitable substrates	Original finishes, polyester laminates Lesonal 2K Primer 480 Lesonal 2K Primer 488 Lesonal 2K Filler 540 Grey Lesonal EP Primer Grey 440
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Substrate preparation Prior to commencing any sanding work, thoroughly cleanse the surface of any grease or wax with Lesonal Degreaser 910. Apply using two clean clothes in a wipe-on, wipe-off process.

Sand with P800 – P1000 wet or Sand with P400 – P500 dry.

After sanding work is completed, and just prior to the application of 2K Topcoat 320, degrease again thoroughly with Lesonal Degreaser 910.

Mixing	2	2K Topcoat MM 320
	1	2K Hardener 720 / 728 (any)
	+10%	Multi Thinner 810 (any)



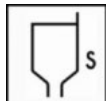
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Viscosity 15-16 sec DIN cup 4 at 20°C.



Spray gun set-up / application pressure	Spray gun	Fluid tip-set-up	Application pressure
	Gravity feed	1.2-1.5 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.7 bar at the air cap

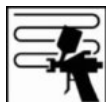


APPLICATION TECHNIQUE

Application process & blending Apply 2 coats. Allow to become touch dry between each coat, generally this will take around 5-10 minutes flash off time between coats.

Lettering:

To be applied within 48 hours. After 48 hours, scuff with a grey scuffing pad.



Pot-life 2K Topcoat MM 320

2K Hardener 720	4 hours at 20°C
2K hardener 728 B	30 minutes at 25°C
2K hardener 728 C	1½ hours at 25°C

Drying times



	2K Hardener 720	2K Hardener 728 B	2K Hardener 728 C	2K Hardener 728 CC
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20°C	Dust dry	30 mins	20-25 mins	50-60 mins	70-90 mins
	Dry to handle	4 hrs	60-70 mins	5-6 hrs	> 6 hrs
	Hard dry	9 hrs	2 hrs	10 hrs	> 12 hrs
60°C	Dust dry	5 mins	< 10 mins	30-35 mins	40-55 mins
	Dry to handle	25 mins	30-40 mins	60-70 mins	2 hrs
	Hard dry	50 mins	50-60 mins	2-3 hrs	4 hrs

Cleaning of equipment Use Lesonal Multi Thinner 810 (any)

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Helpful tips

Application on thermoplastic acrylic finishes:

These types of finishes can be very sensitive to attack from solvents in the paint that you are applying. This can result in poor gloss and in extreme cases, contour mapping, and/or sanding scratch swelling. When applying Lesonal 2K Topcoat 320, the following could be done to avoid problems:

- 1) Extend the flash off time between coats.
- 2) Don't apply excessively heavy or double coats.

Similar attention should be paid when applying primers or surfacers.

VOC

The theoretical VOC is 599 g/ltr to spray mixture.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.
Product shelf life data see TDS S9.02.01

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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