










460 FLEX Urethane Tintable Sealer

FOR PROFESSIONAL USE ONLY

Description			
<p>460 Flex Tintable Sealer is a two-component sealer. The 460 Flex Tintable Sealer provides excellent flexibility, adhesion and holdout. This product also has good opacity, flow and leveling. 460 Flex is tinted by using all solid U-Tech intermix tints</p>			
	3 1	460 FLEX Blender U-Tech solid intermix tint	
		Use U-Tech measuring stick # 106	
	4 1	460 FLEX Urethane Tintable Sealer 460 Flex Activator	
		Use U-Tech measuring stick # 109	
		Spray gun set-up: 1.3-1.5 mm HVLP max. 10 psi at air cap	Application pressure: 40-50 psi (3-4 bar) o Check gun manufacturer specification
		2 x 1 coat Apply single coats	
		Between coats 5-10 minutes at 70°F (20°C)	
		Dry Times Dry to recoat Maximum recoat window 7 days	70°F (20°C) 20 Minutes 140°F (60°C) N/A
		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator. Dry sanding, grinding, abrading, flame cutting and/or welding of the dry paint film will produce hazardous dust and/or fumes. Wear suitable NIOSH / MSHA approved respirator to avoid inhalation. Avoid all contact with airborne particles.	

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Product and additives

Product	460 Flex Blender U-Tech Solid Intermix Tints
Hardener	460 Flex Activator
Reducers	
Additives	

Basic raw materials

460 Flex Blender: acrylic urethane resins
U-Tech Solid Intermix Tints
460 Flex Activator: polyisocyanate resin and solvent

Suitable substrates

- Existing finishes, degreased and sanded with #P320 to #P400 grit paper dry or #P500 to #P600 grit wet.
- Fiberglass gelcoat (unbroken), degreased and sanded with #P320 to #P400 grit dry.

Mixing Ratio



3 parts by volume of 460 FLEX Blender
1 part by volume of U-Tech solid intermix tint

Stir Thoroughly (or easy and accurate mixing, use the U-Tech Measuring Stick # 106)



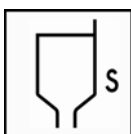
Then mix as followed:
4 parts by volume of 460 FLEX Urethane Tintable Sealer
1 part by volume of 460 Flex Activator

Stir Thoroughly (or easy and accurate mixing, use the U-Tech Measuring Stick # 109)

NOTE :

Use the 460 Flex Urethane Tintable Sealer chart for basic formulations. 460 Flex Blender is packaged in ¾ gallons to allow space for addition of the intermix tint To make 460 Flex Sealer Transparent Use T855 Binder as the one part of tint mixed with 3 parts of 460 Flex Sealer Blender

Viscosity



24 seconds ZAHN cup #2 (15 seconds DIN #4) at 70°F (20°C).



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Spray gun set-up / application pressure



Spray gun
HVLP Siphon
HVLP Gravity

Fluid tip – set-up
1.8–2.2 mm
1.3–1.5 mm

Application pressure
max. 10 psi
max. 10 psi

Application process



Apply 1-2 medium flowing coats

Pot-life

5 hours at 70°F (20°C)

Film thickness

Per coat: 0.75 mils. (20 µm)

Flash off



5-10 minutes between coats

Drying times



	70°F (20°C)	140°F (60°C)
Dry to recoat	20 minutes	N.A.

Sanding



Final dry sanding step #P400-500 before application of topcoats

Initial sanding steps may be executed with a coarser sanding grit; #P320

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Final wet sanding step #P500-600 before application of topcoats

Initial sanding steps may be executed with a coarser sanding grit; #P400



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Recoatable with

All Utech topcoat and basecoat systems (see specific technical data sheet information)

NOTE: Must be sanded if not topcoated within 7 days.

Material usage

With recommended application, the theoretical material usage is $\pm 652 - 722$ sq.ft./gl per coat.

- o *The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure, method and application circumstances.*

Cleaning of equipment

Clean equipment with solvent borne cleaners

VOC

460 Flex Blender Urethane Tintable Sealer	4.6 lb/gal	552 g/liter
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Product storage

Store products unopened, and used products with closed lids preferably between 60°F-95°F (10°C-35°C)
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

- o U-Tech Solid Intermix Tints: 2 years
- o 460 Flex Blender : 2 years
- o 460 Flex Activator: 12 months
- o 460 Flex Blender Urethane Tintable Sealer: 2 years

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IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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