

# 1021 HG Clearcoat 211-B / C / CC

Clearcoat

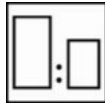
01/08/2019

L5.03.02 APAC

## DESCRIPTION

Lesonal 1021 HG Clearcoat 211-B / C / CC is a fast drying 2 component clearcoat system with the mixing ratio of 10:1. Provide outstanding solvent resistance and excellent polishability in 2 layers. Suitable for use in wide range of repairs. With fast flash off time improves productivity and high quality results at an economical price.

### Mixing ratio



10 Lesonal 1021 HG Clearcoat 211 (any)  
1 Lesonal 1021 HG Hardener 711

### Equipment



Spray gun set-up:  
1.3-1.5 mm

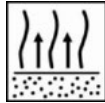
Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.7 bar at the air cap

### Application



2 x 1 coat  
Apply two coats, allowing the first coat to become touch dry prior to the application of the second coat.

### Flash-off



Between coats  
3-5 minutes at 20°C

### 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

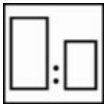
**Product** Lesonal 1021 HG Clearcoat Fast 211-B  
 Lesonal 1021 HG Clearcoat Medium 211-C  
 Lesonal 1021 HG Clearcoat Slow 211-CC  
 Hardener Lesonal 1021 HG Hardener 711

**Basic raw materials** Lesonal 1021 HG Clearcoat 211 (any) ; Acrylic Resins  
 Lesonal 1021 HG Hardener 711 ; Polyisocyanate Resins

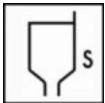
## METHOD OF USE

**Suitable substrates** Lesonal Basecoat SB MM 120

**Mixing** 10 Lesonal 1021 HG Clearcoat 211 (any)  
 1 Lesonal 1021 HG Hardener 711  
 Mix in a parallel-sided container and stir well before use.



**Viscosity** 1021 HG Clearcoat Fast 211-B / CC ; 13-14 sec. DIN Cup 4 at 20°C  
 1021 HG Clearcoat Slow 211-CC ; 13-14 sec. DIN Cup 4 at 30°C



**Spray gun set-up / application pressure** Spray gun Gravity feed Fluid tip-set-up 1.3-1.5 mm Application pressure 1.7-2.2 bar at the spray gun air inlet HVLP max 0.7 bar at the air cap



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## APPLICATION TECHNIQUE

**Application process & blending** Apply two coats, allowing the first coat to become touch dry prior to the application of the second coat. Generally this will take between 3-5 minutes.



<b>Pot-life</b>	1021 HG Clearcoat Fast 211-B / CC	4 hours	at 20°C
	1021 HG Clearcoat Medium 211-CC	4 hours	at 30°C

### Drying times



	1021 HG Clearcoat Fast 211-B	1021 HG Clearcoat Medium 211-C	1021 HG Clearcoat Slow 211-CC
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20°C	Dust dry	5 mins	8 mins	15 mins
	Dry to handle	2 hrs	2 hrs	2 hrs 30 mins

30°C	Dust dry	4 mins	6 mins	10 mins
	Dry to handle	1 hr 30 mins	2 hrs	2 hrs

60°C	Dust dry	3 mins	5 mins	6 mins
	Dry to handle	15 mins	20 mins	25 mins

**Cleaning of equipment** Use Lesonal Multi Thinner 810.

**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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**Akzo Nobel Car Refinishes (Singapore) Pte Ltd****Address: 3 Changi Business Park Vista, #05-01 Akzo Nobel House, Singapore 486051****Tel: +65 6635 5262****FOR PROFESSIONAL USE ONLY**

**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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