Chemcraft International, Inc.

Product Information

Plastofix® 550 – 421-41XX

PRODUCT DESCRIPTION

421-4180	Full Gloss
421-4160	Semi Gloss
421-4140	Satin Gloss
421-4120	Low Gloss

Plastofix® 550 is a high quality, acid catalyzed sealer/topcoat for use on all types of solid wood and veneer meant for interior use. When used as a sealer, its special formulation ensures excellent filling and easy sanding properties with superior holdout for subsequent coatings. When applied as a topcoat, it shows excellent resistance to mechanical damage, dry heat, household and office liquids, etc. Plastofix® 550 is an all-around reactive amino coating (RAC) equally suited for application with roller and curtain coating as well as conventional spraying equipment. This product is developed to provide a very fast cure coating.

FEATURES

Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards. Recommended: American Woodworking Institute (AWI) T.R.4.

Plastofix® 550 has been formulated by using very low discoloration material to help maintain the natural color of the wood or stain.

Note: Plastofix® 550 must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats.

Plastofix® 550 must not be used and dried at temperatures below 64° F. or relative air humidity above 65% as the hardening may otherwise become incomplete. During hardening the enamel must not be exposed to ammonia vapors.

Ammonia cleaners should not be used for cleaning the finished surface.

SPECIFICATION VALUES

Gloss:	As required
Flash Point:	-18°C (0°F)
Specific Gravity:	0.92
Weight per Gallon:	7.68
Solids by Weight:	41%
Solids by Volume:	36%
Fire Hazard Class:	3
Health Hazard Class:	2
Viscosity at 25°C (77°F):	17 sec Zahn #2
VOC:	536 g/l (4.47 lb/gal)
Lbs. VOC/Gallon:	4.19
Lbs. VOC/Lbs. Solids:	1.345
Lbs. VHAPs/Lbs. Solids:	<0.1
Values at Application if Catalyzed:	
Lbs. VOC/Lbs. Solids:	1.479
Lbs. VHAPs/Lbs. Solids:	<0.1

If additional reducers or additives are used, compliance values must be recalculated.

SPECIFICATION INFORMATION

Shelf Life: 12 months recommended if unopened and stored between 15°C and 25°C (59°F – 77°F). Always rotate stock.

Pot Life: Mix only enough for one day's use for optimum product performance. Use of material that has been catalyzed for more than 12 hours may cause failure in film integrity.

Coverage: Coverage is 577 sq ft/gal at 100 % transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Mixing Ratio: 100 parts by volume of 421-41XX Plastofix® 550 to 3 part by volume of 873-1205 Hardener. Other hardeners may be recommended at different ratios.

Reduction: N/A

DIRECTIONS FOR USE

Surface Preparation: Substrate must be sanded using 120 or 150 grit stearated prior to staining or coating. Sealers, if used, should be sanded prior to being coated with 240, 280 and 320 grit stearated paper. Sealers should be topcoated within eight hours of being sanded. Appropriate sealers are 546-7003 with 3% 873-0870, or selfseal. Plastofix® 550 cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable.
Directions for use: Catalyze and reduce the material as recommended. Plastofix® 550 is applied in one to three coats on all kinds of wood meant for indoor use. Thorough sanding between the coats is a must for good adhesion. The second coat must be applied the same day as the board is sanded.

Contact with metal surfaces should be avoided once the Plastofix® 550 has been catalyzed. To ensure proper sheen, the catalyzed material should be agitated at all times.

Plastofix® 550 must be thoroughly stirred, while adding hardener and reducer in the recommended mixing ratio.

Total recommended film build of Plastofix® 550 and sealer should not exceed 4 mils dry.

The customer is responsible for following the recommended application procedures. Failure to adhere to the recommendations given in this technical data sheet will likely result in unsatisfactory film appearance or film failure.

The completed coating system should be checked for required properties prior to start-up of production.

APPLICATION

Method of Application:	**Viscosity**	**Wet Film**	**Dry Film**
Spray - Conventional	Z #2/17"	3 – 4 mils	1.2-1.6 mils
- Airless	Z #2/17"	3 – 4 mils	1.2–1.6 mils
- Curtain Coater	Z #2/17"	3 – 4 mils	1.2-1.6 mils
- Roller Coater	Z #2/17"	1 – 3 mils	0.4-1.2 mils

All measurements recommended are based on results at temperatures of 20°C (68°F).

Drying Times:

At 20°C (68°F)	(Minimum Required)	At 50°C (122°F)	(Minimum Required)
Tack Free:	15 mins	Tack Free:	Flash off before entering oven
Dry to Sand:	2 hours	Dry to Sand:	2 hours
Dry to Stack:	Overnight	Dry to Stack:	3 hours

Note: Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperature of 20°C (68°F) must be maintained throughout the curing cycle to achieve the film integrity as stated in product description.

Clean-Up: Use 803-1298

Chemcraft International Inc. views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Revised: