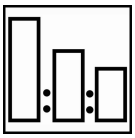
Autocryl Plus

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

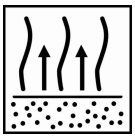
Use Sikkens measuring stick

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

	20°C	60°C
P25 Hardener/Plus Accelerator	1.5 hours	10 minutes
P15 Hardener	4 hours	15 minutes
P25 Hardener	10 hours	25 minutes
P35 Hardener	11 hours	35 minutes
P45 Hardener	11 hours	35 minutes

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

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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

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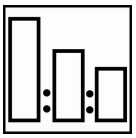
Mixing



Standard system

100	Autocryl Plus
50	P Hardeners
30	Plus Reducers

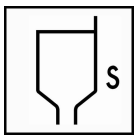
Use measuring stick No. 1 Black

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.
Recoatable 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

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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 ± 10.5 m²/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.

- *Product shelf life data see TDS S9.01.02*

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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