Chemcraft®

A Great Finish is Only the Beginning

Plastofix Post-Cat Clear Conversion Varnish 421-55XX

Product Code:	
421-5510	Matte
421-5520	Low Gloss
421-5535	Satin
421-5550	Semi-Gloss
421-5590	Full Gloss

VISCOSITY:	Zahn #2 signature cup 19 sec at 25°C
FLASH POINT:	6°C (43°F)
DENSITY (Kg/L):	0.96
SOLID (% by weight):	43%
SOLID (% by volume):	37%
SHELF LIFE (months):	12

Product Description: Plastofix® is an economical, high quality, acid catalysed sealer/topcoat for interior use on all types of solid wood and veneer meant for interior use. 421-55XX Plastofix 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.

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:	4.56
VOC lb/gal:	4.56
VOC less exempt g/l:	546
VOC g/l:	546
VOC lb/lb Solid:	1.31
VHAPs lb/lb Solid:	0.86

See individual compliance sheets for specific data

Application Data:

SUGGESTED USES:	Clear Conversion Varnish
MIXING RATIO:	8% with 999-017 by volume
POT LIFE:	8 hours
APPLICATION VISCOSITY:	Zahn #2 signature cup 18-20 seconds
REDUCER:	121-802 or 121-803
RETARDER:	100-119 or 100-137
CLEAN-UP SOLVENT:	Lacquer Thinner
APPLIED FILM THICKNESS:	3-5 wet mils

AkzoNobel

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. Appropriate sealers are 401- or 546- vinyl sealers with 3% 999 017 or self seal. 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.

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:

	At 20°C (Minimum Required)	**At 50°C (Minimum Required)**
Tack Free Time:	20 minutes	Flash off before entering oven
Dry to Sand:	6 hours	2 hours
Dry to Stack:	Overnight	3 hours

Note: 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.

AkzoNobel Wood Coatings
155 Rose Glen Rd.
Port Hope, Ontario, L1A 3V6
905-885-6388