



Flex Additive

47474SP/04

Matthews Flex Additive 47474SP/04 is designed to be used in conventional Matthews Acrylic Polyurethane topcoats.

47474SP/04 can also be used in SVOC topcoats as well as VOC and SVOC clears if VOC is not a concern. Due to the flexible nature of MAP-LV topcoats and clears, flex additive is not necessary.

47474SP/04 provides flexibility to the coating which will allow pliable substrates to withstand flexing and impact during fabrication or service.



Compatible Surfaces:

Flexible Matthews Topcoats and Clears may be applied over properly prepared flexible substrates such as:

- Acrylic
- Cooley
- Flexible Faces
- Panaflex
- Polycarbonate
- Trim Cap
- Vinyl

Associated Products:

Any Matthews Conventional or Low VOC colors (including associated catalysts and reducers)

Any Matthews Conventional or Low VOC clears (including associated catalysts and reducers)

***NOTE: 47474SP/04 Flex Additive is not to be used in Matthews Ultra Low VOC topcoats or clears.**

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Directions for Use

Surface Preparation:

Substrate should be prepared according to Matthews Substrate Preparation Guide prior to topcoat application.

Mix Ratio:



Mix Ratio for Spraying (by volume)

Any Matthews
SOA, N, or SV color/clear : Catalyst* : Reducer* + 47474SP/04

3 parts : 1 part : 1 part + 1/2 part

*Refer to Technical Data Sheet (TDS) for Matthews Topcoat or Clear being used.

All components should be mixed thoroughly before using.
Strain material after mixing.



Pot Life: 8 hours

Pot-life is the amount of time before spray viscosity doubles. These are estimates based on lab results at 50% relative humidity, 70°F/21°C—results will vary based on application conditions and reducer selection.

Note: mix no more product than can be used within pot life.

Additives:



None

Spray Set Up:



Air Pressure: Conventional: 40 - 50 psi at the gun*
HVLV: 10 psi at the cap*

* Refer to spray gun manufacturer recommendations for inlet pressure.



Pressure Pot Fluid Delivery: 8 - 12 Fluid Ounces per Minute



Gun Set Up: Siphon Feed: 1.2 - 1.4 mm 0.047 - 0.055 fluid tip
HVLV: 1.2 - 1.4 mm 0.047 - 0.055 fluid tip
Pressure Pot: 1.0 - 1.2 mm 0.039 - 0.047 fluid tip

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Directions for Use

Application:



Apply:

Apply two full wet coats, allowing proper flash time* between coats. Apply additional coats as necessary to achieve total dry film thickness and/or metallic control.

*Flash times will vary dependent upon film thickness, temperature, spray gun set-up, application, etc.

Recommended		Per Coat	Total
Film Thickness:	Wet Film Thickness (WFT)	3.0 - 4.0 mils	6.0 - 8.0 mils
	Dry Film Thickness (DFT)	1.0 mil	2.0 mils

Caution: All 2-component crosslinking slows significantly at temperatures below 60°F or 16°C. Never spray or subject freshly painted coatings to these conditions or loss of gloss, decreased durability and improper curing can occur.

Estimated Drying Times*:



Air-Dry @ 50% Relative Humidity, 70°F/21°C

Dust Free	15 minutes
Set to Touch	30 minutes - 1 hour
Dry to Handle	1.5 - 2 hours
Tape Time	16 hours
Vinyl Application	48 hours
Reflective Vinyl Application	96 hours

Recoating: Paint films cured over 24 hours should be cleaned, lightly dry scuff sanded with 320 - 400g by hand/machine or wet sanded with 600g, then cleaned again before recoating.

Equipment Cleaning:

Clean equipment promptly with lacquer thinner or equivalent cleaning solvent.

Note: Do not leave mixed material in equipment.

Technical Data:

VOC Information (conventional topcoats and clears)

VOC Actual RTS	4.89 - 5.34 lbs/gal
VOC Actual RTS	586 - 640 g/L
VOC Regulatory (less water less exempt) RTS	4.89 - 5.34 lbs/gal
VOC Regulatory (less water less exempt) RTS	586 - 640 g/L

3.5 VOC Information (VOC and SVOC topcoats and clears with Low VOC reducers)

VOC Actual RTS	2.03 - 2.94 lbs/gal
VOC Actual RTS	243 - 352 g/L
VOC Regulatory (less water less exempt) RTS	3.23 - 3.25 lbs/gal
VOC Regulatory (less water less exempt) RTS	387 - 389 g/L

3.5 VOC Information (VOC and SVOC topcoats and clears with Exempt reducers)

VOC Actual RTS	1.45 - 2.35 lbs/gal
VOC Actual RTS	174 - 282 g/L
VOC Regulatory (less water less exempt) RTS	2.72 - 2.87 lbs/gal
VOC Regulatory (less water less exempt) RTS	326 - 344 g/L

For complete VOC information, visit MatthewsPaint.com > Quick Links > VOC Data

Performance Characteristics

Volume solids (RTS)	27 - 48.3%
Theoretical Coverage (1 mil @ 100% transfer efficiency)	433 - 774 sq.ft./RTS gal
Application Conditions - Temperature	100°F (38°C) Maximum
Application Conditions - Relative Humidity	85% maximum 5° above dew point

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Important: The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION - US (412) 434-4515; CANADA (514) 645-1320; Mexico 01-800-00-21-400
Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Matthews Paint. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Matthews Paint warrant freedom from patent infringement in the use of any formula or process set forth herein. If you require technical assistance, please call us toll-free 800/323-6593.



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