

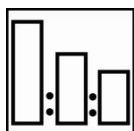
Autoclear Xspeed

FOR PROFESSIONAL USE ONLY

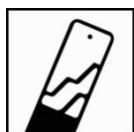
Description

Autoclear Xspeed Clear is two pack clearcoat system provides excellent flow, gloss and smooth finish. It is easy to apply and suitable for all types of repairs, in most application conditions.

Mixing



100 Autoclear Xspeed
 50 P Hardeners - P25 / P35
 10-20 Plus Reducer (Medium / Slow / Extra Slow) OR Xpress Dry Reducer



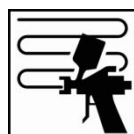
Use Sikkens measuring stick

3 Purple

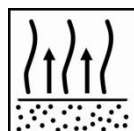


Spray gun set-up:
 1.3-1.4mm

Application pressure:
 1.7-2.0 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 25°C
 Reducer selection according temperature

Before curing
 10-15 minutes at 25°C
 Flash-off time depending on oven type



Product selection	25°C	35°C	60°C
P25 / Xpress Dry Reducer (10%)	2 hrs	1 hr 5 mins	30 minutes
P35 / Xpress Dry Reducer (10%)	2 hrs 20 mins	1 hrs 18 mins	30 minutes
P25 / Plus Reducer Medium (10%)	2 hrs 35 mins	1 hrs 25 mins	30 minutes
P35 / Plus Reducer Slow (10%)	3 hrs 10 mins	2 hrs 10 mins	30 minutes
P25 / Xpress Dry Reducer (20%)	2 hrs	1 hr	30 minutes
P35 / Xpress Dry Reducer (20%)	2 hrs	1 hrs 10 mins	30 minutes
P25 / Plus Reducer Medium (20%)	2 hrs 30 mins	1 hrs 30 mins	30 minutes
P35 / Plus Reducer Slow (20%)	3 hrs	2 hrs	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 Xspeed

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Description

Autoclear Xspeed Clear is two **pack** clearcoat system provides excellent flow, gloss and smooth finish. It is easy to apply and suitable for all types of repairs, in most application conditions.

Product and additives

Clearcoat Autoclear Xspeed

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

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

Xpress Dry Reducer Xpress Dry Reducer; spot and panel repairs, temperature range: 15°C-25°C.

Basic raw materials

Basic Clear: Acrylic resins
P Hardener: Poly-isocyanate resins
Plus Reducers – A blend of organic solvents
Xpress Dry Reducer: A blend of organic solvents, additives and catalysts

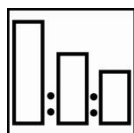
Suitable substrates

Autobase Plus; after a minimum flash off time of 15 minutes at 25°C

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Mixing



Standard systems

100 Autoclear Xspeed
 50 P Hardeners
 10 -*20 Plus Reducers

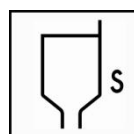
*Adding 20% reducer improves flow and extends pot-life

Use measuring stick No. 3 – Purple

Accelerated system

100 Autoclear Xspeed
 50 P Hardeners
 10 -*20 Xpress Dry Reducer

Viscosity



100 Autoclear Xspeed
 50 P Hardeners
 10 Plus Reducers / Xpress Dry Reducer

18-21 seconds – DIN Cup 4 at 25°C.

100 Autoclear Xspeed
 50 P Hardeners
 20 Plus Reducers / Xpress Dry Reducer

15-19 seconds – DIN Cup 4 at 25°C.

Spray gun set-up / application pressure

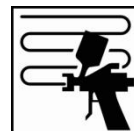


Spray gun
 Gravity feed

Fluid tip – set-up
 1.3-1.4 mm

Application pressure
 1.7-2.0 bar at the spray gun air inlet
 HVLP max 0.6-0.7 bar at the air cap

Application process & blending



Apply a medium closed coat, allowing for a 3-5 minutes flash-off time at 25°C.
 Next, apply a full coat, allowing for a 10-15 minutes flash-off time at 25°C before baking at 60°C.

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 within 24 hours at 25°C.
 When sanding and heavy polishing is required, a third coat may be applied after the stated flash-off times at 25°C.

Dry film thickness

45-50µm

Pot-life

P25 Hardener
 P35 Hardener

60 – 150 minutes at 25°C
 90 – 180 minutes at 25°C

P25 Hardener with Xpress Dry Reducer
 P35 Hardener with Xpress Dry Reducer

60 - 70 minutes at 25°C
 75 - 80 minutes at 25°C

Note: Pot life varies based on the amount of reducer added. Using 10% reducer results in a shorter pot life compared to using 20%.



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Drying times

Allow for a minimum of 10 minutes flash off time at 20°C - 30°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 spray booth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object.

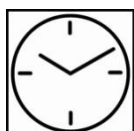


P25 / Xpress Dry Reducer 10%	P35 / Xpress Dry Reducer 10%	P25 / Plus Reducer Med 10%	P35 / Plus Reducer Slow 10%
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15°C	Dust dry	8 minutes	13 minutes	15 minutes	25 minutes
	Dry to handle*	2 hrs 25 mins	2 hrs 45 mins	3 hrs 10 mins	4 hrs 40 mins
	Hard dry	4.5 hrs	5.5 hrs	5 hrs	6 hrs

25°C	Dust dry	5 minutes	8 minutes	11 minutes	20 minutes
	Dry to handle*	2 hrs	2 hrs 20 mins	2 hrs 35 mins	3 hrs 10 mins
	Hard dry	3.5 hrs	4.5 hrs	4 hrs	5 hrs

35°C	Dust dry	3 minutes	5 minutes	6 minutes	15 mins
	Dry to handle*	1 hr 5 mins	1 hr 18 mins	1 hr 25 mins	2 hrs 10 mins
	Hard dry	2.5 hrs	3.5 hrs	3 hrs	4 hrs



P25 / Xpress Dry Reducer 20%	P35 / Xpress Dry Reducer 20%	P25 / Plus Reducer Med 20%	P35 / Plus Reducer Slow 20%
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15°C	Dust dry	10 minutes	15 minutes	17 minutes	27 minutes
	Dry to handle*	2 hrs 20 mins	2 hrs 35 mins	3 hrs	4 hrs 30 mins
	Hard dry	5 hrs	5.5 hrs	5.5 hrs	6.5 hrs

25°C	Dust dry	7 minutes	11 minutes	14 minutes	24 minutes
	Dry to handle*	2 hrs	2 hrs	2 hrs 30 mins	3 hrs
	Hard dry	4 hrs	5 hrs	4.5 hrs	5.5 hrs

35°C	Dust dry	5 minutes	8 minutes	8 minutes	16 minutes
	Dry to handle*	1 hr	1 hr 10 mins	1 hr 30 mins	2 hrs
	Hard dry	3 hrs	4 hrs	3.5 hrs	4.5 hrs

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*Dry to handle; Following the drying cycle at 60°C object temperature, allow the Autoclear Xspeed to cool down fully to ambient temperature.

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 30 minutes after cool down to ambient temperature.

Theoretical coverage

By using the recommended application, the theoretical material usage is $\pm 6.5 - 7 \text{ m}^2/\text{liter}$ RTS mixture.
 The theoretical material usage at $1\mu\text{m}$ dry film thickness is: $327 - 348 \text{ m}^2/\text{liter}$

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 Gun cleaners

VOC

The VOC content of this product in ready to use form is $557 - 586 \text{ g/liter}$ RTS mixture.

Shelf-life

Autoclear Xspeed Clear	2 years at 20°C
Hardener P25	1 year at 20°C
Hardener P35	1 year at 20°C
Plus Reducer Medium	4 years at 20°C
Plus Reducer Slow	4 years at 20°C
Plus Reducer Extra Slow	4 years at 20°C
Plus Reducer Xpress Dry	2 years at 25°C

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
 Avoid extreme temperature fluctuation. (Min 5°C – Max 35°C)
 Product shelf life data see TDS S9.01.02

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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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