



Effective 24 May, 2008

# 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<sup>®</sup> Fleet Line 2K products.

### Paint systems - conform with directive 2004/42/EC

Can be used in:

- DuPont Refinish surfacers: LE Primers Plus and LE Primers Plus Non-sanding;
- Imron<sup>®</sup> Fleet Line surfacers: P702/P704/P706, P702/P704/P706 Non-sanding and P504 Non-sanding;
- DuPont Refinish topcoats: Centari<sup>®</sup> 5035 and Imron<sup>®</sup> 7035;
- Imron<sup>®</sup> Fleet Line topcoats: Imron<sup>®</sup> Elite and Imron<sup>®</sup> Elite HDC;
- DuPont Refinish clears: 3550S and 3750S;
- Imron<sup>®</sup> Fleet Line clears: EL500.

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

Can be used in:

- DuPont Refinish surfacers: 1040R and 1141S/1144S/1147S;
- DuPont Refinish topcoats: Centari<sup>®</sup> 500, Centari<sup>®</sup> 500 HB, Centari<sup>®</sup> 501 and Imron<sup>®</sup> 700;
- Imron<sup>®</sup> Fleet Line topcoats: Imron<sup>®</sup> Traffic;
- DuPont Refinish clears: 120SX, 676S, 696S and 7600S.



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### RECOMMENDED USE

Products	Packages (l)	Shelf life at 20°C (year)
805R	1	2

### 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<sup>®</sup> 501\*, 676S\*, 7600S\*, Centari<sup>®</sup> 5035, Imron<sup>®</sup> Traffic\*, Imron<sup>®</sup> 7035, Imron<sup>®</sup> Elite and Imron<sup>®</sup> 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					
		<b>LE Primers Plus</b>	<b>805R</b>	<b>AK260</b>	<b>XB Thinners</b>
	<b>Volume</b>	4.5	0.5	1	0-0.2
	<b>Weight</b>	93	7	14	0-3
	<b>Pot life at 20°C</b>	45-60 min			
		<b>LE Primers Plus</b>	<b>805R</b>	<b>256S</b>	<b>XB Thinners</b>
	<b>Volume</b>	3.6	0.4	1	0-0.2
	<b>Weight</b>	93	7	17	0-3
	<b>Pot life at 20°C</b>	45-60 min			
		<b>LE Primers Plus</b>	<b>805R</b>	<b>XK205</b>	<b>XB Thinners</b>
	<b>Volume</b>	6.3	0.7	1	0.5-1
	<b>Weight</b>	93	7	10	4-8
	<b>Pot life at 20°C</b>	45-60 min			
	<b>Non-sanding</b>	<b>LE Primers Plus</b>	<b>805R</b>	<b>AK260</b>	<b>LE2031/LE2032/LE2035</b>
	<b>Volume</b>	2.7	0.3	1	2
	<b>Weight</b>	93	7	23	41
	<b>Pot life at 20°C</b>	45-60 min			
	<b>Non-sanding</b>	<b>LE Primers Plus</b>	<b>805R</b>	<b>XK205/XK206</b>	<b>LE2031/LE2032/LE2035</b>
	<b>Volume</b>	3.6	0.4	1	3
	<b>Weight</b>	93	7	18	46
	<b>Pot life at 20°C</b>	45-60 min			



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## PRODUCT PREPARATION (con'd)

SEMI-FLEXIBLE SYSTEMS - SURFACERS - Conform with directive 2004/42/EC					
	<b>Non-sanding</b>	<b>P504</b>	<b>805R</b>	<b>ET Activators</b>	<b>ET Thinners</b>
	<b>Volume</b>	4.5	0.5	1	2.5
	<b>Weight</b>	93	7	15	31
	<b>Pot life at 20°C</b>	4 hr			
		<b>P702/P704/P706</b>	<b>805R</b>	<b>ET Activators</b>	<b>ET Thinners</b>
	<b>Volume</b>	6.3	0.7	1	0.5-1
	<b>Weight</b>	93	7	10	4-8
	<b>Pot life at 20°C</b>	45-60 min			
	<b>Non-sanding</b>	<b>P702/P704/P706</b>	<b>805R</b>	<b>ET Activators</b>	<b>NSC70</b>
	<b>Volume</b>	3.6	0.4	1	3
	<b>Weight</b>	93	7	18	46
	<b>Pot life at 20°C</b>	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
	<b>Volume</b>	2.7	0.3	1	0.15
	<b>Weight</b>	90	10	35	5
	<b>Pot life at 20°C</b>	1 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
		Imron® 7035	805R	XK205	XB Thinners
	<b>Volume</b>	2.7	0.3	1	0.15
	<b>Weight</b>	90	10	35	5
	<b>Pot life at 20°C</b>	1 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
		Imron® Elite	805R	ET Activators	ET Thinners
	<b>Volume</b>	2.7	0.3	1	0.4-0.7
	<b>Weight</b>	90	10	32	14-19
	<b>Pot life at 20°C</b>	2 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
		Imron® Elite HDC	805R	ET Activators	ET Thinners
	<b>Volume</b>	2.7	0.3	1	0.4-0.7
	<b>Weight</b>	90	10	32	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 with directive 2004/42/EC					
		EL500	805R	ET Activators	
	<b>Volume</b> <b>Weight</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			






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## PRODUCT PREPARATION (con'd)

FULL FLEXIBLE SYSTEMS - CLEARS - Conform with directive 2004/42/EC					
		EL500	805R	ET Activators	ET Thinners
	Volume Weight	3 57	2 42	3 63	1 18
	Pot life at 20°C	1 hr			
	30 min x 60°C	+ 1 hr air dry - tape-free			







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## FLEXIBLE ADDITIVE

### PRODUCT PREPARATION (con'd)

SEMI-FLEXIBLE SYSTEMS - SURFACERS - Not conform with directive 2004/42/EC					
		1040R	805R	1010R	1025R
	<b>Volume</b>	3.6	0.4	1	2
	<b>Weight</b>	93	7	17	30
	<b>Pot life at 20°C</b>	1 hr			
		1141S/1144S/1147S	805R	1125S	1175S
	<b>Volume</b>	4.5	0.5	1	1
	<b>Pot life at 20°C</b>	50-60 min			























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## FLEXIBLE ADDITIVE

### PRODUCT PREPARATION (con'd)

SEMI-FLEXIBLE SYSTEMS - TOPCOATS - Not conform with directive 2004/42/EC					
		Centari® 500	805R	AK210	AK360
	<b>Volume</b>	1.8	0.2	1	0.5
	<b>Weight</b>	90	10	45	21
	<b>Pot life at 20°C</b>	2 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
		Centari® 500 HB	805R	AK260	AK360
	<b>Volume</b>	2.7	0.3	1	0.6
	<b>Weight</b>	90	10	33	17
	<b>Pot life at 20°C</b>	2 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
		Centari® 501	805R	AK260	AB380
	<b>Volume</b>	3.6	0.4	1	1
	<b>Weight</b>	90	10	24	21
	<b>Pot life at 20°C</b>	4 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
		Imron® 700	805R	AU270	AU370
	<b>Volume</b>	3.6	0.4	2	1
	<b>Weight</b>	90	10	48	21
	<b>Pot life at 20°C</b>	3 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
		Imron® Traffic	805R	ET Activators	ET Thinners
	<b>Volume</b>	3.6	0.4	1	1-1.5
	<b>Weight</b>	90	10	24	20-30
	<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 with directive 2004/42/EC					
		<b>120SX</b>	<b>805R</b>	<b>AK210</b>	
	<b>Volume</b>	1.8	0.2	1	
	<b>Weight</b>	89	11	49	
	<b>Pot life at 20°C</b>	4 hr			
	<b>30 min x 60°C</b>	+ 2 hr air dry - tape-free			
		<b>676S</b>	<b>805R</b>	<b>AK260</b>	<b>AB385</b>
	<b>Volume</b>	2.7	0.3	1	0.6
	<b>Weight</b>	89	11	35	18
	<b>Pot life at 20°C</b>	1 hr 30 min			
	<b>30 min x 60°C</b>	+ 2 hr air dry - tape-free			
		<b>696S</b>	<b>805R</b>	<b>AK260</b>	
	<b>Volume</b>	2.7	0.3	1	
	<b>Weight</b>	89	11	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>7600S</b>	<b>805R</b>	<b>7675S</b>	
	<b>Volume</b>	3.6	0.4	1	
	<b>Weight</b>	89	11	26	
	<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)

FULL FLEXIBLE SYSTEMS - SURFACERS - Not conform with 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			
		1141S/1144S/1147S	805R	1125S	1175S
	Volume	5	1.5	3	1
	Pot life at 20°C	50-60 min			



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## PRODUCT PREPARATION (con'd)

FULL FLEXIBLE SYSTEMS - TOPCOATS - Not conform with directive 2004/42/EC					
		Centari <sup>®</sup> 500	805R	AK210	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 <sup>®</sup> 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 <sup>®</sup> 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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### PRODUCT PREPARATION (con'd)

FULL FLEXIBLE SYSTEMS - CLEARS - Not conform with directive 2004/42/EC					
		120SX	805R	AK210	AK360
	<b>Volume Weight</b>	1 47	1 53	2 94	1 44
	<b>Pot life at 20°C</b>	1 hr			
	<b>30 min x 60°C</b>	+ 1 hr air dry - tape-free			
		696S	805R	AK260	AK360
	<b>Volume Weight</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			
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.					