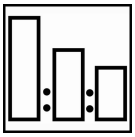
Autoclear 2.0

FOR PROFESSIONAL USE ONLY

Description

Two-pack VOC compliant clearcoat concept, designed for optimum application properties. This concept covers all sizes of repairs at optimum quality levels under all application conditions. The clearcoat technology will ensure a very robust and reliable product performance combined with high gloss level on Autowave 2.0.



3	Autoclear 2.0
3	Autoclear 2.0 Hardener
1	Autoclear 2.0 Reducer Fast / Slow

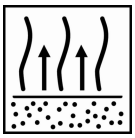
Use Sikkens measuring stick

21 Pink

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
First apply a medium closed coat, next apply a full coat



Between coats
3-5 minutes at 20°C

Before curing
3-5 minutes at 20°C

	40°C	60°C
Reducer Fast	30 minutes	15 minutes
Reducer Slow	45 minutes	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

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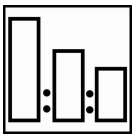


3	Autoclear 2.0 / Autoclear 2.0 HT
3	Autoclear 2.0 Hardener
1	Autoclear 2.0 Reducer HT

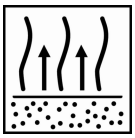
Use Sikkens measuring stick

21 Pink

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
First apply a medium closed coat, next apply a full coat



Between coats
3-5 minutes at 40°C

Before curing
3-5 minutes at 40°C

	40°C	60°C
2.0 / Reducer HT	90 minutes	30 minutes
2.0 HT / Reducer HT	110 minutes	35 minutes

Use suitable respiratory protection
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Description

Two-pack VOC compliant clearcoat concept, designed for optimum application properties. This concept covers all sizes of repairs at optimum quality levels under all application conditions. The clearcoat technology will ensure a very robust and reliable product performance combined with high gloss level on Autowave 2.0.

Product and additives

	Autoclear 2.0 Autoclear 2.0 HT
Hardener	Autoclear 2.0 Hardener
Reducers	Autoclear 2.0 Reducer Fast Autoclear 2.0 Reducer Slow Autoclear 2.0 Reducer HT

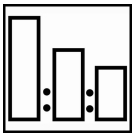
Basic raw materials

Autoclear 2.0:	Polyol resins
Autoclear 2.0 Hardener:	Poly-isocyanate resins

Suitable substrates

Existing OEM sanded finishes
Autowave 2.0
Autowave MM Optima
Autowave MM

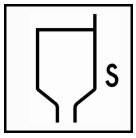
Mixing



3 Autoclear 2.0 (HT)
3 Autoclear 2.0 Hardener
1 Autoclear 2.0 Reducer Fast / Slow / HT
Use measuring stick No. 21 Pink

Note: Mix the paint after components A, B and C have been added!

Viscosity



Reducer Fast / Slow:	15-17 seconds DIN Cup 4 at 20°C
Reducer HT:	14-16 seconds DIN Cup 4 at 30°C
HT / Reducer HT:	13-15 seconds DIN Cup 4 at 40°C

Spray gun set-up / application pressure

Spray gun	Fluid tip – set-up	Application pressure
Gravity feed	1.2-1.3 mm	2.0-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap

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Application process & blending

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

Pot-life

Autoclear 2.0 (Reducer Fast)	1.5 hours at 20°C
Autoclear 2.0 (Reducer Slow)	2 hours at 20°C
Autoclear 2.0 (Reducer HT)	2.5 hours at 30°C
Autoclear 2.0 (Reducer HT)	1.5 hours at 40°C
Autoclear 2.0 HT (Reducer HT)	3 hours at 30°C
Autoclear 2.0 HT (Reducer HT)	2 hours at 40°C

Drying times

		20°C	40°C	60°C
2.0 (Reducer Fast)	**Dust dry**	25 minutes	10 minutes	5 minutes
	Dry to polish	16 hours	30 minutes	15 minutes
2.0 (Reducer Slow)	**Dust dry**	45 minutes	20 minutes	10 minutes
	Dry to polish	16 hours	45 minutes	30 minutes

		30°C	40°C	60°C
2.0 (Reducer HT)	**Dust dry**	60 minutes	30 minutes	10 minutes
	Dry to polish	2.5 hours	1.5 hours	30 minutes
2.0 HT (Reducer HT)	**Dust dry**	75 minutes	40 minutes	15 minutes
	Dry to polish	3.5 hours	2 hours	35 minutes

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Drying times (continued)

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 directly after cool down to ambient temperature.

Film thickness

By using the recommended application (2 coats)	45-60 µm

Theoretical Coverage

Ready for use mixture at 1 µm layer thickness	522 m²/liter

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

2004/42/IIB(d)(420)420
The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/liter 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 20°C.
Avoid extreme temperature fluctuation.

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

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