

2K Topcoat MM 320

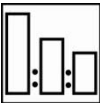





Topcoat

19/08/2020

L5.01.03 AUS

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 1 +10%	2K Topcoat MM 320 2K Hardener 720 or 728 (any) Multi Thinner 810 (any)														
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		2-3 x 1 coat Apply Two to three coats, depending on color opacity and spray gun set-up Allow to become touch dry between each coat.															
Flash-off		Between coats 5-10 minutes at 20°C															
Drying times		<table border="1"> <thead> <tr> <th></th> <th>20°C</th> <th>60°C</th> </tr> </thead> <tbody> <tr> <td>With 2K Hardener 720</td> <td>9 hours</td> <td>50 minutes</td> </tr> <tr> <td>With 2K Hardener 728 B</td> <td>3-4 hours</td> <td>20 minutes</td> </tr> <tr> <td>With 2K Hardener 728 C</td> <td>7-8 hours</td> <td>45 minutes</td> </tr> <tr> <td>With 2k Hardener 728 CC</td> <td>N/A</td> <td>60 minutes</td> </tr> </tbody> </table>		20°C	60°C	With 2K Hardener 720	9 hours	50 minutes	With 2K Hardener 728 B	3-4 hours	20 minutes	With 2K Hardener 728 C	7-8 hours	45 minutes	With 2k Hardener 728 CC	N/A	60 minutes
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With 2K Hardener 728 C	7-8 hours	45 minutes															
With 2k Hardener 728 CC	N/A	60 minutes															
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

2K Topcoat MM320

Hardener Lesonal 2K Hardener 728 B; spot and small panel repairs at 15°C- 25°C
 Lesonal 2K Hardener 728 C; spot and panel repairs at 20°C- 30°C
 Lesonal 2K Hardener 728 CC; larger areas and overall refinishing at 20°C- 40°C

Thinner Lesonal Multi Thinner Fast 810-B; spot and small panel repairs between 15°C- 25°C
 Lesonal Multi Thinner 810-C; spot and panel repairs and large areas between 20°C- 30°C
 Lesonal Multi Thinner HT 810-CC; small to larger areas and complete resprays between 25°C- 40°C

Tips:

The above suggestions are a guide, so always take into consideration, temperature and size of job when using Lesonal 2K 728 Hardeners and Multi Thinner 810 combinations.

Basic raw materials Lesonal 2K Topcoat MM 320; Acrylic Resins
 Lesonal 2K 720/728 (any); Polyisocyanate resins
 Lesonal Multi Thinner 810 (any); A blend of organic solvents

METHOD OF USE

Suitable substrates Original finishes, polyester laminates
 Lesonal 2K Primer 480 Lesonal 2K Filler 540 Grey
 Lesonal 2K Primer 488 Lesonal EP Primer Grey 440

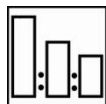
Substrate preparation Prior to commencing any sanding work, thoroughly cleanse the surface of any grease or wax with AkzoNobel Wax and Grease Remover.

- 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 AkzoNobel Wax and Grease Remover

Mixing

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



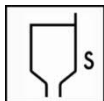
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Viscosity 15-16 sec DIN cup 4 at 20°C.

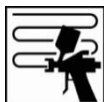


Spray gun set-up / application pressure	Spray gun Gravity feed	Fluid tip-set-up 1.3-1.5 mm	Application pressure 1.7-2.2 bar at the spray gun air inlet HVLP max 0.7 bar at the air cap
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APPLICATION TECHNIQUE

Application process & blending Apply 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 mins	30 mins	N/A
	Dry to handle	4 hrs	60 mins	3.5 hrs	N/A
	Hard dry	9 hrs	3-4 hrs	7-8 hrs	N/A
60°C	Dust dry	5 mins	5 mins	5-10 mins	10-15 mins
	Dry to handle	25 mins	10-15 mins	20-25 mins	35-45 mins
	Hard dry	50 mins	20 mins	45 mins	60 mins

Note : Allow for warm-up time before baking.

Cleaning of equipment Use Lesonal Multi Thinner 810 (any)

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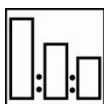
Product & ancillary items Lesonal Tinter 01 can be used in Lesonal 2K Topcoat MM 320. When added to these products, it is possible to duplicate the matt appearance found on plastic car parts such as bumpers.

For use in Lesonal 2K Topcoat MM 320

Note: Do Not use in clearcoats

Matting 2K Topcoat	Mix by volume:	2K Topcoat MM 320	Tinter 01
	Semi-matt	100 parts	50 parts
	Matt	100 Parts	100 parts

Mixing ratio



2 2K Topcoat MM 320 / Tinter 01
 1 2K Hardener 720 / 728 (any)
 +10% Multi Thinner 810 (any)
 Stir well before use.

Drying times



2K Topcoat MM 320 /Tinter 01	20°C	60°C
With 2K Hardener 720	12 hours	50 minutes
With 2K Hardener 728 C	10 hours	70 minutes

Textured finishes



Always use a gravity feed spray gun for this kind of application!

- Apply 2-3 coats (depending on the color opacity) at normal application distance and air pressure. Allow for a minimum of 15 minutes flash-off time at 20°C after the last coat.
- The textured finish may be obtained by reducing the application pressure to approximately 0,5-1 bar and enlarging of the application distance.
 The lower the application pressure, the coarser the texture on the surface.

Various textures can be achieved by variations in:

- Higher or lower application pressure
- Larger or closer distance between spray gun and object
- Larger or narrower spray gun opening

Higher or lower paint mixture viscosity (by adding reducer or thinner)

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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.
Recommended film thickness 50-60 µm

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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