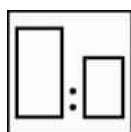


Autoclear Optima

FOR PROFESSIONAL USE ONLY

Description

Autoclear Optima is a high-performance, two-pack VOC-compliant clearcoat offering multiple fast-drying options, including bake at 40°C and at 50°C, as well as ambient drying. It supports a 1.5-coat application premium gloss, smooth flow, and easy application. With a wide application window, it ensures consistent, reliable performance across various temperatures and humidity levels. Autoclear Optima is the ideal partner for flexible workshop operations, helping to improve workflow, increase throughput, reduce energy consumption, and accelerate processes for greater overall efficiency.



100 Autoclear Optima Fast / Medium
50 Autoclear Optima Hardener



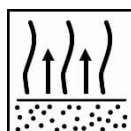
Spray gun set-up:
1.2-1.3 mm

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



½ + 1 coat

One-stop application
½ + 1 coat
First apply a light closed coat
Next apply a full coat



Between coats
No flash-off at 20°C*

Before curing
No flash-off at 20°C

*1-2 vertical panel application, allow flash-off 0-3 min



	Autoclear Optima Fast Autoclear Optima Hardener			Autoclear Optima Medium Autoclear Optima Hardener		
	20°C	40°C	50°C	30°C	40°C	50°C
Dust dry	20-25 min	X	X	20 min	X	X
Dry to handle	45-50 min	7 min	5 min	35 min	13 min	10 min



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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Description

Autoclear Optima is a high-performance, two-pack VOC-compliant clearcoat offering multiple fast-drying options, including bake at 40°C and at 50°C, as well as ambient drying. It supports a 1.5-coat application delivering premium gloss, smooth flow, and easy application. With a wide application window, it ensures consistent, reliable performance across various temperatures and humidity levels. Autoclear Optima is the ideal partner for flexible workshop operations, helping to improve workflow, increase throughput, reduce energy consumption, and accelerate processes for greater overall efficiency.

Product and additives

Clearcoat	Autoclear Optima Fast Autoclear Optima Medium
Hardener	Autoclear Optima Hardener

Basic raw materials

Autoclear Optima Fast / Medium:	Polyacrylic and Polyester resins
Autoclear Optima Hardener:	Poly-isocyanate resins

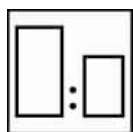
Suitable substrates

Autowave MM 2.0
Autowave Optima MM

Mixing

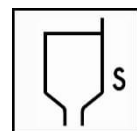


20-30°C (application temperature)	
65	parts by weight of Autoclear Optima Fast
35	parts by weight of Autoclear Optima Hardener
30-40°C (application temperature)	
65	parts by weight of Autoclear Optima Medium
35	parts by weight of Autoclear Optima Hardener



20-30°C (application temperature)	
100	parts by volume of Autoclear Optima Fast
50	parts by volume of Autoclear Optima Hardener
30-40°C (application temperature)	
100	parts by volume of Autoclear Optima Medium
50	parts by volume of Autoclear Optima Hardener

Viscosity



14-18 seconds – DIN Cup 4 at 20°C.

Spray gun set-up / application pressure



Spray gun
Gravity feed

Fluid tip – set-up
1.2-1.3 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

Autoclear Optima

FOR PROFESSIONAL USE ONLY

Application process



- One-stop application: ½ + 1 coat
- o First apply a light closed coat
 - o Next apply a full coat without flash off

1-2 panel application, allow flash-off time 0-3 min.

Pot-life

Autoclear Optima Fast +
Autoclear Optima Hardener 30 minutes at 20°C

Autoclear Optima Medium +
Autoclear Optima Hardener 30 minutes at 30°C

Film thickness

By using the recommended application: 45-60 µm.

Drying times



		20°C	40°C	50°C
Autoclear Optima Fast Autoclear Optima Hardener	Dust dry	20-25 min	x	x
	Dry to handle	45-50 min	7 min	5 min

		30°C	40°C	50°C
Autoclear Optima Medium Autoclear Optima Hardener	Dust dry	20 min	x	x
	Dry to handle	35 min	13 min	10 min



Drying / Curing with short wave light IR equipment and a surface distance of 70 – 80cm.

Allow 3 mins minutes flash off prior to infra-red curing.

The panel temperature should not exceed 60°C.

Infra Red	Low power (30°C)	High power (60°C)
Autoclear Optima Fast / Medium	2 mins	4-5 mins

For additional information, see TDS S9.01.01

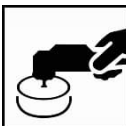
Blending

For blending, see [TDS S8.01.01](#).

Recoatibility

Recoatible with itself within 8 hours, after which sanding is mandatory

Polishability



Baking. Ready to polish after object cools down.
Ambient. Ready to polish after 60-90 minutes air dry at 20°C.

Material usage

Autoclear Optima

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Ready for use mixture at 1 µm layer thickness:

± 521 m²/liter

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)419

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/l VOC.
The VOC content of this product in ready to use form is max. 419 g/liter.

Product storage

Product shelf-life is currently 1 year Hardeners and 2 years Autoclear Optima when stored unopened at 20°C

Optimal storage temperature is approximately 21°C. Avoid too much temperature fluctuation. The maximum temperature range for storage is 5°C - 35°C

- o Product shelf life data see TDS S9.01.02

AkzoNobel Car Refinish bv.

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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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