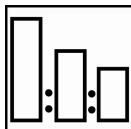
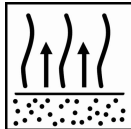
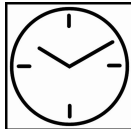


Autoclear WB 2.0

FOR PROFESSIONAL USE ONLY

Description		
Two-pack state of the art waterborne clearcoat with very large application window that combines a high performance with environmental compliance.		
	100 Autoclear WB 2.0 50 Autoclear WB 2.0 Hardener 30 Autoclear WB Reducer 30-40 Activator WB	
	Use Sikkens measuring stick 10 Green	
	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 First apply a medium closed coat, next apply a full coat	
	Between coats 3-10 minutes at 20°C	Before curing 0-5 minutes at 20°C
		20°C 60°C 5½ hours 35 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		

Autoclear WB 2.0

FOR PROFESSIONAL USE ONLY

Description

Two-pack state of the art waterborne clearcoat with very large application window that combines a high performance with environmental compliance.

Product and additives

Autoclear WB 2.0

Hardener Autoclear WB 2.0 Hardener

Reducers Autoclear WB Reducer

Additives Activator WB

No plasticizer (Elast-O-Activ) required for application on plastic car parts.

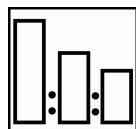
Basic raw materials

Autoclear WB 2.0: Polyacrylate resins
Autoclear WB 2.0 Hardener: Poly-isocyanate resins

Suitable substrates

Autowave 2.0
Sanded original finishes

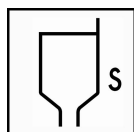
Mixing



100 Autoclear WB 2.0
50 Autoclear WB 2.0 Hardener
30 Autoclear WB Reducer
30-40 Activator WB

*Use measuring stick No. 10 Green.
Mix the components in a plastic can, mix thoroughly after adding each of the components.*

Viscosity



15-17 seconds – DIN Cup 4 at 20°C.

Spray gun set-up / application pressure



Spray gun
Gravity feed

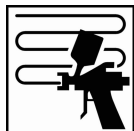
Fluid tip – set-up
1.2-1.4 mm

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

Autoclear WB 2.0

FOR PROFESSIONAL USE ONLY

Application process & blending



Apply a medium closed coat, allowing for a 3-10 minutes flash-off and apply a full coat
Flash off 3-10 minutes at 20°C before baking.

Recoat with itself within 24 hours
For blending, see TDS S8.01.01.

Pot-life

1 hour at 20°C

Film thickness

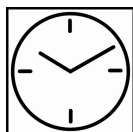
By using the recommended application: 50-60 µm

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.

Consider the time required for the spraybooth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object.

**Do not use any type of air acceleration or drying equipment during the drying cycle of the Autoclear WB 2.0*



Autoclear WB 2.0

20°C	Dust dry	1 hour 40 minutes
	Dry to handle*	5½ hours
50°C	Dust dry	30 minutes
	Dry to handle*	1 hour
60°C	Dust dry	20 minutes
	Dry to handle*	35 minutes

*Dry to handle

Following the drying cycle at 60°C object temperature, allow the Autoclear WB 2.0 to cool down fully to ambient temperature 20°C inside the spraybooth before placing the object in an area with a minimum temperature of 15°C for optimum the through hardening.

In case of lower area temperatures, i.e. winter times, extend the drying time by 15-20 minutes at 60°C



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

Autoclear WB 2.0

FOR PROFESSIONAL USE ONLY

Polishability



Ready to be polished after stated air-drying times have been reached, or after a full bake at 60°C object temperature.

Theoretical coverage

Ready for use mixture at 1 µm dry film thickness

m²/liter
± 307

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

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/liter VOC.
The VOC content of this product in ready to use form is max. 420 g/liter.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.
o Product shelf life data see TDS S9.01.02

Akzo Nobel Coatings LTD

Address: Unit 2B, Didcot Park
Churchward, Southmead Industrial Estate
Didcot, Oxfordshire, OX11 7HB
Tel: +44 (0)1235 862226

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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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Head Office

Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com