

## 421-48XX Plastofix® Light Post-Cat Clear TC

<b>Product codes:</b>	421-4810 Matte	<b>Viscosity</b>	Zahn #2 signature cup 27 sec at 77°F
	421-4820 Low Gloss	<b>Flash Point:</b>	62°F (17°C)
	421-4835 Satin	<b>Density (lb/gal):</b>	8.2
	421-4890 High Gloss	<b>Solid (% by weight):</b>	50%
		<b>Solid (% by volume):</b>	41%
		<b>Shelf Life (months):</b>	12

### Product Description:

Plastofix Light is a high quality, acid curing Reactive Amino Coating (RAC). This is a fast building product due to its high solid content (41% volume). Depending on the spray equipment being used Plastofix Light may be ready to spray at 30 seconds viscosity (Zahn #2). Plastofix Light has very good light stability based on the choice of resin used in the product. Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards. Recommended: Architectural Woodwork Institute ((AWI). TR 4

### Uses:

This product is recommended for kitchen cabinets, high build office or residential furniture as well as other interior wood applications.

### Environmental Data (as supplied):

<b>VOC less exempt lb/gal:</b>	<4.20
<b>VOC lb/gal:</b>	<4.20
<b>VOC less exempt g/l:</b>	
<b>VOC g/l:</b>	
<b>VOC lb/lb Solid:</b>	<1.05
<b>VHAPs lb/lb Solid:</b>	<0.35

### Note:

N/A

### Application Data

<b>Suggested Uses:</b>	Wood Finish
<b>Mixing Ratio:</b>	100 parts 421-48XX to 10 part 873-0870
<b>Suggested Uses:</b>	12 hours (catalyzed)
<b>Application Viscosity:</b>	Zahn #2 signature cup 20 – 22 seconds
<b>Reducer:</b>	803-1325
<b>Retarder:</b>	800-5328
<b>Clean-up Solvent:</b>	803-1298
<b>Recommended Wet Film:</b>	3 – 4 mils
<b>Coverage:</b>	722 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 or 150 grit stearated paper prior to staining or coating. Sealers, if used, should be sanded with 240, 280 and 320 grit stearated paper prior to being coated. The substrate as well as the sealers should be topcoated within eight hours of being sanded. Plastofix Light cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable. AkzoNobel recommends using 825-90XX, 825-91XX Promatch® C-Mix Stains or 890-85XX Promatch Dye Stains.

**General Information:**

Catalyze and reduce the material as recommended. Plastofix Light is applied in one to three coats on all kinds of wood meant for indoor use. On open pored woods, the best self-sealing is obtained by adding a minimum of 25% Reducer 803-1325 to the Plastofix Light after catalyzing. Thorough sanding between the coats is a must for good adhesion. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Contact with metal surfaces should be avoided once the Plastofix Light has been catalyzed. To ensure proper sheen, the catalyzed material should be agitated at all times.

This product can be used as a self-sealer if reduced 20 – 30%. Appropriate sealers are Catalyzed Vinyl Sealer 546-7023 with 3% Catalyst 873-0870, or Chemvinyl 546-8002, or Danseal 432-1220. Consult with your coatings supplier for specific recommendations.

Plastofix Light demonstrates excellent resistance to marring, dry heat, moisture, household and office liquids, etc. When this product is used as its own sealer, its special formulation ensures excellent filling and easy sanding properties with superior holdout for subsequent coating. Plastofix Light must be thoroughly stirred, while adding catalyst and reducer in the recommended ratio. Total recommended film build of Plastofix Light and sealer should not exceed 4 mils dry.

Plastofix Light must not be polluted with oil, varnish or the like and must not be sanded with steel wool between coats.

Plastofix Light must not be used and dried at temperatures below 64°F or relative humidity above 65%. During the curing process, 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:**

	<b>Room Temperature (20°C / 68°F)</b>	<b>Forced Drying Schedule (50°C / 122°F)</b>
<b>Tack Free Time:</b>	15 minutes	Flash off before entering oven
<b>Dry to Sand:</b>	2 hours	Overnight
<b>Dry to Stack:</b>	45 minutes	3 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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