

2014 Sign Training
• GRIP-GARD BC FLEX



Sign Finishes



AkzoNobel

PICTOGRAM DESCRIPTION



Degrease



Machine sand dry



Hand sand wet



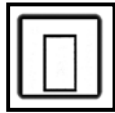
Hand sand dry



Scotch Brite



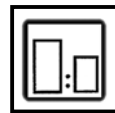
Use Akzo Measuring Stick



Ready to Spray



Mixing Ratio: 2 components, equal portions



Mixing Ratio: 2 components



Mixing Ratio: 3 components



Stir



Siphon Feed Spray gun



Gravity Spray gun



Application Method: Siphon gun



Application Method: Gravity gun



Polish



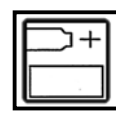
Flash-off



Drying time



Use fresh air mask or charcoal respirator



Addition of catalyst



Store free from frost



Store in a cool place



Protect from Humidity



Close can



See Technical Data Sheet



Brush



Roller



***GRIP-GARD® BC
FLEX SYSTEM***

05/2014

GRIP-FLEX T-4000 Surface Cleaner

T-4000 IS A MILD SOLVENT BASED CLEANER FOR USE ON MOST PLASTIC SUBSTRATES. ALSO CAN BE USED AS A PAINT REMOVER ON MANY SUBSTRATES.



Contains blend of alcohol solvents. A solvent protecting respirator should be used especially when working in confined areas and always wear gloves when degreasing.

**VOC Content
6.6 lbs./gal.**

SUITABLE SURFACES:

Polycarbonate, acrylic, ABS, styrene and most rigid PVC substrates.

SUBSTRATE PRE-CLEANING METHOD



With clean lint free rags, wash down the area to be painted with T-4000 to remove surface contaminants.



With clean lint free wiping towels, remove the T-4000 before it has time to evaporate.

TO REMOVE STATIC ELECTRICITY



Blend equal parts of T-4000 and clean water. A mix ratio of 1:1 by volume.



Using a clean chamois, wipe the area to be painted.

GRIP-FLEX T-4000 Surface Cleaner

TO REMOVE PAINT



- Pour a liberal amount of pure T4000 into the pan and allow to dissolve the old face paint.
- Using clean rags, wash down and wipe away the paint to be removed. Change rags frequently. Keep contact time to a minimum.

NOTES:

- When removing paint always test a small area first to assure T-4000 does not damage the plastic.

GRIP-MASK STRIPPABLE MASKANT

A WATER BASE TRANSPARENT STRIPPABLE COATING FOR USE IN THE DECORATION OF MULTI-COLORED PLASTIC SIGNAGE.



Contains emulsified resins, plasticizers, water and other ingredients.

RTS
0.0
lbs./gal.

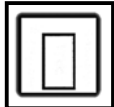
SUITABLE SURFACES:

Polycarbonate, Acrylic, impact modified acrylic, ABS, Styrene, and many flexible rigid and flexible vinyl's.

PREPARATION:



Clean plastic with T-4000. Remove static electricity with a 1:1 solution of T-4000 and clean water.



Ready to spray

POTLIFE:

3 weeks after opening container

SHELF LIFE:

6 months minimum in unopened containers



Airless	.017-.023"	0.44-0.59 mm
Siphon Feed:	.086"	2.2 mm
Pressure Feed:	.078-.086"	2.0-2.2 mm
HVLP	.070-.110"	1.8-2.8 mm

GRIP-MASK STRIPPABLE MASKANT

APPLICATION:



Apply 20-25 wet mils. Approximately 3 coats with an airless applicator. More coats required with conventional spray equipment.



No flash time between coats is required.



- 12 – 24 hours at 65 - 95°F (18 - 35°C) 50%RH
- Grip-Mask May be force dried at 100 to 110°F
- Increasing the air flow over the Grip-Mask will reduce the dry times



Keep from freezing.



NOTES:

- Preferred application method is airless.
- Not for use on bare metal surfaces.
- Low film thickness results in poor stripping properties.

GRIP-GARD® BC

Transparent Reducers

GRIP-GARD BC FLEX REDUCERS ARE USED TO OPTIMIZE THE APPLICATION PROPERTIES OF GRIP-FLEX PLASTIC SIGN PAINTS.



The flash time of the product can be adjusted for both temperature and job size.

Grip-Gard BC Flex Reducers

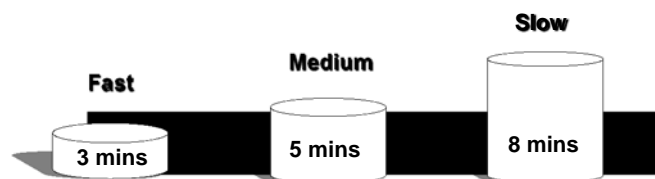
Fast:	60°F-75°F	16°C-24°C
Medium :	70°F-85°F	20°C-30°C
Slow:	above 85°F	30°C



The drying time does not change from one reducer to the other when used in the recommended temperature ranges.



Flash at
70°F/20°C



Translucent Plastic Face Paint

GRIP-GARD® BC Binder #50

A SPECIAL BINDER USING THE GRIP-GARD BC TONER SYSTEM AS A TRANSPARENT Or OPAQUE PLASTIC SIGN PAINT.



Contains physical drying resins, solvents and other ingredients.

SUITABLE SURFACES:

Polycarbonate, acrylic, impact modified acrylic, ABS, styrene and many rigid and flexible vinyl's.

PREPARATION:



Clean plastic surface with T-4000. Remove static electricity with a 1:1 solution of T-4000 and clean water using clean white paper towels.

MIXING COLOR:



Choose the color required in Mixit.
When the product selection window appears choose the product marked BCTR
(BC Transparent)



NOTE:

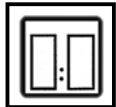
- Any Toner Can be used directly from the GGBC Mixing bank. Add 1 part toner to 3 parts binder for transparent or 1 part toner to 1 part binder for Opaque.
- For Black Colors use Toner #140
- For White Colors use toner #120

Translucent Plastic Face Paint

GRIP-GARD® BC Binder #50

MIXING RATIOS

Transparent colors from Mixit :



100 parts volume GRIP-GARD BC Transparent formula
100 parts volume GRIP-GARD BC Transparent Reducer
Fast, Medium or Slow

Black, Aluminum or stock colors:



100 parts GRIP-GARD BC 140 Black or Stock Formula
50 parts GRIP-GARD BC Binder **#90**
Then
100 parts volume GRIP-GARD BC Transparent formula
50 - 100 parts volume GRIP-GARD BC Transparent
Reducer Fast, Medium or Slow

POTLIFE:

1 year



Siphon Feed: 1.4 - 1.7 mm
Gravity Feed: 1.3 - 1.5 mm

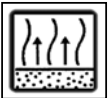
Translucent Plastic Face Paint

GRIP-GARD® BC Binder #50

APPLICATION TRANSPARENT COLORS:



Apply 4 - 8 single coats or until desired opacity is achieved.



2-5 minutes Flash between coats or until touch free

APPLICATION BLACK, STOCK or SILVER METALLIC COLOR:



Apply 2 - 4 single coats or until covered.



2-5 minutes Flash between coats or until dull



Dry to remove maskant	30 minutes
Dry to recoat	30 minutes
Dry to re-Grip-Mask	2 hours
Dry for installation	24 hours



NOTE:
Any color used in an opaque scenario should be mixed the same manner as a black or stock color.

GRIP-GARD BC TRANSPARENCY ADD

This is a clear blend which can be mixed and kept in stock. You can add this mixture to all ready to spray colors to increase the transparency and reduce color mottling for difficult colors



Contains acrylic resins, solvents and other ingredients.

SUITABLE SURFACES:

When added to the RTS Color, this can be applied to Polycarbonate, acrylic, impact modified acrylic, ABS, styrene and many rigid and flexible vinyl's.

MIXING:

1 part GRIP-GARD BC Toner 070 Transparency Enhancer
3 parts GRIP-GARD BC Binder #50

Then Mix

100 parts of this clear blend
100 parts volume GRIP-GARD BC Transparent Reducer
Fast, Medium or Slow

After the mixing is complete, this clear additive can be added to the ready to spray color at any level needed to increase the transparency of the color and to reduce mottling

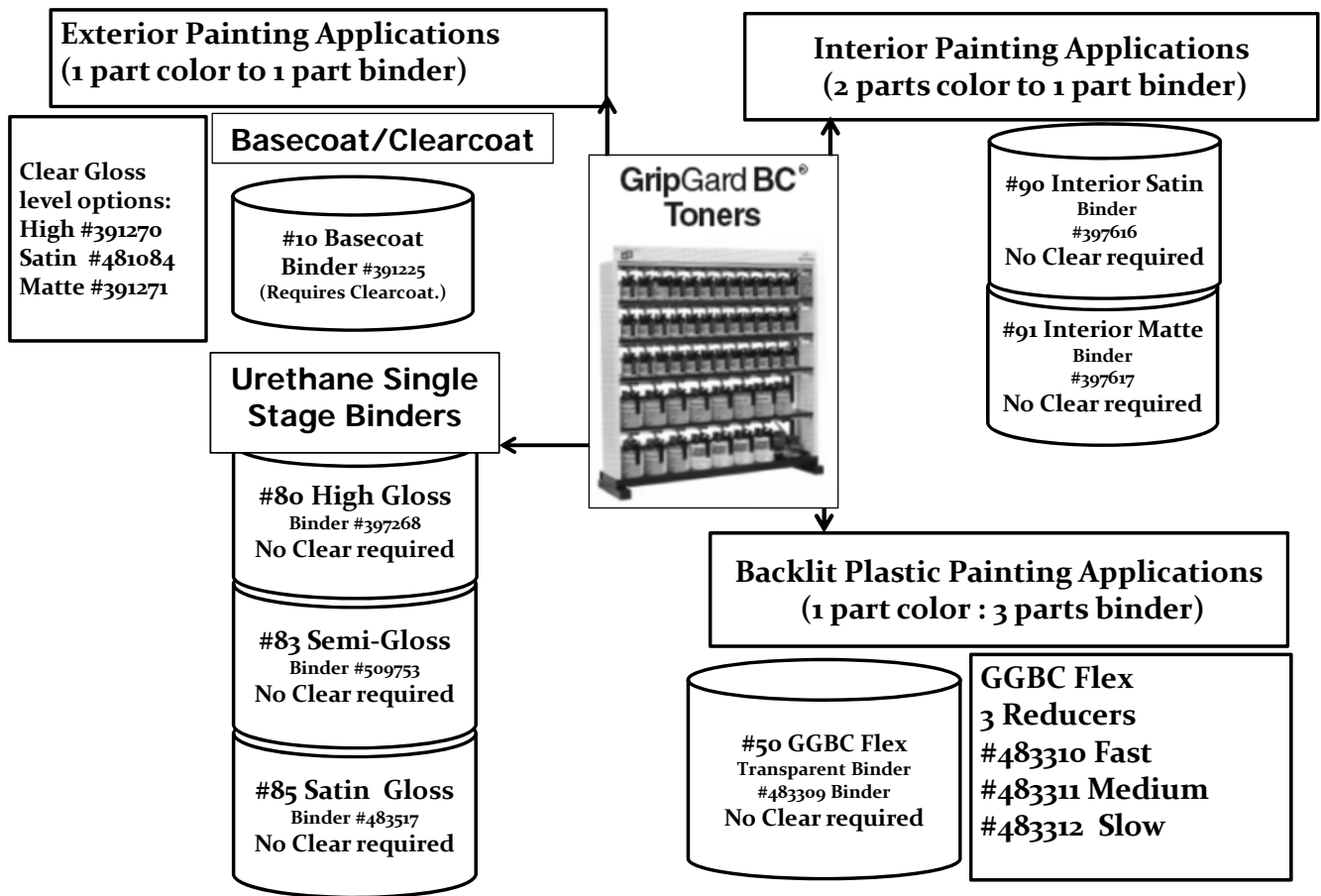
POTLIFE:

None



Siphon Feed:	1.6 - 1.8 mm
Pressure Feed:	1.0-1.2 mm
Gravity Feed:	1.3-1.5 mm

GRIP-GARD® BC Binder Options





Sign Finishes



AkzoNobel