

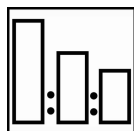
Autosurfacer HB

FOR PROFESSIONAL USE ONLY

Description

Autosurfacer HB is a fast drying two-pack high build primer-surfacer for car refinishing systems. Developed for panel and spot repairs where extreme high film build is required. Autosurfacer HB is only available as a sanding surfacer.

Sanding application



5 Autosurfacer HB
1 Hardener P25 / P35
1 Plus Reducers



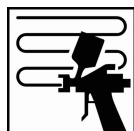
Use Sikkens measuring stick

23 Violet

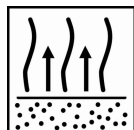


Spray gun set-up:
1.8-2.2 mm

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

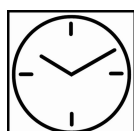


1-3 x 1 coat



Between coats:
5-10 minutes at 20°C

Before curing:
5-10 minutes at 20°C

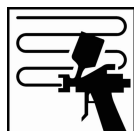


3 hours at 20°C

30 minutes at 60°C



Final sanding step: P500
See TDS S8.06.02



Recoat with all Sikkens topcoats



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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Suitable substrates

Existing finishes
Steel
OEM electrocoat
Sikkens Washprimers

Glass Reinforced Polyester laminates
Polyester bodyfillers
Sikkens Polysurfacer
Primer Surfacer EP II

Autosurfacer HB will provide adequate adhesion if applied directly to steel. However, it is advised for systems which should meet the highest standards to apply Autosurfacer HB over Sikkens Washprimer. Allow for a minimum of 15 minutes flash-off time at 20°C after washprimer application.

Product and additives

Autosurfacer HB

Hardeners

Hardener P25: spot or panel repairs at 20°C-25°C
Hardener P35: larger areas at 20°C-40°C

Plus Reducers

Plus Reducer Fast: spot and panel repairs, temperature range: 15°C-25°C
Plus Reducer Medium: spot / 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

Additives

Autocryl Structure Paste Fine: See TDS 6.57
Elast-O-Actif: See TDS S8.06.03c

Basic raw materials

Autosurfacer HB: Acrylic resins
P Hardeners: Polyisocyanate resin

Surface preparation



Remove contamination using an appropriate cleaner



Final sanding step P220 - P320
See TDS S8.06.02 for sanding specifications



Remove contamination using an appropriate cleaner
Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

Autosurfacer HB

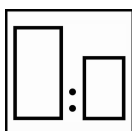
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Stir before use



Stir Autosurfacer HB thoroughly before use.

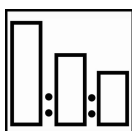
Tinting



Autosurfacer HB can be tinted with up to 10 parts by volume of Autocryl, Autocryl Plus or Autocryl Plus LV MM toners.

After tinting Autosurfacer HB stir thoroughly before adding hardener

Mixing

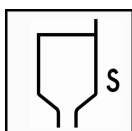


- 5 Autosurfacer HB
- 1 Hardener P25 / P35
- 1 Plus Reducers

Flexible parts

Once elasticized to the required level, Autosurfacer HB can be applied on plastic parts. All virgin plastic parts should be pre-coated with a suitable plastic primer.
See TDS.S8.06.3c.

Viscosity



30-40 seconds DIN cup 4 at 20°C

Spray gun set-up / application pressure



Spray gun
Gravity feed

Fluid tip – set-up
1.8-2.2 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

Pot-life

Hardener P25:	1 hour at 20°C
Hardener P35:	2 hours at 20°C

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Application



Spot application:

Apply one coat over the total sanded area. Flash off until completely matt and apply the 2nd and 3rd coat within each preceding coat. Flash off until completely matt after each coat.

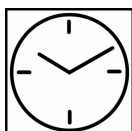
Panel application:

Apply 2-3 coats and flash off until completely matt after each coat.

Film thickness

By using the recommended application: 3 coats; 240-300 µm

Drying time sanding



3 hours at 20°C

2 hours at 40°C

30 minutes at 60°C

Indicated drying times are based on to the use of P25 Hardener



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

Final sanding



Final sanding step P500

For detailed information see TDS S8.06.02



Final sanding step P1000

For detailed information see TDS S8.06.02



Remove contamination using an appropriate cleaner

Recoatable with

All Sikkens topcoats

Theoretical Coverage

By using the recommended application, the theoretical material usage is 4 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.

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Cleaning of equipment

Sikkens Solvent or solvent borne guncleaners

VOC

2004/42/IIb(c)(540)520

The EU limit value for this product (product category: IIb. c) in ready to use form is max. 540 g/liter of VOC.
The VOC content of this product in ready to use form is max. 520 g/liter.

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

Akzo Nobel Car Refinish bv.
Address: Rijksweg 31, PO Box 3, 2170 BA Sassenheim
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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Head Office

Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com