



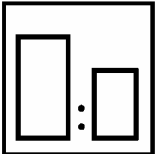


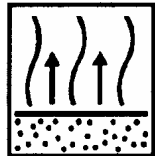

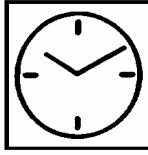
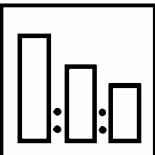


## AUTOCOAT® LV FLEX

**DESCRIPTION:** Car body parts made of deformable plastics require special flexible paints. Use of Autocoat LV Flex will greatly improve the flexibility to such an extent that the coatings can tolerate deformation of the plastic part without cracking or chipping.

**PRODUCT:** Autocoat LV Flex  
**BASIC RAW MATERIAL:** Autocoat LV Flex: special polyester resin.

**APPLICATION:** **Example: To prepare Autocoat LV for flexible parts.**

- |    |   |   |    |   |  |
|----|---|---|----|---|--|
| 1. |    | Contains butyl acetate methyl amyl ketone, xylene and other ingredients. When mixed, also contains isocyanates. | 5. |     | Use the Sikkens Measuring Stick #11 (Blue).  |
| 2. |   | 100:33<br>Autocoat LV<br>Autocoat LV Flex   | 6. |   | 2x1<br>HVLP-Gravity<br>0.051"-0.059" (1.3-1.5 mm)<br>HVLP-Siphon<br>0.071"-0.087" (1.8-2.2 mm) |
| 3. |  | Use the Sikkens Measuring Stick #4 (Green).   | 7. |   | 10 minutes at 70°F (20°C)  |
| 4. |  | Stir this mixture.  | 8. |  | 20 hours at 70°F (20°C)<br>1 hour at 140°F (60°C)<br>(Slow Hardener)                           |
| 5. |  | 100:50:25<br>Autocoat LV with Autocoat LV Flex<br>Autocoat LV Hardener Standard or Slow<br>Autocoat LV Reducer  |    |   |  |

**SUITABLE SURFACES:**

- Untreated plastic parts; degrease with Sikkens Anti-Static Surface Cleaner or an appropriate VOC compliant cleaner degreaser in a VOC regulated area. After proper identification and preparation, untreated plastic parts must first be primed with Plastoflex Primer, Primer PO or in some VOC regulated areas, Autowave Filler 790 mixed with Autowave Flex. Please see the Technical Data Sheet relative to the product chosen.
- Pre-painted plastic parts should be treated as an existing finish. After sanding and cleaning, apply Autocoat LV, Autobase/Clearcoat mixed with Autocoat LV Flex.



## AUTOCOAT® LV FLEX

**MIXING RATIO:** Mix 100 parts by volume of Product  
33 parts by volume Autocoat LV Flex  
For easy and accurate mixing, use the Sikkens Measuring Stick #4 (Green).  
After adding Autocoat LV Flex to the top coat, this material must be further prepared as follows:

Mix 100 parts by volume of topcoat with Autocoat LV Flex  
50 parts by volume Autocoat LV Hardener Fast, Standard or Slow  
25 parts by volume of Autocoat LV Reducer.  
For easy and accurate mixing, use the Sikkens Measuring Stick #11 (Blue).

**NOTE:** As in the example above, Autocoat LV Flex should always be added prior to hardener or reducer.

**SUITABILITY:** Autocoat LV Flex is suitable to be added to the following products:  
—Autocoat LV —Autosurfacer LV Sealer  
—Autobase —Colorbuild 2.1-2.8 Surfacer and Sealer  
—Autoclear II LV —Autocoat LV Clear High Solids

**NOTE:** Do not use Autocoat LV Flex in Autobase Plus.  
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)

Below is a table describing the various products that may be applied to hard, flexible and soft plastic parts.

	Hard Parts	Flexible Parts	Soft Parts
Primer PO or Plastoflex® Primer (for untreated plastics)	X	X	X
Autosurfacer LV Sealer	X		
Colorbuild 2.1-2.8 Primer Surfacer with 33% Autocoat LV Flex		X	
Colorbuild 2.1-2.8 Primer Sealer with 33% Autocoat LV Flex		X	
Colorbuild 2.1-2.8 Primer Surfacer with 50% Autocoat LV Flex			X
Autosurfacer LV Sealer with 33% Autocoat LV Flex		X	X
Autocoat LV	X		
Autocoat LV with 33% Autocoat LV Flex		X	X
Autobase	X		
Autobase with 10% Autocoat LV Flex		X	X
Autoclear II LV	X		
Autoclear II LV with 33% Autocoat LV Flex		X	
Autoclear II LV with 100% Autocoat LV Flex			X
Autocoat LV Clear High Solids	X		
Autocoat LV Clear High Solids with 33% Autocoat LV Flex		X	X



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## AUTOCOAT® LV FLEX

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### APPLICATION METHOD:

Application method will not change by adding Autocoat LV Flex to the products. For correct application and drying times, please refer to the following Technical Data Sheets:

- Autocoat LV
- Autoclear II LV
- Autobase Solid and Metallic Colors
- Autocoat LV Clear High Solids
- Autosurfacer LV Sealer
- Autoclear LV

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### STOCK KEEPING:

#### COLOR:

Clear

#### CONTAINER SIZE:

1 quart (946 ml)

#### SHELF LIFE:

One year if stored at room temperature in original container.

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### SAFETY ASPECTS:

#### READY TO SPRAY VOC:

Autocoat LV + 33% Autocoat LV Flex:	3.4 lb/gal	410 g/liter
Autobase + 10% Autocoat LV Flex:	maximum 5.9 lb/gal	710 g/liter
Autocoat LV Clear High Solid + 33% Autocoat LV Flex:	3.5 lb/gal	420 g/liter
Autoclear II LV + 33% Autocoat LV Flex:	2.1 lb/gal	250 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 air-supplied respirator when exposed to vapors or spray mist.

