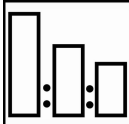
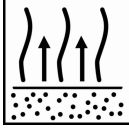
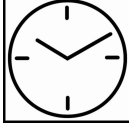


Autocryl Plus

FOR PROFESSIONAL USE ONLY

Description			
Two-pack acrylic enamel for passenger cars, commercial vehicles and equipment. For new work and repairs.			
	100 Autocryl Plus 50 P Hardeners 30 Plus Reducers		
	Use Sikkens measuring stick 1 Black		
	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		
	Between coats 3-5 minutes at 20°C	Before curing 5-7 minutes at 20°C	
	P25 Hardener/Plus Accelerator P15 Hardener P25 Hardener P35 Hardener P45 Hardener	20°C 1.5 hours 4 hours 10 hours 11 hours 11 hours	60°C 10 minutes 15 minutes 25 minutes 35 minutes 35 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

Autocryl Plus

FOR PROFESSIONAL USE ONLY

Description

Two-pack acrylic enamel for passenger cars, commercial vehicles and equipment.
For new work and repairs.

Suitable substrates

Existing finishes
Glass Reinforced Polyester laminates
All Sikkens preparatory products

Product and additives

Autocryl Plus

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:	temperature range: above 35°C.
Accelerator	Plus Accelerator:	spot and panel repairs, temperature range: 15°C-25°C.
Additives	Matting Paste:	See TDS S1.08.01
	Elast-O-Actif:	See TDS S8.06.03c

Basic raw materials

Autocryl Plus: Acrylic resins
Autocryl Plus Hardener: Poly-isocyanate resins

Surface preparation



Remove contamination using an appropriate cleaner



Final sanding step P500
For detailed surface preparation see TDS S8.06.02



Final sanding step P1000
For detailed surface preparation see TDS S8.06.02

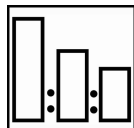


Remove contamination using an appropriate cleaner

Autocryl Plus

FOR PROFESSIONAL USE ONLY

Mixing



Standard system

100 Autocryl Plus
50 P Hardeners
30 Plus Reducers

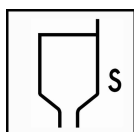
Use measuring stick No. 1 Black

Accelerated systems

100 Autocryl Plus
50 P25 Hardener
30 Plus Accelerator

Use measuring stick No. 1 Black

Viscosity



15-18 seconds DIN Cup 4 at 20°C.

Spray gun set-up / application pressure

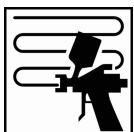


Spray gun
Gravity feed

Fluid tip – set-up
1.2-1.4 mm

Application pressure
1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

Application process & blending



Apply a medium closed coat, allow for a 3-5 minutes flash-off time and apply a full coat.
Flash off 5-7 minutes before baking.
Recoat with itself within 24 hours
For blending, see TDS S8.01.01.

Pot-life

P25 Hardener/Plus Accelerator	1 ½ hour	at 20°C
P15 Hardener	1 ½ hour	at 20°C
P25 Hardener	2 hours	at 20°C
P35 Hardener	3 hours	at 20°C
P45 Hardener	3 ½ hours	at 20°C

Film thickness

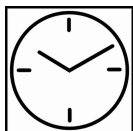
50 µm

Autocryl Plus

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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.



	20°C		60°C	
	Dust dry	Dry to handle	Dust dry	Dry to handle
P15 Hardener	15 minutes	4 hours	5 minutes	15 minutes
P25 Hardener Plus Accelerator	15 minutes	1.5 hours	5 minutes	10 minutes
P25 Hardener	15 minutes	10 hours	5 minutes	25 minutes
P35 Hardener	20 minutes	11 hours	5 minutes	35 minutes
P45 Hardener	20 minutes	11 hours	5 minutes	45 minutes



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

Polishability



Ready to polish after the stated air-dry times or 1 hour after cool down to ambient temperature

Material usage

By using the recommended application, the theoretical material usage is $\pm 10.5 \text{ m}^2/\text{liter RTS mixture}$.

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 Solvent or solvent borne guncleaners

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.

Avoid extreme temperature fluctuation.

- o Product shelf life data see TDS S9.01.02

Autocryl Plus

FOR PROFESSIONAL USE ONLY

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Tel: +31(0)71308-6944

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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