North America

Programmed System Technique (PST)
Clearcoats
07/28/2025

Autoclear 2121 LV

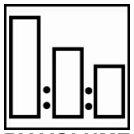
Autoclear 2121 LV is a three-component polyurethane coating designed for use over Autowave basecoat. This clearcoat offers two reducer speeds which can accommodate a broad range of repair sizes and spraying conditions. With a swift 1.5 coat application, Autoclear 2121 LV decreases the time required to spray while providing great flow and exceptional gloss.

Safety Considerations

- Use suitable personal protection.
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator.

Suitable Surfaces

- Sikkens Autowave
- Sikkens Autobase Plus
- Existing Clearcoat
  - Flash for the the TDS indicated time before clearcoat application.
  - For blend panels, thoroughly abrade with P1000 dry or a gray scuff pad.



BY VOLUME
STICK #5

Mix	By Volume
4	Parts Autoclear 2121 LV
1	Part Autoclear 2121 LV Hardener
1	Part Autoclear 2121 LV HT Reducer or LT Reducer

Spray-Gun Set-Up

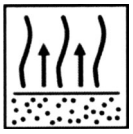
- 1.3 – 1.4mm HVLP Gravity
- 1.3 – 1.4mm Compliant Gravity

Application Air Pressure

- HVLP – 10 psi (<0.7 bar) at cap maximum.
- Consult manufacturer specifications.

Application

- Apply 1.5 (1½) coats with minimal flash between coats.
  - The first coat is to be applied as a thin, closed coat.
  - Follow this coat with a full-flowing coat.



Flash Between Coats at 70°F (21°C)

- 0 – 3 minutes*

Flash at 70°F (21°C) Before Force Drying

- No flash required before curing

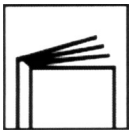
*Flash time is dependent on reducer selection and application temperature. Refer to the ***Flash Drying*** section in the TDS for detailed information.

Drying (LT Reducer)

- Dust free (70°F (21°C)) – 1 hour
- Dry to handle (70°F (21°C)) – 5 hours
- Dry to handle (140°F (60°C)) – 30 min.

Drying (HT Reducer)

- Dust free (70°F (21°C)) – 2 hours
- Dry to handle (70°F (21°C)) – 6 hours
- Dry to handle (140°F (60°C)) – 30 min.



Recoat Information

- After a complete drying cycle, may be recoated with Autoclear 2121 LV within 24 hours without sanding.

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information.

Autoclear 2121 LV

Description

Autoclear 2121 LV is a three-component polyurethane coating designed for use over Autowave basecoat. This clearcoat offers two reducer speeds which can accommodate a broad range of repair sizes and spraying conditions. With a swift 1.5 coat application, Autoclear 2121 LV decreases the time required to spray while providing great flow and exceptional gloss.

Suitable Substrates

- Properly prepared existing finishes
- Sikkens Autowave*
- Sikkens Autobase Plus*

*Allow to flash for the basecoat TDS indicated time before clearcoat application.

Products and Additives

Product	• Autoclear 2121 LV	– Item # 601439 (Gal)
Hardeners	• Autoclear 2121 LV Hardener	– Item # 601437 (Qt)
Reducers	• Autoclear 2121 LV HT Reducer ○ ≥80°F (≥27°C)	– Item # 601436 (Qt)
	• Autoclear 2121 LV LT Reducer ○ 60°-80°F (16°-27°C)	– Item # 601435 (Qt)
Additives		
	○ SDS and TDS for products available online at – http://my.anaac.net/	

Basic Raw Materials

• Autoclear 2121 LV	– Polyol resins
• Autoclear 2121 LV Hardener	– Polyisocyanate resins
• Autoclear 2121 LV Reducers	– Special solvent blends and additives

Existing Finish Substrate Preparation

Pre-Cleaning

- If needed, pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean the substrate with the appropriate AkzoNobel / Sikkens waterborne and solventborne surface cleaners.

Sanding Preparation for Blend Panels

- Abrade existing clearcoat with #P1000 dry using a DA with a soft interface pad. Alternately, use a gray scuff pad with a quality scuffing paste and water.

Surface Cleaning – Prior to Paint Application

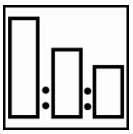
- Clean with the appropriate AkzoNobel / Sikkens waterborne and solventborne surface cleaners.

Mixing Color Formulas and Products

Formulas

- Easy mixing of products, including hardening, reduction, and the addition of additives, can be done by utilizing MIXIT or Color Manager.

Mixing – By Volume

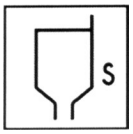


BY VOLUME
STICK #5

Mix	Standard Mix
4	Parts Autoclear 2121 LV
1	Part Autoclear 2121 LV Hardener
1	Part Autoclear 2121 LV HT Reducer or LT Reducer

- Flex additive is not required for application on plastic substrates.

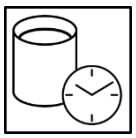
Viscosity – Ready to Spray



DIN #4

	At 70°F (21°C)
• Autoclear 2121 LV	– 11–13 Seconds

Pot-Life When Mixed



Product Mix	Temperature	Time
• Autoclear 2121 LV (LT Reducer)	– at 60°-80°F (15°-27°C)	– ≈45 minutes
• Autoclear 2121 LV (HT Reducer)	– at 80°-100°F (27°-38°C)	– ≈30 minutes

Spray Gun Set-Up

Consult spray gun manufacturer instructions for specific spray gun pressure settings.

Spray Gun	Fluid Tip	Application Pressure
HVLP Gravity Feed	1.3 – 1.4mm	<10 psi (<0.7 bar) at cap, maximum.
Compliant Gravity Feed	1.3 – 1.4mm	psi per spray gun manufacturer

Application

- Apply 1 thin closed coat followed by a full-flowing coat.
  - Allow a flash time of 0-3 minutes between coats. Flash time is dependent on ambient temperature and airflow.

Flash Drying

Flash Between Coats
- 0-3 minutes

Flash at 70°F (21°C) Before Force Drying
- No flash required before curing

NOTE:

- When using Autoclear 2121 LV LT Reducer at lower temperatures, a flash time of up to 3 minutes between coats is recommended.
- When using Autoclear 2121 LV HT Reducer at higher temperatures, a flash time between coats is not required.

✓ Flash time will be dependent on ambient temperature, applied paint wetness/thickness, and available airflow.

Drying / Curing Time

Product/Mix	LT Reducer System		HT Reducer System	
	Dust Free	Dry	Dust Free	Dry
70°F (21°C) Metal Temp	1 hour	5 hours	2 hours	6 hours
122°F (50°C) Metal Temp	10 minutes	40 minutes	15 minutes	40 minutes
140°F (60°C) Metal Temp	10 minutes	30 minutes	15 minutes	30 minutes

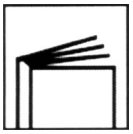
- Dry times stated are when using the recommended application method, film thickness, and object temperature.

Drying / Curing – Infrared

Drying / Curing with short wave light IR equipment and a surface distance of 20 – 27 inches (50 – 70cm). The object temperature must not reach a temperature above 200°F (93°C).

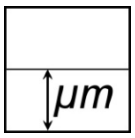
- Allow 5 minutes flash-off before infrared curing.
- Cure 5 minutes on low power followed directly by a 10-minute full-power cure.

Recoating



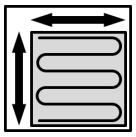
- After a complete drying cycle, may be recoated with Autoclear 2121 LV within 24 hours without sanding.
- After 24 hours, sanding becomes necessary.

Film Thickness – Using Suitable Application



- Using the recommended application method will achieve a thickness of 1.6 – 2.4 mils (41-61µm), dry.

Theoretical Coverage



- Using the recommended application, the theoretical material coverage is ≈704 ft^2/gal (≈17.3m^2/liter) at a 1 mil thickness (25.4µm).
- Actual coverage is dependent on many factors. These may include the shape of the object, surface smoothness, application technique, and other application variables.

Decals and Lettering

- Small decals and adhesive stripes can be applied 48 hours (70°F (21°C)) after full cure.
- Hand painted striping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a gray scuffing pad before application.

Cleaning of Equipment

- Clean equipment and dispose of waste following local and federal regulations. In compliant localities, use Sikkens Cleaning Solvent LV. For national rule regions, use Sikkens Cleaning Solvent.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

Polishing

- Dust and minor damage can be polished out after the stated air-dry times have been reached, or after a full bake has been achieved at 140°F (60°C) object temperature, followed by a cool down of the object to ambient temperature.
- Carefully sand out imperfections and restore the surface according to the polishing recommendations of the products being used.

VOC / Regulatory Information

Product	VOC Pounds per Gallon	VOC Grams per Liter
Autoclear 2121 LV (ready to spray)	≤ 2.1	≤ 250

- Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

Product Storage

- Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures. Optimum storage temperature is approximately 70°F (21°C). Avoid too much temperature fluctuation. The maximum temperature range for storage is 40°F - 95°F (5°C - 35°C).
- Refer to the Sikkens Product Shelf-Life Overview TDS or the current price list for the most up-to-date shelf-life information.

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