

---

## FLEX ADDITIVE

---

**DESCRIPTION:** A universal flex additive for all Lesonal urethane materials.

---

**PRODUCT & ADDITIVES:**

**MAIN PRODUCT:** Lesonal Flex Additive

**BASIC RAW**

**MATERIALS:** Special Polyester Resin.

---

**APPLICATION:**


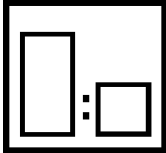
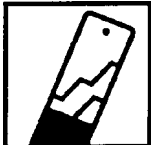
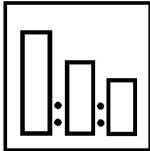

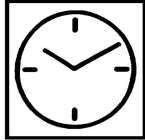
**SUITABILITY:** Flex Additive is suitable to be added to the following products:

- Grey Urethane Surfacer
- Grey Urethane Surfacer (Low VOC)
- HS Surfacer/Sealer
- LV HS Surfacer/Sealer
- Lesonal Clearcoats

**NOTE:** Do not use Flex Additive in Basecoat SB

---

**APPLICATION:** **Example: To prepare Universal Clear for flexible parts.**

1.  Contains butyl acetate, methylamyl ketone, xylene and other ingredients. When mixed also contains isocyanates
2.  100:10%  
Lesonal Universal Clear  
Flex Additive
3.  Mixing stick : Use the measuring increments on the side of any mixing stick, 100:10%. Stir Thoroughly.
4.  3:1:1  
Universal Clear with Flex  
Additive  
Lesonal Clear Hardener  
Lesonal Fast Activator
5.  Refer to the Technical Data Sheet.
6.  5 hours at 70°F (20°C)  
20 minutes at 140°F (60°)

## FLEX ADDITIVE

**MIXING RATIO:** 100:10%, 5:1 or 3:1 (SEE TABLE BELOW)

For Universal Clear mix 100 parts of clear then 10% Lesonal Flex Additive. For other products mix 5 Parts or 3 Parts of Product with one part of Lesonal Flex Additive. Stir this mixture and add the correct amount of hardener and reducer.

### APPLICATION

#### METHOD:

Application method will not change by adding Flex Additive to the products. Please see the technical data sheets relative to the product chosen for correct application and mixing ratios.

The use of Lesonal™ Flex Additive depends on the flexibility of the plastic part. Flexible parts are categorized as follows:

Degree of flexibility	Example
Hard	Mirror
Flexible	Bumper cover
Soft	Spoiler

Use the following table to identify how much Flex Additive is required:

	Hard Parts	Flexible Parts	Soft Parts
Gray Urethane Surfacer without Flex Additive	X		
Gray Urethane Surfacer mixed 5:1 with Flex Additive		X	
Gray Urethane Surfacer mixed 3:1 with Flex Additive			X
Gray Urethane Surfacer (Low VOC) without Flex Additive	X		
Gray Urethane Surfacer (Low VOC) mixed 5:1 with Flex Additive		X	
Gray Urethane Surfacer (Low VOC) mixed 3:1 with Flex Additive			X
HS Surfacer/Sealer without Flex Additive	X		
HS Surfacer/Sealer Mixed 4:1 with Flex Additive		X	
HS Surfacer/Sealer Mixed 3:1 with Flex Additive			X
LV HS Surfacer/Sealer without Flex Additive	X		
LV HS Surfacer/Sealer Mixed 5:1 with Flex Additive		X	
Lesonal Clearcoats without Flex Additive	X		
Lesonal Clearcoats mixed 5:1 with Flex Additive		X	
Lesonal Clearcoats mixed 3:1 with Flex Additive			X
Lesonal Universal Clear 100:10% with Flex Additive		X	X



---

**FLEX ADDITIVE**

---

**COLOR:** Clear

**SHELF LIFE:** 2 years if stored unopened at 70°F (20°C).

---

**SAFETY ASPECTS:**

**VOC CONTENT:** Lesonal™ Flex Additive: 3.0 lb/gal (360 g/liter)

**NOTICE:** Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all products with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.