



FEATURES

- * Single-pack H₂O based polyurethane
- * Very fast drying
- * Accentuates print work appearance - low blush or colour shift on printed images
- * Excellent flow and levelling properties resulting in a high gloss 'magic-mirror' finish
- * Highly flexible - can be applied to flexible substrates
- * UV stable - protects against weathering and discolouration
- * Highly durable - protects against marring, abrasion and scuffing
- * Excellent adhesion to plastics, ABS, PCs, self-adhesive vinyls and PVCs

USES

- * Provides a visually enhancing and protective top coat to printed media.
- * Accentuates print colours and colour density, visually enhancing the colour of the print work.
- * Self cross-linking polyurethane that offers excellent durability and strength, protecting both substrate and inks against physical abrasion, chemical attack and UV weathering.
- * Compatible with eco solvent, solvent and UV-cured ink prints. Not suitable for Latex inks - use Flexathane G300. High speed production environments will require accelerated drying mechanisms eg. IR curing.

GENERAL DATA

Type	Polyurethane (Aliphatic)
Drying time @ 20°C	Touch Dry: < 75 minutes Through Dry: < 120 minutes
Curing	7 Days
Viscosity (Brookfield RVT)	150 - 200 mPas (Spindle 1)
Specific gravity	1.00 - 1.05
Gloss	High gloss (>80 on 20° Geometry)
NVM (Non-volatile matter)	34 - 36%
VOC	<100g/litre
Dry film thickness	20 - 40 µm
Theoretical spreading rate	10 - 15 m ² / litre for 20-40 µm film build
Pendulum Hardness (Konig)	120
pH	7.5-8.5
Accelerated Weather Testing (EN927-6)	Xenon Arc 2016 Pass (90% gloss retention, no discolouration, no cracking, flaking or loss of adhesion)



COLOUR RANGE

Clear

APPLICATION

- | | |
|------------------|---|
| General | * Ready-for-use with pad applicator, roller, spray-gun or liquid laminator. A brush can be used, but not recommended. A high density pad applicator is preferred. |
| Thinning | * Thinning NOT required for conventional application. For spraying, dilute with 5% H ₂ O. |
| Liquid Laminator | * If required, dilute by up to 10% H ₂ O. Manufacturer available for consultation. |
| Cleaning | * Use H ₂ O. Do NOT allow the product to dry before cleaning. |
| Substrates | * Use on plastics, vinyls, self-adhesive vinyls, PCs, ABS and PVCs
* Apply on rigid or flexible substrates |



APPLICATIONcont'd

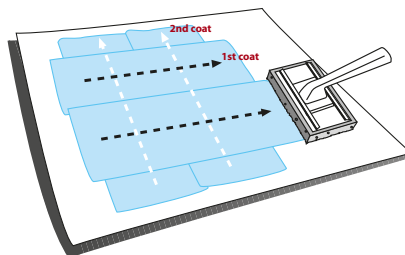
- Recommended Film Build
 - * 20 - 40 microns (μm)
 - * $>25 \mu\text{m}$ gives a high gloss finish

- Spreading Rate
 - * Depends on mode of application and required film build
 - * As a guide: a $25 \mu\text{m}$ film build will cover $12\text{m}^2/\text{litre}$ where 100% delivery efficiency
 - * Delivery Efficiency:
 - Pad applicator - 90%
 - Conventional spraying - 40%
 - HVLP spraying - 70%

Directions for use

PAD APPLICATOR

- * Pour appropriate amount of Flexathane into tray or similar container.
- * Coat an even layer of Flexathane onto the applicator
- * Apply Flexathane onto the substrate using vertical or horizontal strokes until the desired **film thickness and overall evenness** is achieved.
- * Apply a second coat, ensuring that the 2nd coat is applied at 90° to the 1st coat. typically 60-75 mins after 1st coat has been applied.



SPRAYING

- * Use a 1.4 - 2.0 mm fluid tip and 280 - 420 KPa (40 - 60 psi)
- * Use 50% overlapping strokes. Apply with a straight wrist and ensure the gun is no further than 15cm from substrate during spraying. Apply a continuous action throughout the process and do not stop until the project is completed or the Flexathane is finished.
- * Apply 1 - 2 medium coats for the desired finish
- * Clean the gun with H₂O immediately after use.

LIQUID LAMINATOR

- * If required, thin with 5-10% H₂O. Contact manufacturer if technical assistance required.

Drying Time

- * Air drying < 45mins @ 20°C
- * IR curing < 5mins

PRECAUTIONS

- * Test Flexathane suitability on substrate and inks before proceeding.
- * Clean with water and **mild** soap. Strong solvents or soaps NOT recommended.
- * Keep container sealed and store in a cool dry place. Do NOT freeze.

FLASH POINT

Not applicable - water based

PACK SIZES

- 5 Litre
- 2 Litre
- 1 Litre