





	North America	Technical Data Sheet
	<b>LV Elast-O-Actif™</b>	Others
		11.03.2015
<b>FOR PROFESSIONAL USE ONLY</b>		

**Description**

Car parts made of deformable plastics require special flexible paints. The use of LV Elast-O-Actif will greatly improve the flexibility and impact resistance to such an extent that the coatings can tolerate deformation of the plastic part without cracking or chipping.

	<p><b>Safety Considerations</b>          Use suitable personal protection.          AkzoNobel recommends the use of a fresh air supply respirator.          Refer to the product Safety Data Sheet (SDS) for more complete safety information.</p>
	<p><b>Mixing</b>          The amount of LV Elast-O-Actif varies depending on the product being used and the type of plastic being repaired. Please refer to the following pages for a table with mixing details per product.</p>
	<p><b>Mixing can be performed two ways.</b></p> <p><b>Conventional Mixing</b></p> <ol style="list-style-type: none"> <li>1. Parts by volume selected product</li> <li>2. Parts by volume LV Elast-O-Actif</li> </ol> <p>Mix well and add:</p> <ol style="list-style-type: none"> <li>3. Parts by volume hardener</li> <li>4. Parts by volume reducer / activator</li> </ol> <p><b>Mixing on MPU</b></p> <ol style="list-style-type: none"> <li>1. Parts by volume selected product</li> <li>2. Parts by volume hardener</li> </ol> <p>Mix well and add:</p> <ol style="list-style-type: none"> <li>3. Parts by volume LV Elast-O-Actif</li> </ol>
	<p><b>HVLP or Compliant Spray-Gun Set-Up:</b>          Apply per product TDS instructions.</p>
	<p><b>Application</b>          Application method will not change by adding LV Elast-O-Actif. Please see the TDS relative to the product chosen for correct application and drying times.</p>

Read complete TDS for detailed product information.

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**Suitable Substrates**

The following categories have been created to differentiate between the types of substrates and the flexibility of the plastic parts.

1. Hard plastic parts - Includes mirror covers, rear spoilers
2. Flexible parts - Includes bumper covers
3. Soft parts – Includes rear spoilers, foam

The amount of LV Elast-O-Actif needed is dependent on the type of substrate being repaired.

**Products and Additives**

LV Elast-O-Actif can be added to the following products.

Colorbuild Plus 250  
 Autoclear Superior 250 2 Pack  
 Autoclear EnergySelect LV

LV Elast-O-Actif is not required in:  
 Autowave  
 Autosealer WB.

Elast-O-Actif cannot be added to Autowave.  
 When applying Autowave on soft (foam) spoilers, it is necessary to add 10% Autowave Hardener to the basecoat followed by Activator WB.

**Basic Raw Materials**

- Special polyester resin



**Colorbuild Plus 250 Mixing**

If the part to be can be deformed by hand, increase the flexibility of Colorbuild Plus 250 as follows:

	<p><b>100</b> <b>15</b></p>	<p><b>Make a Mixture of</b> Parts by volume Colorbuild Plus 250 Parts by volume LV Elast-O-Actif</p>
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Stir the paint and LV Elast-O-Actif mixture together then step #2 mix surfacer or sealer –

<p>#5 Stick</p>	<p><b>4</b> <b>1</b> <b>1</b></p>	<p><b>Surfacer</b> Parts by volume Colorbuild Plus 250 / LV Elast-O-Actif mixture (Previous step) Parts by volume Colorbuild Plus 250 Hardener Parts by volume Colorbuild Plus 250 Activator Use the Sikkens #5 (Orange) measuring stick when mixing by hand.</p>
<p>#9 Stick</p>	<p><b>3</b> <b>1</b> <b>1</b></p>	<p><b>Sealer</b> Parts by volume Colorbuild Plus 250 / LV Elast-O-Actif mixture (Previous step) Parts by volume Colorbuild Plus 250 Hardener Parts by volume Colorbuild Plus 250 Activator Slow or Extra Slow Use the Sikkens #9 (Gray) measuring stick when mixing by hand.</p>

**Autoclear Superior 250 2 Pack – Conventional Mixing**

If the part to be painted can be deformed by hand, increase the flexibility of Autoclear Superior 250 2 Pack..

<p>#14</p>	<p><b>100</b> <b>10</b></p>	<p>Autoclear Superior 250 2 Pack Fast or Slow Clearcoat Parts by volume LV Elast-o-Actif</p>
	<p><b>2</b> <b>1</b></p>	<p>Mix thoroughly and activate: Autoclear Superior 250 2 Pack Clearcoat with Elast-o-Actif Autoclear Superior 250 2 Pack Hardener</p>

**Autoclear Superior 250 2 Pack – MPU Mixing**


If the part to be painted can be deformed by hand, increase the flexibility of Autoclear Superior 250 2 Pack.

	<p><b>2</b> <b>1</b></p>	<p>Autoclear Superior 250 2 Pack Fast or Slow Clearcoat Autoclear Superior 250 2 Pack Hardener</p>
	<p><b>5</b></p>	<p>Mix thoroughly and activate: Parts by volume LV Elast-o-Actif</p>

**Autoclear EnergySelect LV – Conventional Mixing**

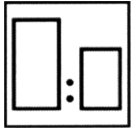
Autoclear EnergySelect LV does not require flex additive when being applied over hard or flexible plastic substrates. However, LV Elast-O-Actif is required when soft foam parts are being painted.

	<p><b>100</b> <b>5-8</b></p>	<p>Autoclear EnergySelect LV Clearcoat Parts by volume Elast-o-Actif</p>
	<p><b>2</b> <b>1</b></p>	<p>Mix thoroughly and activate: Autoclear EnergySelect LV Clearcoat with Elast-o-Actif Autoclear EnergySelect Hardener</p>

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**Autoclear EnergySelect LV – MPU Mixing**

If the part to be painted can be deformed by hand, increase the flexibility of Autoclear EnergySelect LV as follows.

	<b>2</b>	Autoclear EnergySelect LV Clearcoat with Elast-o-Actif Autoclear EnergySelect LV Hardener
	<b>1</b>	
	<b>10</b>	Mix thoroughly and add to ready to spray product: Elast-o-Actif

**VOC / Regulatory Information**

VOC values are listed below for the ready to spray product mix containing Elast-O-Actif.	
Colorbuild Plus 250 Primer Surfacer	1.79 lbs/gal (215 g/)
Colorbuild Plus 250 Primer Sealer	1.88 lbs/gal (226 g/L)
Autoclear Superior 250 2 Pack	2.1 lbs/gal (250 g/L)
Autoclear EnergySelect LV	2.0 lbs/gal (237 g/L)

**Product Storage**

Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (20°C).	
LV Elast-O-Actif Item #398218	1 year

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**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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