

## AUTOSURFACER® FLEX

**DESCRIPTION:** Autosurfacer Flex is an elastomeric additive, which is used with Autosurfacer 940 HS when refinishing flexible plastic parts. Adding Autosurfacer Flex improves flexibility to such an extent that the coating can tolerate deformation of the plastic part without cracking or damage to the finish.

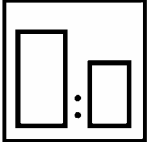
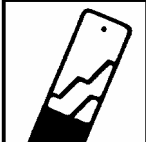
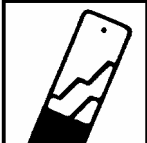


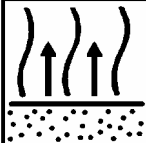
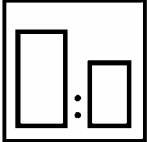
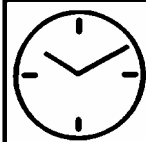
**PRODUCT:** Autosurfacer Flex

**BASIC RAW MATERIALS:** Modified polyester resin

**SUITABILITY:** Autosurfacer Flex can be used in Autosurfacer 940 HS

### APPLICATION: EXAMPLE: TO PREPARE AUTOSURFACER 940 HS FOR FLEXIBLE PARTS

(as a wet-on-wet sealer)

- |    |   |   |    |  |  |
|----|---|---|----|--|--|
| 1. |   | 100:50<br>Autosurfacer 940 HS<br>Autosurfacer Flex  | 5. |   | Use the Sikkens<br>Measuring Stick #9 (Grey).  |
| 2. |  | Use the Sikkens Measuring<br>Stick #1, 2 or 3.  | 6. |  | 1x1<br>HVLP Siphon<br>0.071"–0.087" (1.8–2.2 mm)<br>HVLP Gravity<br>0.051"–0.059" (1.3–1.5 mm)<br>Max 10 psi (max 0.8 bar) |
| 3. |  | Stir this mixture.  | 7. |  | 15 minutes at 70°F (20°C)  |
| 4. |  | 3 : 1 : 1<br>Autosurfacer 940 HS with<br>Autosurfacer Flex<br>Autosurfacer 940 HS Hardener<br>Autosurfacer Reducer 940 HS | 8. |  | (Wet-on-Wet)<br>15 minutes at 70°F (20°C)<br>(Non-Sanding)<br>2-1/2 hours at 70°F (20°C)                                   |

### MIXING RATIOS: **Mixing of Autosurfacer 940 HS with Autosurfacer Flex**

100 Autosurfacer 940 HS  
50 Autosurfacer Flex

Stir thoroughly and proceed as follows:

**For wet-on-wet:**

3 parts by volume of the above mixture  
1 part by volume Autosurfacer 940 HS Hardener  
1 part by volume Autosurfacer Reducer 940 HS

**For high-build:**

3 parts by volume of the above mixture  
1 part by volume Autosurfacer 940 HS Hardener



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## AUTOSURFACER<sup>®</sup> FLEX

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### MIXING RATIOS (CONTINUED):

Depending on the flexibility of the plastic parts, we differentiate 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

	Hard Parts	Flexible Parts
Plastoflex Primer or Primer PO (for untreated plastics)	X	X
Autosurfacer 940 HS	X	
Autosurfacer 940 HS with Autosurfacer Flex		X

### APPLICATION METHOD:

Application method will not change by adding Autosurfacer Flex to the products. Please see Autosurfacer 940 HS TDS.

### NOTE:

Autosurfacer 940 HS is not recommended on soft (foam) spoilers.

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### STOCK KEEPING:

**COLOR:** Amber

**CONTAINER  
SIZE:** 1 liter

**SHELF LIFE:** Two years if stored unopened at room temperature.

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### SAFETY ASPECTS:

#### READY TO SPRAY VOC:

Autosurfacer 940 HS/Autosurfacer Flex (100:50): (3:1 with Autosurfacer 940 HS Hardener)	4.5 lb/gal	545 g/liter
Autosurfacer 940 HS/Autosurfacer Flex (100:50): (3:1:1 with Autosurfacer 940 HS Hardener and Autosurfacer Reducer 940 HS)	4.6 lb/gal	550 g/liter

### 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 organic vapor respirator or air supplied respirator when exposed to vapors or spray mist.