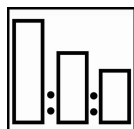


Autocryl Plus LV

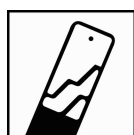
FOR PROFESSIONAL USE ONLY

Description

Two component, high Solid mixing machine based, polyester/acrylic topcoat specifically designed for the refinishing of passenger cars. The system has a VOC content of 420 g/liter and is supported by a full range of ancillary items.



100 Autocryl Plus LV
50 Autocryl Plus LV Hardener
10 Autocryl Plus LV Thinner



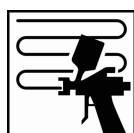
Use Sikkens measuring stick

3 Purple

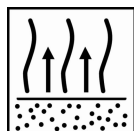


Spray gun set-up:
1.2-1.4 mm

Application pressure:
1.7-2.2 bar at the air inlet.
HVLP max 0.6-0.7 bar at the air cap.

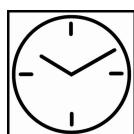


2 x 1 coat



Between coats:
1-3 minutes at 20°C

Before curing:
5-7 minutes at 20°C



Autocryl Plus LV Accelerator
Autocryl Plus LV Thinner

	20°C	60°C
Autocryl Plus LV Accelerator	3½ hours	20 minutes
Autocryl Plus LV Thinner	5 hours	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

Autocryl Plus LV

FOR PROFESSIONAL USE ONLY

Description

Two component, high Solid mixing machine based, polyester/acrylic topcoat specifically designed for the refinishing of passenger cars. The system has a VOC content of 420 g/liter and is supported by a full range of ancillary items.

Suitable substrates

Existing finishes
Polyester laminates
All Sikkens preparatory products with the exception of Autosurfacers WB

Product and additives

	Autocryl Plus LV	
Hardeners	Autocryl Plus LV Hardener	
Thinners	Autocryl Plus LV Thinner Autocryl Plus LV Thinner HT	
Additives	Autocryl Plus LV Accelerator: Autocryl Structure Paste Fine: Matting Paste:	spot and panel repairs at 15°C-25°C See TDS 6.57 See TDS S1.08.01

Basic raw materials

Autocryl Plus LV: polyester and acrylic resin combination
Autocryl Plus LV Hardeners: 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

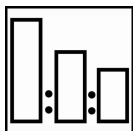


Remove contamination using an appropriate cleaner

Autocryl Plus LV

FOR PROFESSIONAL USE ONLY

Mixing



Standard system

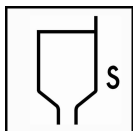
100	Autocryl Plus LV
50	Autocryl Plus LV Hardener
10	Autocryl Plus LV Thinner / Autocryl Plus LV Thinner HT

Accelerated system

100	Autocryl Plus LV
50	Autocryl Plus LV Hardener
10	Autocryl Plus LV Accelerator

Use Sikkens measuring stick nr. 3

Viscosity



17-21 seconds DIN Cup 4 at 20°C

Spray gun set-up / application

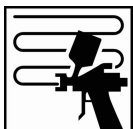


Spray gun
Gravity feed

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 1-3 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 S8.01.01.1

Pot-life

Autocryl Plus LV Thinner / Thinner HT
Autocryl Plus LV Accelerator

2 hours at 20°C
1 hour at 20°C

Film thickness

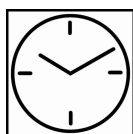
45-65 µm

Autocryl Plus LV

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Drying times

Allow a 5 minute flash-off time at 70°F (20°C) before moving the car into a pre-heated drying oven (booth) at 140°F (60°C). All drying times relate to standard application and object temperature.
Consider the time required for the spraybooth air temperature and object to reach 140°F (60°C).

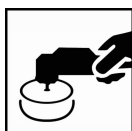


	20°C		60°C	
	Dust dry	Dry to handle	Dust dry	Dry to handle
Plus LV Accelerator	75 minutes	3.5 hours	10 minutes	20 minutes
Plus LV Thinner	1.5 hours	5 hours	15 minutes	30 minutes
Plus LV Thinner HT	6 hours	16 hours	25 minutes	40 minutes



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 ± 64,5 sq.ft./liter (6 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

VOC

2004/42/IIIB(d)(420)420

The EU limit value for this product (product category: IIB. d) in ready to use form is max. 420 g/liter of 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°F (20°C).
Avoid extreme temperature fluctuation.

- o Product shelf life data see TDS S9.01.02

Autocryl Plus LV

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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