



Effective 6 April, 2010

805R

FLEXIBLE ADDITIVE

Description

805R Flexible Additive is a binder.
Composition based on polycaprolacton.

Products

805R Flexible Additive

Properties

- Provides excellent flexibility in DuPont Refinish and Imron® Fleet Line 2K products.

Paint systems - conform with directive 2004/42/EC

Can be used in:

- DuPont Refinish surfacers: VR-1140, 1052R/1056R, 1220R Non-sanding, LE Primers Plus and LE Primers Plus Non-sanding;
- Imron® Fleet Line surfacers: P702/P704/P706, P702/P704/P706 Non-sanding and P504 Non-sanding;
- DuPont Refinish topcoats: Centari® 5035 and Imron® 7035;
- Imron® Fleet Line topcoats: Imron® Elite and Imron® Elite HDC;
- DuPont Refinish clears: VR-1120, 3550S, 3750S and 3800S;
- Imron® Fleet Line clears: EL500.

Paint systems - not conform with directive 2004/42/EC

Can be used in:

- DuPont Refinish surfacers: 1040R and 1220R;
- DuPont Refinish topcoats: Centari® 500, Centari® 500 HB, Centari® 501 and Imron® 700;
- Imron® Fleet Line topcoats: Imron® Traffic;
- DuPont Refinish clears: 120S, 655S, 679S, 696S and 3050S.



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RECOMMENDED USE

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
805R	1	4	1.071

Remarks

- On flexible plastic parts, the use of Full Flexible Systems is recommended. On every other plastic part, use the Semi-Flexible Systems. See information attached.
- It is not recommended to use Centari[®] 501*, 679S*, VR-1120, Centari[®] 5035, Imron[®] Traffic*, Imron[®] 7035, Imron[®] Elite and Imron[®] Elite HDC in a Full Flexible System.
- Material has to be at room temperature (18-25°C) before use.

* Product not conform with directive 2004/42/EC.

Safety

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.
















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PRODUCT PREPARATION

SEMI-FLEXIBLE SYSTEMS - SURFACERS - Conform with directive 2004/42/EC				
	VR-1140	805R	VR-1131	VR-1150
 Volume	5.4	0.6	1	0.7
Weight	93	7	11	7
 Pot life at 20°C	1 hr			
	1052R/1056R	805R	1010R	1025R
 Volume	3.6	0.4	1	1
Weight	92	8	18	16
 Pot life at 20°C	30 min			
	1052R/1056R	805R	256S	XB383
 Volume	4.5	0.5	1	1.5
Weight	92	8	15	19
 Pot life at 20°C	30 min			
	1052R/1056R	805R	XK205	XB383
 Volume	6.3	0.7	1	2.5
Weight	92	8	11	23
 Pot life at 20°C	30 min			
	LE Primers Plus	805R	AK260	XB Thinners
 Volume	4.5	0.5	1	0-0.2
Weight	93	7	14	0-3
 Pot life at 20°C	45-60 min			
	LE Primers Plus	805R	256S	XB Thinners
 Volume	3.6	0.4	1	0-0.2
Weight	93	7	17	0-3
 Pot life at 20°C	45-60 min			
	LE Primers Plus	805R	XK205	XB Thinners
 Volume	6.3	0.7	1	0.5-1
Weight	93	7	10	4-8
 Pot life at 20°C	45-60 min			















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PRODUCT PREPARATION (con'd)

SEMI-FLEXIBLE SYSTEMS - SURFACERS - Conform with directive 2004/42/EC					
	Non-sanding	1220R	805R	1010R	1030R
	Volume	4	1	3	2
	Weight	86	14	40	24
	Pot life at 20°C	3 hr			
	Non-sanding	LE Primers Plus	805R	AK260	LE2031/LE2032/LE2035
	Volume	2.7	0.3	1	2
	Weight	93	7	23	41
	Pot life at 20°C	45-60 min			
	Non-sanding	LE Primers Plus	805R	XK205/XK206	LE2031/LE2032/LE2035
	Volume	3.6	0.4	1	3
	Weight	93	7	18	46
	Pot life at 20°C	45-60 min			
	Non-sanding	P504	805R	ET Activators	ET Thinners
	Volume	4.5	0.5	1	2.5
	Weight	93	7	15	31
	Pot life at 20°C	4 hr			
		P702/P704/P706	805R	ET Activators	ET Thinners
	Volume	6.3	0.7	1	0.5-1
	Weight	93	7	10	4-8
	Pot life at 20°C	45-60 min			
	Non-sanding	P702/P704/P706	805R	ET Activators	NSC70
	Volume	3.6	0.4	1	3
	Weight	93	7	18	46
	Pot life at 20°C	45-60 min			















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PRODUCT PREPARATION (con'd)

SEMI-FLEXIBLE SYSTEMS - TOPCOATS - Conform with directive 2004/42/EC					
		Centari® 5035	805R	XK205	XB Thinners
	Volume	2.7	0.3	1	0.15
	Weight	90	10	35	5
	Pot life at 20°C	1 hr			
	30 min x 60°C	+ 1 hr air dry - tape-free			
		Imron® 7035	805R	XK205	XB Thinners
	Volume	2.7	0.3	1	0.15
	Weight	90	10	35	5
	Pot life at 20°C	1 hr			
	30 min x 60°C	+ 1 hr air dry - tape-free			
		Imron® Elite	805R	ET Activators	ET Thinners
	Volume	2.7	0.3	1	0.4-0.7
	Weight	90	10	32	14-19
	Pot life at 20°C	2 hr			
	30 min x 60°C	+ 1 hr air dry - tape-free			
		Imron® Elite HDC	805R	ET Activators	ET Thinners
	Volume	2.7	0.3	1	0.4-0.7
	Weight	90	10	32	14-19
	Pot life at 20°C	3 hr			
	30 min x 60°C	+ 1 hr air dry - tape-free			


















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SEMI-FLEXIBLE SYSTEMS - CLEARS - Conform with directive 2004/42/EC				
	VR-1120	805R	VR-1131	
 Volume	1.8	0.2	1	
Weight	89	11	51	
 Pot life at 20°C	45 min			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	3550S	805R	XK205	
 Volume	2.7	0.3	1	
Weight	89	11	36	
 Pot life at 20°C	1 hr			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	3750S	805R	XK205	XB387
 Volume	2.7	0.3	1	0.4
Weight	89	11	36	12
 Pot life at 20°C	45 min			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	3800S	805R	XK205	
 Volume	2.7	0.3	1	
Weight	89	11	37	
 Pot life at 20°C	1 hr			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	EL500	805R	ET Activators	
 Volume	2.7	0.3	1	
Weight	89	11	36	
 Pot life at 20°C	2 hr			
 30 min x 60°C	+ 1 hr air dry - tape-free			





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FULL FLEXIBLE SYSTEMS - SURFACERS - Conform with directive 2004/42/EC				
	VR-1140	805R	VR-1131	
 Volume	1	1	1.5	
Weight	60	40	59	
 Pot life at 20°C	1 hr			















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PRODUCT PREPARATION (con'd)

FULL FLEXIBLE SYSTEMS - CLEARS - Conform with directive 2004/42/EC				
	3550S	805R	XK205	XB383
 Volume	3	2	3	2
Weight	58	42	63	33
 Pot life at 20°C	30 min			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	3750S	805R	XK205	XB387
 Volume	3	2	3	1
Weight	57	42	62	17
 Pot life at 20°C	30 min			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	3800S	805R	XK205	XB Thinners
 Volume	3	2	3	1
Weight	57	42	64	17
 Pot life at 20°C	30 min			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	EL500	805R	ET Activators	ET Thinners
 Volume	3	2	3	1
Weight	57	42	63	18
 Pot life at 20°C	1 hr			
 30 min x 60°C	+ 1 hr air dry - tape-free			







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SEMI-FLEXIBLE SYSTEMS - SURFACERS - Not conform with directive 2004/42/EC				
	1040R	805R	1010R	1025R
 Volume	3.6	0.4	1	2
Weight	93	7	17	30
 Pot life at 20°C	1 hr			
	1220R	805R	1010R	1225R
 Volume	3.6	0.4	1	2
Weight	93	7	16	28
 Pot life at 20°C	3 hr			


















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PRODUCT PREPARATION (con'd)

SEMI-FLEXIBLE SYSTEMS - TOPCOATS - Not conform with directive 2004/42/EC					
		Centari® 500	805R	AK210 / 125S	AK360
	Volume	1.8	0.2	1	0.5
	Weight	90	10	45	21
	Pot life at 20°C	2 hr			
	30 min x 60°C	+ 1 hr air dry - tape-free			
		Centari® 500 HB	805R	AK260	AK360
	Volume	2.7	0.3	1	0.6
	Weight	90	10	33	17
	Pot life at 20°C	2 hr			
	30 min x 60°C	+ 1 hr air dry - tape-free			
		Centari® 501	805R	AK260	AB380
	Volume	3.6	0.4	1	1
	Weight	90	10	24	21
	Pot life at 20°C	4 hr			
	30 min x 60°C	+ 1 hr air dry - tape-free			
		Imron® 700	805R	AU270	AU370
	Volume	3.6	0.4	2	1
	Weight	90	10	48	21
	Pot life at 20°C	3 hr			
	30 min x 60°C	+ 1 hr air dry - tape-free			
		Imron® Traffic	805R	ET Activators	ET Thinners
	Volume	3.6	0.4	1	1-1.5
	Weight	90	10	24	20-30
	Pot life at 20°C	3 hr			
	30 min x 60°C	+ 1 hr air dry - tape-free			















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SEMI-FLEXIBLE SYSTEMS - CLEARS - Not conform with directive 2004/42/EC					
		120S	805R	125S	
	Volume	1.8	0.2	1	
	Weight	89	11	52	
	Pot life at 20°C	4 hr			
	30 min x 60°C	+ 2 hr air dry - tape-free			
		655S	805R	255S	
	Volume	2.7	0.3	1	
	Weight	89	11	34	
	Pot life at 20°C	30 min			
	30 min x 60°C	+ 2 hr air dry - tape-free			
		679S	805R	AK260	AB385
	Volume	2.7	0.3	1	0.6
	Weight	89	11	35	18
	Pot life at 20°C	1 hr 30 min			
	30 min x 60°C	+ 2 hr air dry - tape-free			
		696S	805R	AK260	
	Volume	2.7	0.3	1	
	Weight	89	11	35	
	Pot life at 20°C	1 hr 30 min			
	30 min x 60°C	+ 1 hr air dry - tape-free			









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SEMI-FLEXIBLE SYSTEMS - CLEARS - Not conform with directive 2004/42/EC				
	3050S	805R	AK260	
 Volume	2.7	0.3	1	
Weight	89	11	35	
 Pot life at 20°C	2 hr			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	3050S	805R	XK205	
 Volume	3.6	0.4	1	
Weight	89	11	28	
 Pot life at 20°C	2 hr			
 30 min x 60°C	+ 1 hr air dry - tape-free			







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FULL FLEXIBLE SYSTEMS - SURFACERS - Not conform with directive 2004/42/EC				
	1040R	805R	1010R	1025R
 Volume	1	1	2	0.5
Weight	58	42	78	17
 Pot life at 20°C	1 hr			
	1220R	805R	1010R	1225R
 Volume	1	1	2	0.5
Weight	60	40	73	16
 Pot life at 20°C	2 hr			












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FULL FLEXIBLE SYSTEMS - TOPCOATS - Not conform with directive 2004/42/EC				
	Centari [®] 500	805R	AK210 / 125S	AK360
 Volume Weight	3 75	1 25	3 68	1 21
 Pot life at 20°C	1 hr 30 min			
 30 min x 60°C	+ 2 hr air dry - tape-free			
	Centari [®] 500 HB	805R	AK260	AK360
 Volume Weight	3 75	1 25	2 50	1 22
 Pot life at 20°C	1 hr 30 min			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	Imron [®] 700	805R	AU270	AU370
 Volume Weight	3 75	1 25	2 50	1 21
 Pot life at 20°C	2 hr			
 30 min x 60°C	+ 1 hr air dry - tape-free			















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FULL FLEXIBLE SYSTEMS - CLEARS - Not conform with directive 2004/42/EC				
	120S	805R	125S	AK360
 Volume	1	1	2	1
Weight	47	53	98	44
 Pot life at 20°C	1 hr			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	696S	805R	AK260	AK360
 Volume	1	1	2	0.75
Weight	47	53	100	33
 Pot life at 20°C	30 min			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	3050S	805R	AK260	AK360
 Volume	1	1	2	0.75
Weight	47	53	100	33
 Pot life at 20°C	30 min			
 30 min x 60°C	+ 1 hr air dry - tape-free			
	3050S	805R	XK205	AB380
 Volume	1	1	1	0.5
Weight	47	53	50	21
 Pot life at 20°C	30 min			
 30 min x 60°C	+ 1 hr air dry - tape-free			
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