

421-56XX Plastofix® Plus 550 Post-Cat Clear TC

Product codes:	421-5610 Matte	Viscosity	Zahn #2 signature cup 19 sec at 77°F
	421-5620 Low Gloss	Flash Point:	-4° F (-20°C)
	421-5640 Satin	Density (lb/gal):	7.6
	421-5660 Semi-Gloss	Solid (% by weight):	35%
		Solid (% by volume):	28%
		Shelf Life (months):	12

Product Description:

Plastofix Plus 550 is a two-component post-catalyzed Reactive Amino Coating (RAC). Plastofix Plus 550 is a fast drying, good building product that shows excellent resistance to both chemicals and to physical wear. The coating has excellent leveling and a smooth even appearance, even on open-grain woods. Plastofix Plus 550 is supplied at a ready to spray viscosity. This coating will dry quickly and sand easily and can be used a self seal finish.
 Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards.

Uses:

Plastofix Plus 550 is recommended for office and household furniture, kitchen cabinets, as well as many other high performance interior wood applications. Plastofix Plus 550 is designed for use on all types of solid wood and veneer meant for interior use.

Environmental Data (as supplied):	VOC less exempt lb/gal:	<3.75
	VOC lb/gal:	<2.25
	VOC less exempt g/l:	
	VOC g/l:	
	VOC lb/lb Solid:	<1.00
	VHAPs lb/lb Solid:	<0.12

Note:

See individual compliance sheets for specific data

Application Data	Suggested Uses:	Wood Finish
	Mixing Ratio:	100 parts 421-56XX to 3 parts 873-1205 or 100 parts 421-56XX to 10 parts 873-0870
	Suggested Uses:	8 hours
	Application Viscosity:	Zahn #2 signature cup 18 seconds
	Reducer:	N/A
	Retarder:	800-5328
	Clean-up Solvent:	800-5500
	Recommended Wet Film:	3 – 5 mils
	Coverage:	Coverage is 335 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Note:

N/A

Directions for use:**Surface Preparation:**

Substrate must be sanded using 120, 150 or 180 grit steared paper prior to staining or coating. When sealing, the sealer coat should be sanded prior to being coated with 280/320 grit steared paper. The sealer should be topcoated within eight hours of being sanded. This product is designed to be used as a self seal. When recoating, the previous coat of Plastofix Plus 550 must be sanded and the next coat applied within eight hours. Plastofix Plus 550 cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable. AkzoNobel recommends using 825-00XX or 825-09XX series stains or 824-50XX series waterborne stains.

General Information:

Agitate material before use. Plastofix Plus 550 must be agitated thoroughly at all times to ensure product consistency and consistent gloss. Always mix Plastofix Plus 550 while adding hardener and reducers in the recommended mixing ratios. Apply at 3-5 mils wet on sanded substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit steared paper. The second and subsequent coats must be applied the same day as the previous coat is sanded. Maximum film build of Plastofix Plus 550 should not exceed 4 mils dry. Maximum film build of total coating system must not exceed 4 mils dry. Contact with metal surfaces should be avoided.

Please note that as with any other amino-containing product, this material contains, and has the potential to emit, formaldehyde (CAS# 50-00-0). As per the US Department of Labor Standard 29 CFR 1910.1048 covering formaldehyde, section (d)(1)(i) states that "Each employer who has a workplace covered by this standard shall monitor employees to determine their exposure to formaldehyde." Please refer to the OSHA web site at www.osha.gov for further information. Plastofix Plus 550 must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. Plastofix Plus 550 must not be used and dried at temperatures below 64°F or relative humidity above 65%. During hardening the coating must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION

Drying Times:

	Room Temperature (20°C / 68°F)	Forced Drying Schedule (50°C / 122°F)
Tack Free Time:	30 – 40 minutes	Flash off before entering oven
Dry to Sand:	60 - 90 minutes	Overnight
Dry to Stack:	30 – 60 minutes	3 – 4 hours

Note:

N/A

Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel 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 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 a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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Updated: 2024-05-19 01:00:24

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