

AUTOCRYL® ELAST-O-ACTIF

DESCRIPTION: Car body parts made of deformable plastics require special flexible paints. An addition of Autocryl Elast-O-Actif improves the flexibility to such an extent that the paint can tolerate deformation of the plastic parts without cracking or chipping.

PRODUCT: Autocryl Elast-O-Actif.

BASIC RAW MATERIAL:

Special polyester resin.



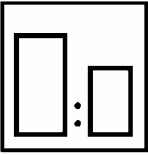


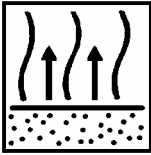

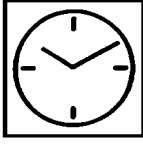
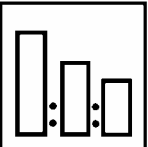
APPLICATION:

SUITABILITY: Autocryl Elast-O-Actif is suitable to be added to the following products:

- Colorbuild
- Autosurfacer 2+1HS
- Autocryl
- Sikkens Clearcoats

NOTE: Do not use Elast-O-Actif in Autobase Plus.

Example: To prepare Autoclear III for flexible parts.

- | | | | | | |
|----|---|--|----|--|--|
| 1. |  | Contains xylene and other ingredients. When mixed, also contains isocyanates. | 6. |  | Use the Sikkens Measuring Stick #1 (Black). |
| 2. |  | 100:10
Autoclear III
Autocryl Elast-O-Actif | 7. |  | 2x1
HVLP Siphon
0.071"–0.087" (1.8–2.2 mm)
HVLP Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (max 0.8 bar) |
| 3. |  | Use the Sikkens Measuring Stick #14 (Blue). (Use first two columns.) | 8. |  | 5–10 minutes at 70°F (20°C) |
| 4. |  | Stir this mixture | 9. |  | 4–5 hours at 70°F (20°C)
10–15 minutes at 140°F (60°C) |
| 5. |  | 100:50:30
Autoclear III with Autocryl Elast-O-Actif
Sikkens Standard Hardener
Sikkens Rapid Activator | | | |

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MIXING RATIO (EXAMPLE):

100 Parts by volume of Autoclear III
10 Parts by volume of Autocryl Elast-O-Actif
For easy and accurate mixing, use the Sikkens Measuring Stick #14 (Blue), use the first two columns.

After adding Elast-O-Actif to the topcoat, this material must be further prepared as follows:

100 Parts by volume of Autoclear III with Elast-O-Actif
50 Parts by volume of Sikkens Standard Hardener
30 Parts by volume of Sikkens Rapid Activator
For easy and accurate mixing, use the Sikkens Measuring Stick #1 (Black).

Depending on the flexibility of the plastic parts, we differentiate between the following categories:

1. Hard plastic parts i.e. Mirror covers, rear spoilers (xenoy alloy)
2. Flexible parts i.e. Bumper covers, Lexus cladding parts
3. Soft parts i.e. Rear spoilers (foam)

	Hard Parts	Flexible Parts	Soft Parts
Plastoflex Primer, or Primer PO (for untreated plastics)	X	X	X
Colorbuild	X		
Colorbuild with 33% Elast-O-Actif		X	
Colorbuild with 50% Elast-O-Actif			X
Autosurfacer 2+1 HS	X		
Autosurfacer 2+1 HS with 33% Elast-O-Actif		X	
Autosurfacer 2+1 HS with 50% Elast-O-Actif			X
Autocryl	X		
Autocryl with 33% Elast-O-Actif		X	
Autocryl with 50% Elast-O-Actif			X
Autoclear III	X		
Autoclear III with 10% Elast-O-Actif		X	
Autoclear III with 33% Elast-O-Actif			X
Sikkens Clearcoats	X		
Sikkens Clearcoats with 33% Elast-O-Actif		X	
Sikkens Clearcoats with 100% Elast-O-Actif			X

NOTE:

ELAST-O-ACTIF IS NOT PERMITTED IN AUTOBASE® PLUS.

In the case of application of Autobase® Plus on soft (foam) spoilers. It is necessary to add 10% Sikkens Standard Hardener or Autoclear II LV Hardener to the base coat before continuing to add Autobase Plus Reducer.

APPLICATION METHOD:

Application method will not change by adding Elast-O-Actif to the products. Please see the TDS relative to the product chosen for correct application and drying times.



AUTOCRYL[®] ELAST-O-ACTIF

STOCK KEEPING:

COLOR: Clear

CONTAINER SIZE: 1 liter

SHELF LIFE: Two years if stored at room temperature in original container.

SAFETY ASPECTS:

**READY TO
SPRAY VOC:**

Autoclear III/Autocryl Elast-O-Actif (100:10)
Then mixed 100:50:30 with Standard Hardener and Rapid Activator:

Note 1: 4.1 lb/gal 495 g/liter

Note 2: 3.8 lb/gal 460 g/liter

Note 1: VOC less water and less exempt solvent (Rule 1151 compliance).

Note 2: VOC calculated including water and exempt solvents.

NOTICE:

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.