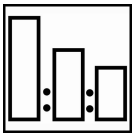
Autoclear Plus HS

FOR PROFESSIONAL USE ONLY

Description

High-build, two-component clearcoat designed for universal application and optimal appearance for both Autowave and Autobase Plus 2-and 3 coat systems which secures excellent flow and gloss.



100 Autoclear Plus HS
50 P Hardeners
10 Plus Reducers

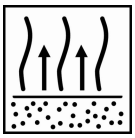
Use Sikkens measuring stick

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
First apply a medium closed coat, next apply a full coat after indicated flash off time



Between coats
5-10 minutes at 20°C

Before curing
5-10 minutes at 20°C

	20°C	60°C
P15 Hardener	4 hours	15 minutes
P25 Hardener	6 hours	35 minutes
P35 Hardener	10 hours	45 minutes
P45 Hardener	10 hours	45 minutes

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

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Description

High-build, two-pack clearcoat designed for universal application and optimal appearance in Autowave and Autobase 2-and 3 coat systems. Excellent flow and gloss.

Product and additives

Autoclear Plus HS

Hardener
P15 Hardener; spot and panel repairs at 20°C-25°C
P25 Hardener; spot and panel repairs at 20°C-30°C
P35 Hardener; larger areas and overall refinishing at 20°C-40°C
P45 Hardener; larger areas and overall refinishing above 40°C

Plus Reducers
Plus Reducer Fast; spot and panel repairs, temperature range: 15°C-25°C.
Plus Reducer Medium; spot and panel repairs and large areas, temperature range: 20°C-30°C.
Plus Reducer Slow; larger areas and complete paint jobs, temperature range: 25°C-35°C.
Plus Reducer Extra Slow; to use in extremely hot temperatures, temperature range: above 35°C.

Additives
Autoclear Mat; a matt clearcoat finish to create different clearcoat gloss levels (TDS 5.5.1)
Elast-O-Actif; to elasticize Autoclear Plus HS making it suitable for plastic parts. See S8.06.03c

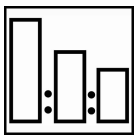
Basic raw materials

Autoclear Plus HS: Acrylic and polyester resins
P Hardener: Poly-isocyanate resins

Suitable substrates

Autobase Plus; after a minimum flash off time of 15 minutes at 20°C
Autobase Classic; after a minimum flash off time of 15 minutes at 20°C
Autowave; after a minimum flash off time of 15 minutes at 25°C
Autowave 2.0: until completely matt and dry

Mixing

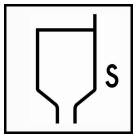


Standard systems

100	Autoclear Plus HS
50	P Hardeners
10	Plus Reducers

Use measuring stick No. 3 Purple.

Viscosity



15-18 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 a medium closed coat, allowing for a 5-10 minutes flash-off time at 20°C.
Next, apply a full coat, allowing for a 5-10 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.
- *When sanding and heavy polishing is required, a third coat may be applied after the stated flash-off times at 20°C.*

Pot-life

P15 Hardener	3 hours	at 20°C
P25 Hardener	4 hours	at 20°C
P35 Hardener	6 hours	at 20°C
P45 Hardener	7 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.
Consider the time required for the spraybooth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object.

		P15 Hardener	P25 Hardener	P35 Hardener	P45 Hardener
20°C	**Dust dry**	15 minutes	45 minutes	45 minutes	45 minutes
	Dry to handle*	4 hours	6 hours	10 hours	10 hours
60°C	**Dust dry**	5 minutes	5 minutes	10 minutes	10 minutes
	Dry to handle*	15 minutes	35 minutes	45 minutes	45 minutes

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

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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

	mils	µm
By using the recommended application (2 coats)	2.4-3.2	60-80

Theoretical Coverage

The theoretical material usage at 1 µm dry film thickness is:	4059 sq.ft/liter	377 m²/liter

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

The VOC content of this product in ready to use form is 560 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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