

## 805R

27.08.2014

### FLEXIBLE ADDITIVE

#### DESCRIPTION

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

#### PRODUCTS

805R                      Flexible Additive

#### PROPERTIES

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

#### PAINT SYSTEMS - CONFORM TO DIRECTIVE 2004/42/EC

Can be used in:

- Surfacer: 1051R/1057R, LE Primers Plus, LE Primers Plus Non-sanding, PS1061/ PS1064/PS1067
- Imron® Fleet Line surfacers: P702/P706.
- Topcoats: Centari® 5035.
- Imron® Fleet Line topcoats: Imron® Elite and Imron® Elite HDC;
- Clears: 3750S, 3760S and CC6400.
- Imron® Fleet Line clears: EL500.

#### PAINT SYSTEMS - NOT CONFORM TO DIRECTIVE 2004/42/EC

Can be used in:

- Surfacer: 1040R.
- Topcoats: Centari® 500, Centari® 500 HB, Centari® 501 and Imron® 700.
- Imron® Fleet Line topcoats: Imron® Traffic.
- Clears: 696S and 3050S.

#### 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\*, Centari® 5035, Imron® Traffic\*, Imron® Elite and Imron® Elite HDC in a Full Flexible System.
- Material has to be at room temperature (18-25°C) before use.













\* Product does not conform to directive 2004/42/EC.

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### PRODUCT PREPARATION

SEMI-FLEXIBLE SYSTEMS - SURFACERS - Conform to directive 2004/42/EC					
	<b>Volume Weight</b>	<b>1051R/1057R</b>	<b>805R</b>	<b>1010R</b>	<b>1025R</b>
		3.6 92	0.4 8	1 18	1 16
	<b>Pot life at 20°C</b>	30 min			
	<b>Volume Weight</b>	<b>1051R/1057R</b>	<b>805R</b>	<b>256S</b>	<b>XB383</b>
		4.5 92	0.5 8	1 15	1.5 19
	<b>Pot life at 20°C</b>	30 min			
	<b>Volume Weight</b>	<b>1051R/1057R</b>	<b>805R</b>	<b>XK205</b>	<b>XB383</b>
		6.3 92	0.7 8	1 11	2.5 23
	<b>Pot life at 20°C</b>	30 min			
	<b>Volume Weight</b>	<b>LE Primers Plus</b>	<b>805R</b>	<b>AK260</b>	<b>XB Thinners</b>
		4.5 93	0.5 7	1 14	0-0.2 0-3
	<b>Pot life at 20°C</b>	45-60 min			
	<b>Volume Weight</b>	<b>LE Primers Plus</b>	<b>805R</b>	<b>256S</b>	<b>XB Thinners</b>
		3.6 93	0.4 7	1 17	0-0.2 0-3
	<b>Pot life at 20°C</b>	45-60 min			
	<b>Volume Weight</b>	<b>LE Primers Plus</b>	<b>805R</b>	<b>XK205</b>	<b>XB Thinners</b>
		6.3 93	0.7 7	1 10	0.5-1 4-8
	<b>Pot life at 20°C</b>	45-60 min			

# TECHNICAL DATA SHEET











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### PRODUCT PREPARATION (CON'D)










SEMI-FLEXIBLE SYSTEMS - SURFACERS – Conform to directive 2004/42/EC					
	<b>Volume Weight</b>	<b>LE Primers Plus</b>	<b>805R</b>	<b>AK260</b>	<b>LE2031/LE2032/LE2035</b>
		2.7 93	0.3 7	1 23	2 41
	<b>Pot life at 20°C</b>	45-60 min			
	<b>Volume Weight</b>	<b>LE Primers Plus</b>	<b>805R</b>	<b>XK205/XK206</b>	<b>LE2031/LE2032/LE2035</b>
		3.6 93	0.4 7	1 18	3 46
	<b>Pot life at 20°C</b>	45-60 min			
	<b>Volume Weight</b>	<b>P702/P706</b>	<b>805R</b>	<b>ET Activators</b>	<b>ET745/ET750/ET755</b>
		6.3 93	0.7 7	1 10	0.5-1 4-8
	<b>Pot life at 20°C</b>	45-60 min			
	<b>Volume Weight</b>	<b>PS106xR</b>	<b>805R</b>	<b>XK206 / AR7306</b>	<b>XB Thinners</b>
		2.7 93	0.3 7	1 24	0.5 10
	<b>Pot life at 20°C</b>	45-60 min			

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







<b>SEMI-FLEXIBLE SYSTEMS - TOPCOATS - Conform to directive 2004/42/EC</b>					
	<b>Volume Weight</b>	<b>Centari® 5035</b>	<b>805R</b>	<b>XK205</b>	<b>XB Thinners</b>
		2.7 90	0.3 10	1 35	0.15 5
	<b>Pot life at 20°C</b>	1 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>Imron® Elite</b>	<b>805R</b>	<b>ET Activators</b>	<b>ET745/ET750/ET755</b>
		2.7 90	0.3 10	1 32	0.4-0.7 14-19
	<b>Pot life at 20°C</b>	2 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>Imron® Elite HDC</b>	<b>805R</b>	<b>ET Activators</b>	<b>ET745/ET750/ET755</b>
		2.7 90	0.3 10	1 32	0.4-0.7 14-19
	<b>Pot life at 20°C</b>	3 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			

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### PRODUCT PREPARATION (CON'D)

SEMI-FLEXIBLE SYSTEMS - CLEARS - Conform to directive 2004/42/EC					
	<b>Volume Weight</b>	<b>3750S/3760S</b>	<b>805R</b>	<b>XK205</b>	<b>XB387</b>
		2.7 89	0.3 11	1 36	0.4 12
	<b>Pot life at 20°C</b>	45 min			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>EL500</b>	<b>805R</b>	<b>ET Activators</b>	
		2.7 89	0.3 11	1 36	
	<b>Pot life at 20°C</b>	2 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>CC6400</b>	<b>805R</b>	<b>XK205</b>	<b>AZ9100</b>
		2.7 89	0.3 11	1 36	0.2 6
	<b>Pot life at 20°C</b>	1 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			

# TECHNICAL DATA SHEET












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### PRODUCT PREPARATION (CON'D)

FULL FLEXIBLE SYSTEMS - CLEARS - Conform to directive 2004/42/EC					
	<b>Volume Weight</b>	<b>3750S/3760S</b>	<b>805R</b>	<b>XK205</b>	<b>XB387</b>
		3 58	2 42	3 63	1 17
	<b>Pot life at 20°C</b>	30 min			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>EL500</b>	<b>805R</b>	<b>ET Activators</b>	<b>ET745/ET750/ET755</b>
		3 58	2 42	3 63	1 17
	<b>Pot life at 20°C</b>	1 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>CC6400</b>	<b>805R</b>	<b>XK205</b>	<b>XB383</b>
		3 58	2 42	3 63	2 33
	<b>Pot life at 20°C</b>	1 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			

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### PRODUCT PREPARATION (CON'D)

SEMI-FLEXIBLE SYSTEMS - SURFACERS - Not conform to directive 2004/42/EC				
	1040R	805R	1010R	1025R
 <b>Volume Weight</b>	3.6 93	0.4 7	1 17	2 30
 <b>Pot life at 20°C</b>	1 hr			

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### PRODUCT PREPARATION (CON'D)

SEMI-FLEXIBLE SYSTEMS - TOPCOATS - Not conform to directive 2004/42/EC					
	<b>Volume Weight</b>	<b>Centari® 500</b>	<b>805R</b>	<b>125S</b>	<b>AK360</b>
		1.8 90	0.2 10	1 45	0.5 21
	<b>Pot life at 20°C</b>	2 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>Centari® 500 HB</b>	<b>805R</b>	<b>AK260</b>	<b>AK360</b>
		2.7 90	0.3 10	1 33	0.6 17
	<b>Pot life at 20°C</b>	2 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>Centari® 501</b>	<b>805R</b>	<b>AK260</b>	<b>AB380</b>
		3.6 90	0.4 10	1 24	1 21
	<b>Pot life at 20°C</b>	4 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>Imron® 700</b>	<b>805R</b>	<b>AU270</b>	<b>AU370</b>
		3.6 90	0.4 10	2 48	1 21
	<b>Pot life at 20°C</b>	3 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>Imron® Traffic</b>	<b>805R</b>	<b>ET Activators</b>	<b>ET745/ET750/ET755</b>
		3.6	0.4	1	1- 1-1.5
	<b>Pot life at 20°C</b>	3 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			












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#### PRODUCT PREPARATION (CON'D)



SEMI-FLEXIBLE SYSTEMS - CLEARS - Not conform to directive 2004/42/EC					
	<b>Volume Weight</b>	<b>696S</b>	<b>805R</b>	<b>AK260</b>	
		2.7 89	0.3 11	1 35	
	<b>Pot life at 20°C</b>	1 hr 30 min			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>3050S</b>	<b>805R</b>	<b>AK260</b>	
		2.7 89	0.3 11	1 35	
	<b>Pot life at 20°C</b>	2 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
	<b>Volume Weight</b>	<b>3050S</b>	<b>805R</b>	<b>XK205</b>	
		3.6 89	0.4 11	1 28	
	<b>Pot life at 20°C</b>	2 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			










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### PRODUCT PREPARATION (CON'D)

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

FULL FLEXIBLE SYSTEMS - TOPCOATS - Not conform to directive 2004/42/EC					
		Centari® 500	805R	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			

# TECHNICAL DATA SHEET












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### PRODUCT PREPARATION (CON'D)

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

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

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### SAFETY

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

All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

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