

421-72XX Plastofix® Light Post-Cat Clear Topcoat

Product codes:	421-7215 15° Matte	Viscosity	Zahn #2 signature cup 55 sec at 25°C
	421-7225 25° Low Gloss	Flash Point:	15°C (59°F)
	421-7235 35° Satin	Density (kg/l):	1.00
	421-7250 50° Semi-Gloss	Solid (% by weight):	54%
	421-7290 90° High Gloss	Solid (% by volume):	46%
		Shelf Life (months):	12

Product Description:

Plastofix Light is a light stable, fast drying Reactive Amino Coating. It gives a smooth, knock proof and hard wearing surface resisting influence from alcohol, water, etc. meant for interior use. Plastofix Light has improved light stability versus our standard Plastofix.

Uses:

Plastofix is an all round coating equally suited for application with roller and curtain coating as well as conventional spraying equipment.

Environmental Data (as supplied):

VOC less exempt lb/gal:	<3.90
VOC lb/gal:	<3.90
VOC less exempt g/l:	
VOC g/l:	
VOC lb/lb Solid:	<0.75
VHAPs lb/lb Solid:	<0.30

Note:

See individual compliance sheets for specific data

Application Data

Suggested Uses:	Spray
Mixing Ratio:	10:1 with 999-017 by volume
Suggested Uses:	8 hours
Application Viscosity:	Zahn #2 signature cup 20-25 seconds
Reducer:	121-8020 or 121-803
Retarder:	800-5328
Clean-up Solvent:	Lacquer Thinner
Recommended Wet Film:	3-5 wet mils
Coverage:	17-18 m ² /l at 1 mil dry and at 100% efficiency. Coverage will vary depending on method of application or coating thickness.

Note:

N/A

Directions for use:

Surface Preparation:

Substrate must be sanded using 120 or 150 grit stearated paper prior to staining or coating. Sealers, if used, should be sanded prior to being coated with 240, 280 or 320 grit stearated paper. Sealers should be topcoated within eight hours of being sanded. Plastofix cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable.

General Information:

Catalyze and reduce the material as recommended. Plastofix is applied in one to three coats on all kinds of wood meant for indoor use. On open pored woods, the best self sealing is obtained by adding a minimum of 50 percent thinner to the Plastofix after catalyzing. Thorough sanding between the coats is a must for good adhesion. The second coat must be applied within 8 hours of the board being sanded. Contact with metal surfaces should be avoided once the Plastofix has been catalyzed. To ensure proper sheen, the catalyzed material should be agitated at all times. Plastofix must be thoroughly stirred while adding hardener and thinner in the recommended mixing ratio. Total recommended film build of Plastofix and sealer should not exceed 4 mils dry. To obtain a complete cure, the system should be applied at an ambient temperature above 18°C and a relative humidity below 65%. When drying, this product is not to be exposed to ammonia vapors. Finished surfaces must not be cleaned with ammonia containing products. 421-72XX can be used as a self seal or with following sealers: 390-001, 390-0060, 401-004 catalyzed, 401-028 catalyzed, 431-1219, 432-1220, 546-5192 and 546-8003.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION

Drying Times:	Room Temperature (20°C / 68°F)	Forced Drying Schedule (50°C / 122°F)
Tack Free Time:	20 minutes	Flash off before entering oven
Dry to Sand:	6 hours	Overnight
Dry to Stack:	2 hours	3 hours

Note:
N/A

Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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