

Description

Vehicle parts made of deformable plastics require special flexible paints. The use of Elast-O-Actif will improve the flexibility and chip resistance so that the paint system can tolerate normal bending and impacts of the plastic part without cracking or chipping.



Safety Considerations

- Use suitable personal protection.
- AkzoNobel Car Refinishes recommends the use of a fresh air supply respirator.
- Refer to the product Safety Data Sheet (SDS) for more complete safety information.



Elast-O-Actif can be used in –

- Autosurfacers Rapid
- Colorbuild Plus
- Autoclear HS+ 2 Pack
- Autoclear PC



Mixing Ratio

- The amount of 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.



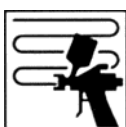
Mixing can be done one of three ways –

- 1) Conventional mixing in a container with a mixing stick.
- 2) Using the mixing computer (AkzoNobel Color Manager and Scale)
- 3) Added to clear-coat dispensed from the Sikkens Manual Proportioning Unit (MPU).



HVLP or Compliant Spray-Gun Set-Up:

- Per product being applied.
- Refer to the specific product TDS.



Application

- The application method will not change by adding Autocryl Elast-O-Actif.
- Please see the TDS for the product being applied for correct application and flash time.



Drying and Curing

- The dry time will not change by adding Autocryl Elast-O-Actif.
- Refer to the TDS for the product being applied for correct flash, dry and curing times.

Read complete TDS for detailed product information.

Description

Vehicle parts made of deformable plastics require special flexible paints. The use of Elast-O-Actif will improve the flexibility and chip resistance so that the paint system can tolerate normal bending and impacts of the plastic part without cracking or chipping.

Suitable Substrates



- The suitability of a substrate is not influenced by the addition of Elast-O-Actif to paint. Please refer to the TDS for the product being applied to determine suitable substrates.
- When used in an appropriate product, paint mixed with Elast-O-Actif may be used on either flexible or ridged parts.

Products and Additives

- Product**
- Elast-O-Actif – Stock #386100

Basic Raw Materials

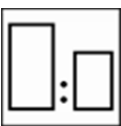
- Product**
- Elast-O-Actif – Special polyester resins

Substrate Preparation



- The preparation of a substrate is not influenced by the addition of Elast-O-Actif to paint. Please refer to the TDS for the product being applied to determine suitable substrates.

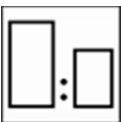
Mixing Autosurfacers Rapid – For Flexible Parts



STICK #9

- Mix**
- | | |
|---|----------------------------|
| 3 | By Volume |
| 1 | Autosurfacers Rapid Primer |
| | Elast-O-Actif |

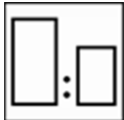
-THEN-



STICK #1

- | | |
|---|---|
| 2 | Mixture of Autosurfacers Rapid Primer and Elast-O-Actif |
| 1 | Autosurfacers Rapid Hardener |

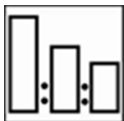
Mixing Colorbuild Plus – For Flexible Parts



STICK #9

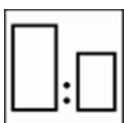
Mix
3
1
Surfacer, By Volume
Colorbuild Plus
Elast-O-Actif

-THEN-



STICK #1

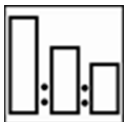
3
1
1
Mixture of Colorbuild Plus and Elast-O-Actif
Colorbuild Plus Surfacer Hardener
Colorbuild Plus Surfacer Activator



STICK #9

Mix
3
1
Sealer, By Volume
Colorbuild Plus
Elast-O-Actif

-THEN-



STICK #5

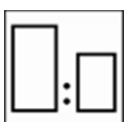
100
25
35
Mixture of Colorbuild Plus and Elast-O-Actif
Colorbuild Plus Surfacer Hardener
Colorbuild Plus Surfacer Activator

Mixing Colorbuild Plus – Color Manager and Mixit Scale Mix For Flexible Parts



- 1) Choose product to mix and quantity in Color Manager.
- 2) Select a ratio that includes Elast-O-Actif.
- 3) Queue the mix to the Mixit Scale.
- 4) At the Mixit Scale select the queued mix from the computer.
- 5) Mix following the prompts on the Mixit Scale or Ecomix head.

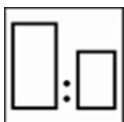
Mixing Autoclear HS+ 2 Pack – Conventional Mix For Flexible Parts



STICK #9

Mix
100
5
By Volume
Autoclear HS+ 2 Pack
Elast-O-Actif

-THEN-



STICK #1

2
1
Mixture of Autoclear HS+ 2 Pack and Elast-O-Actif
Autoclear HS+ 2 Pack Hardener

Mixing Autoclear HS+ 2 Pack – Color Manager and Mixit Scale Mix For Flexible Parts

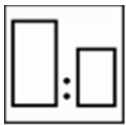


- 1) Choose product to mix and quantity in Color Manager.
- 2) Select a ratio that includes Elast-O-Actif.
- 3) Queue the mix to the Mixit Scale.
- 4) At the Mixit Scale select the queued mix from the computer.
- 5) Mix following the prompts on the Mixit Scale or Ecomix head.

Mixing Autoclear HS+ 2 Pack – MPU Mix For Flexible Parts

- 1) Dispense the desired amount of clear-coat + hardener from the MPU machine.
- 2) Add and stir in 60.7 grams of Elast-O-Actif per quart of dispensed clear-coat.

Mixing Autoclear PC – Conventional Mix For Flexible Parts

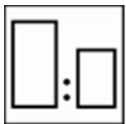


STICK #14

Mix
100
10

By Volume
Autoclear HS+ 2 Pack
Elast-O-Actif

-THEN-



STICK #1

2
1

Mixture of Autoclear HS+ 2 Pack and Elast-O-Actif
Autoclear HS+ 2 Pack Hardener

Mixing Autoclear PC – Color Manager and Mixit Scale Mix For Flexible Parts



- 1) Choose product to mix and quantity in Color Manager.
- 2) Select a ratio that includes Elast-O-Actif.
- 3) Queue the mix to the Mixit Scale.
- 4) At the Mixit Scale select the queued mix from the computer.
- 5) Mix following the prompts on the Mixit Scale or Ecomix head.

Mixing Autoclear PC – MPU Mix For Flexible Parts

- 1) Dispense the desired amount of clear-coat + hardener from the MPU machine.
- 2) Add and stir in 60.7 grams of Elast-O-Actif per quart of dispensed clear-coat.

Viscosity When Mixed



DIN #4

- Elast-O-Actif does not significantly influence mixed product viscosity.
- Please refer to the TDS for the product being mixed for information on viscosity.

Pot-Life When Mixed



- Elast-O-Actif does not influence the pot-life of mixed product.
- Please refer to the TDS for the product being mixed for information on potlife.

Spray Gun Set-Up



- Elast-O-Actif does not influence the choice of spray gun used.
- Please refer to the TDS for the product being mixed for information on spray gun selection and set-up.

Application



- The application method will not vary by adding Autocryl Elast-O-Actif.
- Please see the TDS for the product being applied for correct application and flash time.

Film Thickness – Using Suitable Application



- The paint thickness will not change by adding Autocryl Elast-O-Actif.
- Please see the TDS for the product being applied for correct application and paint thicknesses.

Drying / Curing Time



- The drying time is not altered significantly by adding Autocryl Elast-O-Actif.
- Please see the TDS for the product being applied for correct drying information.

Recoating



- The recoat time is unaffected by adding Autocryl Elast-O-Actif.
- Please see the TDS for the product being applied for recoating information.

Cleaning of Equipment



- Clean equipment following local and federal regulations. In compliant localities, use a VOC compliant high quality solvent borne gun cleaner. For national rule regions, a use high quality lacquer thinner.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

Theoretical Coverage




- The recoat coverage rates are unaffected by adding Autocryl Elast-O-Actif.
- Please see the TDS for the product being applied for coverage information.




FOR PROFESSIONAL USE ONLY

VOC / Regulatory Information

VOC values are listed below for the ready to spray product mixes containing Elast-O-Actif.

	Product	VOC Pounds per Gallon	VOC Grams per Liter
	• Autosurfacers Rapid	– 4.77	– 571
	• Colorbuild Plus Surfacer	– 4.71	– 564
	• Colorbuild Plus Sealer	– 4.48	– 538
	• Autoclear HS+ 2 Pack	– 4.25	– 510
	• Autoclear PC	– 4.10	– 492

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 (21°C)	
	• Elast-O-Actif	– 2 Years

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Telephone: 800.618.1010

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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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