



Product Information

PRODUCT NAME: PLASTOFIX®

PRODUCT CODE: 421-55XX

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. When applied as specified, this product will meet the required performance for the ANSI/KCMA A161.1 1990 9.0 Finish Tests as well as the criteria for the AWI TR-4 Finish System Performance.

SPECIFICATIONS:	Gloss:	As required
	Flash Point:	6°C
	Specific Gravity:	0.96
	Solids by weight:	44%
	Solids by volume:	36%
	Fire Hazard Class:	3
	Health Hazard Class:	2
	Viscosity:	Z #2/19-21" at 25°C
	VOC (as supplied):	540 g/L
	HAPs:	37%
	lbs. VOC/lbs. solids:	1.3
	lbs. VHAPs/lbs. solids:	0.9

HARDENER 100 parts by volume of 421-55XX Plastofix®.
MIXING RATIO: 8 parts by volume of 999-017 Hardener.
Other hardeners may be recommended at different ratios.

REDUCTION: Reduction is not necessary, use 121-802 if desired. Use 100-137 as slow tail reducer if required during summer months.

SHELF LIFE: 12 months recommended if unopened and stored in a cool dry area. Always rotate stock.



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POT LIFE: Mix only enough for one day's use for optimum product performance.

COVERAGE: 9-12 sq. m/L at 100% transfer efficiency. Coverage will vary depending on method of application and coating thickness.

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. Sealers should be topcoated within eight hours of being sanded. Appropriate sealers are 401-004 with 3% 999-017 and 401-008 with 3% 999-017 or self-seal. Plastofix® cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalysed systems should be acid stable.

DIRECTIONS FOR USE: Catalyse 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 catalysing. Thorough sanding between the coats is a must for good adhesion. The second coat must be applied the same day as the board is sanded.

Contact with metal surfaces should be avoided once the Plastofix® has been catalysed. 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.



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DIRECTIONS CONT'D: 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 technical data sheet will likely result in unsatisfactory film appearance or film failure.

The completed coating system should be checked for required properties prior to start-up of production.

DRYING TIME:

Note: Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures.

<u>At 20°C:</u>	<u>(Minimum Required)</u>
Tack Free:	15 minutes
Dry to Sand:	3 Hours
Dry to Stack:	Overnight

<u>At 50°C:</u>	
Tack Free:	Material should be flashed off before placing in oven.
Dry to Sand:	2 hours
Dry to Stack:	3 hours



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APPLICATION:

<u>Method</u>	<u>Viscosity</u>	<u>Recommended</u>	
		<u>Wet Film</u>	<u>Dry Film</u>
Spray - Conventional	Z #2/19-21"	3-4 mils	1.2-1.6 mils
- Airless	} Z #2/19-21"	3-4 mils	1.2-1.6 mils
- HVLP	}		

Note: All measurements recommended are based on results at temperatures of 20°C.

NOTE:

Plastofix® must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats.

Plastofix® must not be used and dried at temperatures below 18°C or relative air humidity above 65% as the hardening may otherwise become incomplete. During hardening the enamel must not be exposed to ammonia vapours.

Ammonia cleaners should not be used for cleaning the finished surface.

CLEAN-UP:

Use 121-802 or 121-001 thinner.

NOTE:

Chemcraft International Inc. 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 our products alone or in combination with other products. Users are advised to make their own tests to determine 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 in combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and are not recommended.

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