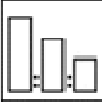




# Technical Data Sheet

## Additives


### Product: Automotive Art Flex Additive 20-45

<b>Features:</b>	Automotive Art Flex Additive 20-45 contains special polymers that enables the use of Motocryl and Clear on semi-flexible plastics	
<b>Benefits:</b>	Avoids cracking	
<b>Recommended Use:</b>	This additive is recommended to use when painting on plastics	
<b>Materials and tools for the job:</b>	<ul style="list-style-type: none"> <li>• Automotive Art Ms Top Clear <span style="float: right;">82-50, 82-40</span></li> <li>• Automotive Art Motocryl <span style="float: right;">50 Line</span></li> <li>• Automotive Art Primer <span style="float: right;">45- Series</span></li> <li>• Automotive Art Hardener <span style="float: right;">30- Series</span></li> <li>• Automotive Art Reducer <span style="float: right;">35- Series</span></li> <li>• Mixing stick, mixing tin and spray gun.</li> </ul>	
<b>Physical properties:</b>	<p><b>Specific gravity (kg/l):</b> 0.985</p> <p><b>Flash point:</b> Closed cup: 25°C (77°F)</p> <p><b>Vol.% solids:</b> -</p> <p><b>Coverage:</b> -</p> <p><b>Viscosity DINCUP 4mm/20°C:</b> -</p> <p><b>Gloss:</b> -</p> <p><b>Color:</b> Clear</p> <p><b>V.O.C. (RTS):</b> -</p>	
<b>Cleaning the equipment:</b>	Lacquer Thinner 6-051	
<b>Shelf Life:</b>	Under normal storage conditions minimum two years (unopened tins).	
<b>Mixing ratio:</b> <b>Hardener</b> 	<p><b>Primer Fillers</b></p> <p><b>Mixture A</b>            4 : 1 Using the mixing stick            100% Primer Filler by vol.            25% Flex Additive 20-45 by vol.</p> <p>Then:</p> <p><b>Mixture B</b>            4 : 1 Using mixing stick            100% by vol. Mixture A            25% by vol. Hardener            25% by vol. Reducer</p>	<p><b>Motocryl and Clears:</b></p> <p><b>Mixture A</b>            4 : 1 Using the mixing stick            100% Motocryl or Clear by vol.            25% Flex Additive 20-45 by vol.</p> <p>Then:</p> <p><b>Mixture B</b>            2 : 1 Using mixing stick            100% by vol. Mixture A            50% by vol. Hardener            10% by vol. Reducer</p>
	When painting on soft plastic or foam parts use 50% of Automotive Art 2K Flex Additive 20-45 in Primers and Top Coats.	
<b>Nozzle size:</b>	<b>Gravity gun:</b> HVLP: 1.6 -1.8 mm	<b>Gravity gun:</b> HVLP: 1.3-1.4 mm



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## Additives

	<b>Suction gun:</b> HVLP: 1.7-1.9 mm	<b>Suction gun:</b> HVLP: 1.4-1.6 mm
<b>Spraying pressure:</b>	HVLP: 2.0 -3.0 bar (30 - 45 p.s.i.)	High pressure: approx. 4 bar (60 p.s.i.)
<b>Application:</b>	Refer to Primer Filler or Top Coat application	
<b>Drying time:</b> At 20° C At 60° C IR short wave 	<b>Tack-free:</b> 5 hours 20 – 40 minutes 7 minutes	<b>Ready for assembly:</b> 12 hours
<b>Pot life at 20° C:</b>	1 – 2 hours	
<b>Warning:</b>	Never add to MotoBase 80 Line or 8LV Line.	