

Autoclear Aerodry

FOR PROFESSIONAL USE ONLY

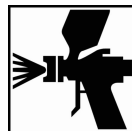
Description

Two-pack VOC compliant ambient drying clearcoat showing excellent properties like an oven cured clearcoat. Autoclear Aerodry offers optimum application properties and easy blending. Its innovative technology offers multiple drying methods while insuring a constant premium finish. Fast ambient drying at a wide range of temperature or 5min at 60°C, outstanding polishability, Autoclear Aerodry is the perfect partner enabling the bodyshop to lower energy and resource costs per repair by diversifying workflows.



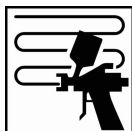
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Autoclear Aerodry
Autoclear Aerodry Hardener (Fast / Standard / Medium)



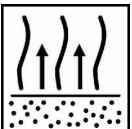
Spray gun set-up:
1.2-1.3 mm

Application pressure:
2.0-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



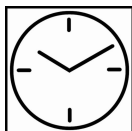
2 x 1 coat

One visit application
½ + 1 coat
First apply a light closed coat.
Followed by a full coat without flash off time



Between coats
0-3 minutes at 20°C

Before curing
0-3 minutes at 20°C



| | | 20°C | 40°C | 60°C |
|--------------------------------------------------------------------|---------------|-----------|-----------|-------|
| Autoclear Aerodry Autoclear Aerodry Hardener Std | Dust dry | 20-30 min | 15-35 min | X |
| | Dry to handle | 40-60 min | 30-55 min | 5 min |
| Autoclear Aerodry Autoclear Aerodry Hardener Fast | Dust dry | 15-25 min | X | X |
| | Dry to handle | 35-55 min | X | 5 min |
| Autoclear Aerodry Autoclear Aerodry Hardener Med | Dust dry | 15 min | x | x |
| | Dry to handle | 50 min | x | x |

Note: Do Not force dry Autoclear Aerodry Medium Hardener. AMBIENT CURING ONLY



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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Product and additives

| | |
|------------------|-------------------------------------------------------------------------------------------------------------|
| Clearcoat | Autoclear Aerodry |
| Hardener | Autoclear Aerodry Hardener Fast Autoclear Aerodry Hardener Standard Autoclear Aerodry Hardener Medium |

Basic raw materials

| | |
|--------------------------------------------------------|------------------------|
| Autoclear Aerodry | Polyaspartic resins |
| Autoclear Aerodry Hardener (Fast / Standard / Medium): | Poly-isocyanate resins |

Suitable substrates

Autowave MM 2.0 + 5% **Autowave 2.0 Hardener*** (+5-10% Activator WB**)
 Autowave MM Optima + 5% **Autowave Optima WB Hardener*** (+5-10% Optima Activator WB**)

* **Addition of Autowave 2.0 Hardener / Autowave Optima WB Hardener is mandatory.**
 (In case of three stage application the advised amount of hardener must be added to each of the coats.)

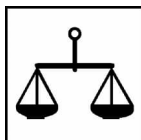
Note: If a pre-coat as described below is applied before applying the Autowave 2.0 basecoat / Autowave MM Optima basecoat it is **not** mandatory to add the 5% Autowave 2.0 Hardener in the Autowave 2.0 or Autowave MM Optima basecoat colour

-**Pre-coat** Sikkens Sealer WB or MM666 / MM600 (60:40) + 5% **Autowave 2.0 Hardener ****
 (+5-10% Activator WB**)

** As with all mixed Autowave MM 2.0 / Autowave MM Optima formula's a larger amount of Activator WB can be added for application at higher temperatures and/or at low humidity (please refer to the chosen basecoat TDS for more information)

Restriction: It is not possible to apply Autoclear Aerodry to ready mixed Autowave colors containing 338NA, 338NB, 338ND, 338NS in combination with Additive LP

Mixing



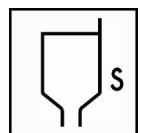
14-20°C

100 parts by weight of Autoclear Aerodry
 100 parts by weight of Autoclear Aerodry Hardener Fast

20-30°C

100 parts by weight of Autoclear Aerodry
 100 parts by weight of Autoclear Aerodry Hardener Fast / Standard / Medium

Viscosity

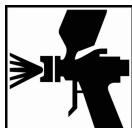


12-14 seconds – DIN Cup 4 at 20°C.

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Spray gun set-up / application pressure

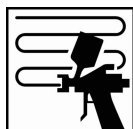


Spray gun
Gravity feed

Fluid tip – set-up
1.2-1.3 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

Application process



Apply two single coats, allowing for a 0-3 minutes flash-off time at 20°C between coats

Alternatively:

One visit-application: ½ + 1 coat

- First apply a light closed coat.
- Next apply a full coat without flash off time .

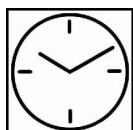
Pot-life

| | |
|---------------------------------------------------------|--------------------|
| Autoclear Aerodry + Autoclear Aerodry Hardener Fast | 45 minutes at 20°C |
| Autoclear Aerodry + Autoclear Aerodry Hardener Standard | 35 minutes at 20°C |
| Autoclear Aerodry + Autoclear Aerodry Hardener Medium | 45 minutes at 20°C |

Film thickness

By using the recommended application: 45-60 µm.

Drying times



| | | 20°C | 40°C | 60°C |
|----------------------------------------|---------------|-----------|-----------|-------|
| Autoclear Aerodry | Dust dry | 20-30 min | 15-35 min | X |
| Autoclear Aerodry Hardener Std | Dry to handle | 40-60 min | 30-55 min | 5 min |
| Autoclear Aerodry | Dust dry | 15-25 min | X | X |
| Autoclear Aerodry Hardener Fast | Dry to handle | 35-55 min | X | 5 min |
| Autoclear Aerodry | Dust dry | 15 min | X | X |
| Autoclear Aerodry Hardener Med | Dry to handle | 50 min | X | X |

Note: DO NOT force dry Autoclear Aerodry Medium Hardener. AMBIENT CURING ONLY



Allow 5 minutes flash off prior to infra red curing
The panel temperature should not exceed 100°C.

For additional information, see TDS S9.01.01

Note: In combination with temperature, drying speed is dependent on humidity levels. In general drying will be faster the higher the humidity. Increasing temperature/s may lower humidity levels and deter drying speed.

Drying at humidity levels under 30% should be avoided as TDS drying times cannot be guaranteed.

DO NOT IR Autoclear Aerodry when the Medium Hardener is used

Blending

For blending, see TDS S8.01.01.

Recoatibility

Recoatible with itself within 48 hours, after which sanding is mandatory

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Polishability



Ready to polish 15 minutes after the indicated drying times

Note: For an optimal result, polish within 3 hours after curing.

Material usage

Ready for use mixture at 1 μm layer thickness: m²/liter
± 494 m²/liter

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

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

2004/42/IB(d)(420)420

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 currently 1 year when stored unopened at 20°C
After opening the can, product shelflife is limited to 1 month at 20°C
Avoid extreme temperature fluctuation and high humidity levels

- *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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