


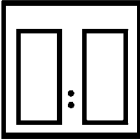








## AUTOWAVE<sup>®</sup> FLEX

**DESCRIPTION:** Autowave Flex is a special additive to be used only with Autowave Filler 790. Adding Autowave Flex will allow Autowave Filler 790 to be flexible to such an extent that it can tolerate deformation of the plastic parts without cracking or chipping.

**PRODUCT:** Autowave Flex  
**BASIC RAW MATERIAL:** Autowave Flex: Polyurethane dispersion

**APPLICATION:** **Example: To prepare Autowave Filler 790 for flexible parts**

1.  Contains urethane resin special solvent and water.
2.  100:100  
Autowave Filler 790  
Autowave Flex
3.  Use the Sikkens Measuring Stick.
4.  Stir thoroughly.
5.  1x1 (Non-Sanding)  
HVLP Siphon  
0.071"–0.087" (1.8–2.2 mm)  
HVLP Gravity  
0.051"–0.059" (1.3–1.5 mm)  
Max 10 psi (max 0.8 bar)
6.  30 minutes (Non-Sanding)  
at 70°F (20°C).
7.  Apply topcoat.
8.  Keep from freezing.



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### SUITABILITY:

We differentiate between the following categories of plastic parts, based on flexibility:

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 scheme describing the various products that may be applied to hard, flexible and soft plastic parts. As Autowave Filler 790 and Autowave Flex are primarily designed for VOC regulated areas, other products listed are also selected for compliancy.

	Hard Parts	Flexible Parts	Soft Parts
* Plastoflex <sup>®</sup> Primer or Primer PO (for untreated plastics)	X	X	X
Autowave Filler 790	X		
Autowave Filler 790 with Autowave Flex		X	X

\*Note: Plastoflex Primer and Primer PO are classified as a specialty coating.

### MIXING RATIO:

Mix 100 parts by volume Autowave Filler 790 with  
100 parts by volume Autowave Flex  
For easy and accurate mixing, use the Sikkens Measuring Stick.

### SPRAYING VISCOSITY:

The proper spraying viscosity is achieved by using the recommended mixing ratio 26–30 sec. ZAHN cup #2 (24–28 sec. DIN cup #4) at 70°F (20°C).

### POT LIFE:

3 days after mixing, at 70°F (20°C).

### FILM THICKNESS:

0.8–1.0 mil per single coat.

### SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
HVLP Siphon	0.071"–0.087" (1.8–2.2 mm)	max 10 psi (max 0.8 bar)
HVLP Gravity	0.051"–0.059" (1.3–1.5 mm)	max 10 psi (max 0.8 bar)



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**NOTE:** This is a water-based product. Before using, the application equipment should be fitted with a stainless steel tip and be thoroughly cleaned and rinsed with Autowave gun cleaner at least two times. Then rinse with clean water.

**APPLICATION METHOD:**

Autowave Flex mixed with Autowave Filler 790 may be applied two ways:

- A. As a non-sanding plastic primer, spray **one** single coat only.
- B. As a plastic primer surfacer that **must** be sanded. Spray 2–3 single coats.

**FLASH TIME:**

- A. Allow this single coat to flash dry for 30 minutes at 70°F (20°C).
- B. 10–15 minutes between coats. Flash-off and drying times will vary with relative humidity (see section "Drying Times" next page).

**DRYING TIMES:**

To Sand	Relative Humidity	
	50%	70%
<b>Application A (1 Single Coat)</b>		
70°F (20°C)	2 hours	2.5 hours
140°F (60°C)	30 minutes	45 minutes
<b>Application B</b>		
60°F (15°C)	4.5 hours	5.5 hours
70°F (20°C)	3 hours	4 hours
80°F (27°C)	2.5 hours	3 hours
140°F (60°C)	45 minutes	1 hour

**INFRARED DRYING:**

15 minutes using short or medium wave length Infrared–Dryer.

**CLEANING OF EQUIPMENT:**

After application, do not allow product to dry in application equipment. Clean equipment with Autowave gun cleaner. Rinse with water.

**SANDING:**

Sand with #P600 to #P800 grit paper wet or with #P400 to #P500 grit dry

**RECOATABILITY:**

- With Autobase, Autobase Plus or Autocoat LV after 30 minutes, a maximum of 3 hours if the product is applied as a non-sanding plastic primer.
- With Autobase, Autobase Plus or Autocoat LV at any stage after sanding.

**COVER RATE:**

Approximately 100–110 sq. ft./liter of unmixed paint per single coat.



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### STOCK KEEPING:

**COLOR:**                      Autowave Flex:            Clear  
   Autowave Filler 790:    Beige

**CONTAINER SIZE:**            Autowave Flex:            1 quart (946 ml)  
   Autowave Filler 790:    1 gallon (3.785 lt)

**SHELF LIFE:**                    Autowave Flex: One year if stored in original container and kept from freezing.  
   Autowave Filler 790: One year if stored in original container and kept from freezing.

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### SAFETY ASPECTS:

**READY TO SPRAY VOC:**            (Mixed 1:1):  
   Note 1:                      1.9 lb/gal            225 g/liter  
   Note 2:                      0.8 lb/gal            95 g/liter

Note 1: VOC less water and less exempt solvent (Rule 1151 compliance).

Note 2: VOC calculated including water and exempt solvents.

**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.