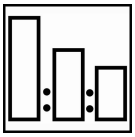
Autoclear 2.0

FOR PROFESSIONAL USE ONLY

Description

Two-pack VOC compliant clearcoat concept, designed for optimum application properties. This concept covers all sizes of repairs at optimum quality levels under all application conditions. The clearcoat technology will ensure a very robust and reliable product performance combined with high gloss level on Autowave 2.0.



3	Autoclear 2.0
3	Autoclear 2.0 Hardener
1	Autoclear 2.0 Reducer Fast / Slow



Use Sikkens measuring stick

21 Pink

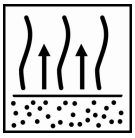


Spray gun set-up:
1.2-1.3 mm

Application pressure:
2.0-2.2 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
3-5 minutes at 20°C

Before curing
3-5 minutes at 20°C



	40°C	60°C
Reducer Fast	30 minutes	15 minutes
Reducer Slow	45 minutes	30 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 2.0

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Description

Two-pack VOC compliant clearcoat concept, designed for optimum application properties. This concept covers all sizes of repairs at optimum quality levels under all application conditions. The clearcoat technology will ensure a very robust and reliable product performance combined with high gloss level on Autowave 2.0.

Product and additives

	Autoclear 2.0
Hardener	Autoclear 2.0 Hardener
Reducers	Autoclear 2.0 Reducer Fast Autoclear 2.0 Reducer Slow

No plasticiser (Elast-O-Actif) required for application on plastic car parts.

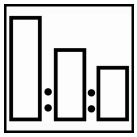
Basic raw materials

Autoclear 2.0:	Polyol resins
Autoclear 2.0 Hardener:	Poly-isocyanate resins

Suitable substrates

Autowave 2.0:
Sanded original finishes

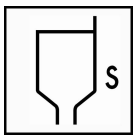
Mixing



3 Autoclear 2.0
3 Autoclear 2.0 Hardener
1 Autoclear 2.0 Reducer Fast / Slow
Use measuring stick No. 21 Pink

Note: Mix the paint <u>after</u> components A, B and C have been added!

Viscosity



Reducer Fast / Slow 15-17 seconds DIN Cup 4 at 20°C

Spray gun set-up / application pressure



Spray gun	Fluid tip – set-up	Application pressure
Gravity feed	1.2-1.3 mm	2.0-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap

Autoclear 2.0

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Application process & blending



Apply a medium closed coat, allowing for a 3-5 minutes flash-off time and apply a full coat
Flash-off 3-5 minutes before baking
Recoatable with itself within 24 hours
For blending, see TDS S8.01.01.

Pot-life

Autoclear 2.0 Reducer Fast	1.5 hours at 20°C
Autoclear 2.0 Reducer Slow	2 hours at 20°C

Drying times



		20°C	40°C	60°C
2.0 Reducer Fast	**Dust dry**	25 minutes	10 minutes	5 minutes
	Dry to polish	16 hours	30 minutes	15 minutes
2.0 Reducer Slow	**Dust dry**	45 minutes	20 minutes	10 minutes
	Dry to polish	16 hours	45 minutes	30 minutes

Drying times (continued)



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

Polishability



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

Points of Attention

Thoroughly shake Autoclear 2.0 before use to ensure all additives are homogeneous, especially after prolonged storing of the material.

Film thickness

By using the recommended application (2 coats)	45-60 µm

Autoclear 2.0

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Theoretical Coverage

Ready for use mixture at 1 µm layer thickness	522 m²/liter

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

2004/42/IIB(d)(420)420
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.

- *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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