

PRODUCT DATA SHEET

FLEXPRO, A 2410

(Adhesion promotor plastic)

Z

Application

plastic painting



Description:

- good adhesion to various plastics
- high efficiency
- to be used i. e. in GHD SURFACER WHITE

Substrates:

- = very well suited
- = well suited
- = suited in some cases

Steel	
Galv. Steel	
Stainless steel	
Aluminium	
Anodized Aluminium	
GRP / SMC	
PP-EPDM	●●
RM CV-Primer	
RM CV-Primer-Filler / Filler	
Powder	
Coil-Coating	
Plywood	
Wood	
OEM Paint work	●
Old paint work	●

Remarks:

The substrate should be clean, free of dust, rust, oil and grease

Special remarks

- The products are suitable for professional use only.
- It cannot be ruled out that this product contains particles < 0.1 µm



Paint process

P 5

Spreading rate

≈ 408 m² / l / 1µm

Solid content

≈ 8 %

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Pre-mix

mix FLEXPRO (70 parts) with GV 200 (30 Parts)



Mixing ratio

100:50 +10 - 30% by volume (GHD SURFACER WHITE)



Hardener

H 380



Reducer

FLEXPRO pre-mix



Spray viscosity DIN 4 / 20°C

20 – 22s DIN4mm

Potlife 20°C

2 h

Application



Compliant-gravity feed cup



HVLP-Spray gun



Suction cup



Airless/Airmix (ESTA)



Pressure pot/ Dble membr. Pump

	bar	2,2 - 2,5	2,0	2,5	2	2,5
Atomization pressure	bar	-	-	-	120 - 150	0,8 - 1,5
Material pressure	mm	1,4 - 1,6	1,5 - 1,7	1,7	0,28 - 0,33	1,0 - 1,1
Nozzle size	kV	-	-	-	60 - 70	-
Voltage	Ω	-	-	-	600 - 800	-
Elect. Resistance		1 - 2	1 - 2	1 - 2	1	1 - 2
Number of spraycoats	min.	without	without	without	without	without
Flash off	μm	20 - 30 *				
Filmbuild						



Drying



over-coatable



tack free



tapeable



ready to assemble



sandable

Min. Max.

Panel temperat. 20°C 60 min 72 h

Panel temperat. 60°C 30 min

Remarks



*ABS, GRP, SMC, PC: GHD SURFACER WHITE with H380 and GV 300/400 (100:50:10-30%);

PA, PP-EPDM, GHD SURFACER WHITE with H380 and FLEXPRO (100:50:10-30%);

PP, PE: (adhesion can not be guaranteed) GHD SURFACER WHITE with H380 and

FLEXPRO (100:50:10-30%);

*Higher dry film thickness possible (50-60 μm)

Attention: Due to different raw material supplier the quality of the different plastics can be differ from time to time. The adhesion should be checked individual before painting.

See D-Part Tables Painting of various Plastic and/or Painting Process P 5 for further details

