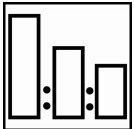


Autoclear LV Exclusive

FOR PROFESSIONAL USE ONLY

Description

Two-pack VOC compliant self healing clearcoat, with dedicated hardener and reducer. The clearcoat ensures optimum application properties and a robust and reliable product performance. The clearcoat offers a superb gloss level on Autowave and has excellent car wash resistance.



100 Autoclear LV Exclusive
60 Autoclear LV Exclusive Hardener
20 Autoclear LV Exclusive Reducer



Use Sikkens measuring stick

31 Blue



Spray gun set-up:
1.2-1.4 mm

Application pressure:

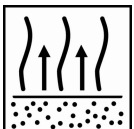
1.7-2.2 bar at the air inlet

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
3-5 minutes at 20°C

Before curing

3-5 minutes at 20°C



Drying time:

40 minutes at 60°C



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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Description

Two-pack VOC compliant self healing clearcoat, with dedicated hardener and reducer. The clearcoat ensures optimum application properties and a robust and reliable product performance. The clearcoat offers a superb gloss level on Autowave and has excellent car wash resistance.

Product and additives

Clearcoat	Autoclear LV Exclusive
Hardener	Autoclear LV Exclusive Hardener ; a general purpose hardener for all repair sizes.
Reducer	Autoclear LV Exclusive Reducer

Basic raw materials

Autoclear LV Exclusive ; Polyol resins
Autoclear LV Exclusive Hardener ; Poly-isocyanate resins

Suitable substrates

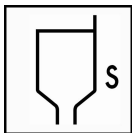
Autowave; after a minimum flash off time of 15 minutes at 25°C
Autowave 2.0: until completely matt and dry

Mixing ratio

100 parts by volume of Autoclear LV Exclusive
60 parts by volume of Autoclear LV Exclusive Hardener
20 parts by volume of Autoclear LV Exclusive Reducer

Use mixing stick No. 31

Viscosity



15-17 seconds – DIN Cup #4 at 20°C

Spray gun set-up / application pressure



Spray gun
Gravity

Fluid tip – set-up
1.2-1.4 mm

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

Application process & blending



Apply a light flowing closed coat, allowing for a 3-5 minutes flash off time.

Next, apply a full flowing coat, allowing for a 3-5 minutes flash-off time before bake.

- Flash off between coats; in case when more then three panels are applied, there is limited flash off time between coats required
- In a throughput booth allow 5-10 minutes flash off time when drying.
- 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

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Pot-life

Autoclear LV Exclusive

1 hour at 20°C

Drying times

Allow 5-10 minutes flash off time when drying in a throughput booth.
All drying times relate to standard application and object temperature



Dust dry	20 minutes
Dry to handle	40 minutes

Through-hardening:

Following the drying cycle at 60°C object temperature, allow the Autoclear LV Exclusive to cool fully to ambient temperature to complete the through-hardening process.



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 damage can be polished out 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 3 hours after cool down to ambient temperature, preferably overnight for optimal results.
- 3M; standard Sikkens polishing procedure
- Farécla: polishing procedure for well cured topcoats

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Film thickness

	μm
Per coat	20-30
By using the recommended application	45-60

Theoretical Coverage

	sq.ft/liter	m^2/liter
Ready for use mixture at 1 μm dry film thickness:	$\pm 5543 \text{ sq.ft/liter}$	$\pm 515 \text{ m}^2/\text{liter}$

The practical coverage 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/l 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 70°C (20°C).
Avoid extreme temperature fluctuation.

- o *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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