

# 2K Topcoat MM 320

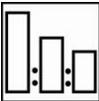
Topcoat

15/11/2019

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"> <tr> <td></td> <td>20°C</td> <td>60°C</td> </tr> <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> </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

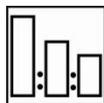
**Substrate preparation** Prior to commencing any sanding work, thoroughly cleanse the surface of any grease or wax with AkzoNobel Wax and Grease Remover.

- 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)



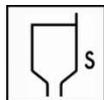
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Viscosity 15-16 sec DIN cup 4 at 20°C.



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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Helpful tips	<p>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:</p> <ol style="list-style-type: none"> <li>1) Extend the flash off time between coats.</li> <li>2) Don't apply excessively heavy or double coats.</li> </ol> <p>Similar attention should be paid when applying primers or surfacers.            Recommended film thickness 50-60 µm</p>
VOC	The theoretical VOC is 599 g/ltr to spray mixture.
Product storage	<p>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</p>

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#### FOR PROFESSIONAL USE ONLY

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