

Product Code:

421-4820	Low Gloss
421-4835	Satin Gloss
421-4850	Semi-Gloss
421-4890	Full Gloss

VISCOSITY:	Z #2/27" at 77°F
FLASH POINT:	62°F (17°C)
DENSITY (lb/gal):	8.2
SOLID (% by weight):	50%
SOLID (% by volume):	41%
SHELF LIFE (months):	12

Product Description: Plastofix® Light is a high quality, acid curing Reactive Amino Coating (RAC). This is a fast building product due to its high solid content (41% volume). Depending on the spray equipment being used Plastofix® Light may be ready to spray at 30 seconds viscosity (Zahn #2). Plastofix® Light has very good light stability based on the choice of resin used in the product.

Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards.
Recommended: Architectural Woodwork Institute ((AWI). TR 4

Uses: This product is recommended for kitchen cabinets, high build office or residential furniture as well as other interior wood applications.

Environmental Data (as supplied):

VOC less exempt lb/gal:	<4.20
VOC lb/gal:	<4.20
VOC less exempt g/l:	<500
VOC g/l:	<500
VOC lb/lb Solid:	<1.05
VHAPs lb/lb Solid:	<0.35

Application Data:

SUGGESTED USES:	Wood Finish
MIXING RATIO:	10 parts 421-48XX to 1 part 873-0870
POT LIFE:	12 hours (catalyzed)
APPLICATION VISCOSITY:	Z #2/20 – 22"
REDUCER:	803-1325
RETARDER:	800-5328
CLEAN-UP SOLVENT:	803-1298
RECOMMENDED WET FILM:	3 – 4 mils
COVERAGE:	722 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.



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Surface Preparation: Substrate must be sanded using 120 or 150 grit steared paper prior to staining or coating. Sealers, if used, should be sanded with 240, 280 and 320 grit steared paper prior to being coated. The substrate as well as the sealers should be topcoated within eight hours of being sanded. Plastofix[®] Light cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable. AkzoNobel recommends using 825-80XX C-mix Stains or 890-85XX N.G.R. stains.

General information: Catalyze and reduce the material as recommended. Plastofix[®] Light 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 25% Reducer (803-1325) to the Plastofix[®] Light after catalyzing. Thorough sanding between the coats is a must for good adhesion. The second and subsequent coats must be applied the same day as the previous coat is sanded. Contact with metal surfaces should be avoided once the Plastofix[®] Light has been catalyzed. To ensure proper sheen, the catalyzed material should be agitated at all times.

This product can be used as a self-sealer if reduced 20 – 30%. Appropriate sealers are Catalyzed Vinyl Sealer (546-7003) with 3% Catalyst (873-0870, or Chemvinyl (546-8002), or Danseal (432-1220). Consult with your coatings supplier for specific recommendations.

Plastofix[®] Light demonstrates excellent resistance to marring, dry heat, moisture, household and office liquids, etc. When this product is used as its own sealer, its special formulation ensures excellent filling and easy sanding properties with superior holdout for subsequent coating. Plastofix[®] Light must be thoroughly stirred, while adding catalyst and reducer in the recommended ratio. Total recommended film build of Plastofix[®] Light and sealer 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. Plastofix[®] Light must not be used and dried at temperatures below 64°F or relative humidity above 65%. During the curing process, the coating must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.

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 68°F	At 122°F
Tack Free Time:	15 mins.	Flash off before entering oven
Dry to Sand:	2 hours	45 mins.
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.

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