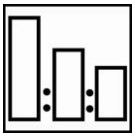
Autoclear Rapid Air AS

FOR PROFESSIONAL USE ONLY

Description

Autoclear Rapid Air AS is a fast two pack air-drying antiscratch clearcoat with a dust-free time of only 5 minutes. Its speed and great polishability make it suitable for quick turnaround tasks in all spraying conditions. The product is easily mixed using a dedicated hardener and universal Plus reducers and easy to use due to its long potlife. The product is especially designed for use with Autowave 2.0



100	Autoclear Rapid Air AS
50	Autoclear Rapid Air AS Hardener
20	Autoclear LV Superior Accelerator / Plus Reducers



Use Sikkens measuring stick

3 Purple

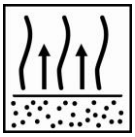


Spray gun set-up:
1.2-1.4 mm

Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



2 x 1 coat



Between coats
3-5 minutes at 20°C

Before curing
3-5 minutes at 20°C



Dry to polish	20°C	60°C
Autoclear LV Superior Accelerator	90 minutes	6 minutes
Plus Reducers	3 hours	9 minutes



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

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Product and additives

	Autoclear Rapid Air AS
Hardener	Autoclear Rapid Air AS Hardener
Reducers	Autoclear LV Superior Accelerator Plus Reducers
Additives	Elast-O-Actif; to elasticize Autoclear Rapid Air AS making it suitable for plastic parts. See S8.06.03c

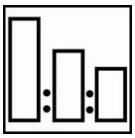
Basic raw materials

Autoclear Rapid Air AS:	Acrylic and polyester resins
Autoclear Rapid Air AS Hardener:	Poly-isocyanate resins

Suitable substrates

Autowave 2.0: until completely matt and dry
Sanded original finishes

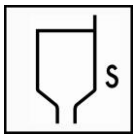
Mixing



100	Autoclear Rapid Air AS
50	Autoclear Rapid Air AS Hardener
20	Autoclear LV Superior Accelerator / Plus Reducers

Use measuring stick No.3 Purple

Viscosity



13-15 seconds – DIN Cup 4 at 20°C.

Spray gun set-up / application pressure



Spray gun	**Fluid tip – set-up**	**Application pressure**
Gravity feed	1.2-1.4 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap

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Application process & blending



Apply two single coats, allowing for a 3-5 minutes flash-off time at 20°C between coats.
Allow for a 3-5 minutes flash-off time at 20°C before baking.

- Flash-off between coats; in case of application to larger areas, flash-off between coats is minimal.
- Recoatable with itself after full drying cycle, sanding becomes necessary after 24 hours
- For blending (spot repair and panel blends), see TDS S8.01.01.

Pot-life

With Autoclear LV Superior Accelerator	3 hours	at 20°C
With Plus Reducers	4 hours	at 20°C

Drying times

Allow for a minimum of 5 minutes flash-off time at 20°C before moving the car into a pre-heated drying oven (booth) at 60°C. All drying times relate to standard application and object temperature.



		Accelerator	Plus Reducer
20°C	**Dust dry**	5 min	5 min
	Dry to polish	90 min	3 hrs
40°C	**Dust dry**	3 min	3 min
	Dry to polish	45 min	70 min
60°C	**Dust dry**	2 min	2 min
	Dry to polish	6 min	9 min



Dry to handle after approximately 10 minutes.
Allow 5 minutes flash off prior to infra red curing
The panel must not reach a temperature above 100°C while curing.
For additional infra red drying information; see TDS S9.01.01

Polishability



Dust and minor imperfections can be polished out after the stated air-dry times have been reached, or after a full bake at 60°C object temperature, followed by a cool down of the object to ambient temperature. Carefully sand out dust particles and restore the surface according polishing recommendations. *Ready to polish approximately 1 hour after cool down to ambient temperature.*

Film thickness

By using the recommended application: 50-60 µm

Theoretical coverage

	m²/liter
Ready for use mixture at 1 µm dry film thickness	± 429

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

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Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/liter VOC.
The VOC content of this product in ready to use form is max. 580 g/liter.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.

- *Product shelf life data see TDS S9.01.02*

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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