**THIXON™ 423 Clear**

**Description**
THIXON™ 423 Clear is a vulcanizing adhesive which can be used as a one-coat adhesive or as a covercoat adhesive over THIXON™403/404 adhesive primer for bonding castable polyurethane to various substrates. THIXON™423 can also be used as a one-coat adhesive for bonding thermoplastic polyurethanes to metal. THIXON™423 can also be used as a protective coating for metal, polyurethane, epoxy, polyester and fiberglass compounds.

**Benefits & Features**
Good one-coat system for Thermoplastic Urethane to metal bonding with better heat resistance than THIXON™ 405.

<table>
<thead>
<tr>
<th>Uncured Properties</th>
<th>Nominal Value</th>
<th>Unit</th>
<th>Test Method</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Blue</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Solids Content</td>
<td>20 %</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Density</td>
<td>0.923 to 0.947</td>
<td>g/cm³</td>
<td>ASTM D2369</td>
</tr>
<tr>
<td>Dry Film Density</td>
<td>0.95</td>
<td>g/cm³</td>
<td></td>
</tr>
<tr>
<td>VOC Content</td>
<td>5.10</td>
<td>lb/gal</td>
<td></td>
</tr>
<tr>
<td>Flash Point</td>
<td>-4.00</td>
<td>°C</td>
<td></td>
</tr>
<tr>
<td>Viscosity (25°C, Brookfield RVT)</td>
<td>0.18 to 0.40</td>
<td>Pa·s</td>
<td>ASTM D1084</td>
</tr>
<tr>
<td>Viscosity (25°C)</td>
<td>19</td>
<td>sec</td>
<td>Zahn Cup 3</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>18.5</td>
<td>m²/l</td>
<td></td>
</tr>
<tr>
<td>Recommended Film Thickness</td>
<td>15</td>
<td>µm</td>
<td></td>
</tr>
<tr>
<td>Recommended Film Thickness Range</td>
<td>15 to 50</td>
<td>µm</td>
<td></td>
</tr>
<tr>
<td>Shelf Life (25°C)</td>
<td>24</td>
<td>month</td>
<td></td>
</tr>
</tbody>
</table>

**Elastomer**
Castable Urethanes with the use of THIXON™ 403/404 primers or Thermoplastic Urethane (TPU)

**Substrate**
CRS, Phosphate or grit blast pre-treated CRS, Aluminum, Stainless Steel, fiberglass, polyester, nylon, rayon fibers, etc.

**Surface Prep**
Review Dow’s rubber-to-substrate bonding agent application guide or contact your account manager.

**Mix Instructions**
Diluent - PM acetate, or THIXON™ 917 solvent blend should be mixed into THIXON™ 423 Blue to ensure consistent and uniform coating color.

**Application Technique**
Brushing: for brush applications use undiluted. Brush on a heavy wet film of THIXON™ 423 without brushing excessively. To obtain the required film thickness, brush on two coats. Dip - For dip applications, dilute 3 parts THIXON™ 423 with 1 part diluent. To obtain a film thickness of 1 mil, dip twice.

**Drying the Film**
Dry the film of THIXON™ 423 before continuing. At normal room temperature, dry for 30 to 45 minutes. At lower temperatures, dry longer. The drying time can be shortened by force drying approximately 5 to 10 minutes at 120 to 160°F. Do not dry at temperatures above 180°F.

**Molding and Curing**
Most molding and curing methods. Use a cure temperature between 190 to 350°F.

**Pre-Bake Resistance**
For the best results, prebake the coated metals for ½ to 3 hours at 200 to 300°F, depending on the weight of the metal. This product can withstand prebaking in forced air convection ovens, with proper ventilation, for up to 16 hours at 250°F.

**Dry Film Stability**
Excellent dry film stability. Inserts which have been coated can be stored for several weeks before use, if they are protected from airborne contaminants.

**Clean-up**
Equipment clean up should be done using recommended dilution solvents.

**Packaging/Sizes Available**
Drums, pails and gallon cans.
Storage & Stability
The shelf life of this material is assured for 24 months (from the date of manufacture) at temperatures below 78°F in an unopened container.

Toxicity and Safety Information
Read the Safety Data Sheet before using this material. Toxicity and safety information is included in the SDS.

Food Contact Applications
Dow Automotive products are not approved for direct or indirect food contact or drinking water applications. If your applications include food contact or drinking water requirements, please contact your Dow representative. For more information on the regulatory status of this product, please refer to the SDS for this product.

Notes
These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

1 By volume
2 Non-volatile solids by weight
3 SetaFlash Closed Cup
4 Spindle #1, @ 20 RPM
5 Applied at a dry film thickness of 15 microns/0.6 mils
6 Unopened
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c. use as a critical component in medical devices that support or sustain human life; or

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