Chemcraft
A Great Finish is Only the Beginning

AkzoNobel

421-55XX Plastofix® Light RTS Conversion Varnish Clear Topcoat

Product codes:	421-5515 15º Matte 421-5525 25º Low Gloss 421-5535 35º Satin 421-5550 50º Semi-Gloss 421-5590 90º High Gloss	**Viscosity**	Zahn #2 signature cup 19 sec at 25°C
		Flash Point:	4°C
		Density (kg/l):	0.97 ± 2% at 25°C
		Solid (% by weight):	43%
		Solid (% by volume):	35%
		Shelf Life (months):	12

Product Description:
Plastofix Light RTS is an economical, high quality, self-sealed acid curing Reactive Amino Coating (RAC). Plastofix Light RTS is based on low discolouring resins and contains UV absorbers to make this product light stable. The smooth hardwearing surface shows excellent resistance to mechanical damage, dry heat, household and office liquids, etc.

Special recognition: when applied as specified, will meet required performance for the ANSI/KCMA A161.1 1990 9.0 Finish Test.

Uses:

Plastofix Light is recommended for kitchen cabinets, high build office or residential furniture as well as other interior wood applications. Plastofix Light 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:**	<2.2
	VOC lb/gal:	<0.8
	VOC less exempt g/l:	
	VOC g/l:	
	VOC lb/lb Solid:	<0.31
	VHAPs lb/lb Solid:	<0.1

Note:
N/A

Application Data	**Suggested Uses:**	Spray
	Mixing Ratio:	8% with 999-017 by volume
	Suggested Uses:	8 hours
	Application Viscosity:	18-20 sec Zahn #2 at 25°C
	Reducer:	121-8020 or 121-803
	Retarder:	800-5328 EEP
	Clean-up Solvent:	Lacquer Thinner
	Recommended Wet Film:	3-5 wet mils
	Coverage:	14 m^2/l (150 pi^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:
Before application of Plastofix® Light RTS, substrate must be sanded using 120 or 150 grit stearated paper prior to staining or coating. Sealers, if used, should be sanded using #280/320 grid stearated paper and free of dust and all contaminants. Sealers should be topcoated within a maximum of 8 hours of being sanded. Plastofix® Light must not be applied over metal, old oil finish or nitrocellulose lacquers. Stain systems used under Plastofix® Light should be acid stable.

General Information:

Catalyze and reduce material as recommended. To ensure proper sheen, the catalyzed material should be agitated at all times. Apply 3 to 5 wet mils on sanded surface. One or two extra coat can be applied following a complete cure and a sanding with a #280/320 paper. On open pored woods, the best self sealing is obtained by adding a minimum of 50% thinner to the Plastofix after catalyzing. Maximum film build of the system should not exceed 4 mils dry. Plastofix® Light must not be polluted with oil, varnish or the like and must not be sanded with steel wool between coats. Avoid all contact with metallic surfaces.
To obtain complete cure, Plastofix® Light must be applied at a temperature above 18ºC and relative humidity below 65%. When drying, this product should not be exposed to ammonia vapors. Finished surface must not be cleaned with ammonia containing products. Always use containers and equipment made of plastic or stainless steel to avoid discoloration of the material due to oxidation.
421-55XX 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 - 30 minutes	Flash off required prior to oven cure
Dry to Sand:	90 - 120 minutes	12 hours
Dry to Stack:	45 - 60 minutes	2 - 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.

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