

# Autowave MM 338SA

Autowave MM 338SA (Argentum) is a single component, ready to spray basecoat with a high metallic gloss that appears like polished aluminum. Autowave MM 338SA (Argentum) is a waterborne basecoat and should be finished with a Sikkens low VOC clearcoat to ensure VOC compliance.



## Safety Considerations

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



BY VOLUME

## Mix

## By Volume

100  
5

Parts Autowave MM 338SA<sup>1</sup>  
Parts Sikkens WB Hardener<sup>2</sup>

<sup>1</sup> Autowave MM 338SA is ready to spray – addition of Activator WB is not needed.

<sup>2</sup> Adding hardener is necessary for VOC compliance.

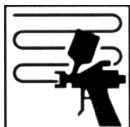


## Spray-Gun Set-Up

- 1.2 – 1.5mm HVLP Gravity
- 1.2 – 1.5mm Compliant

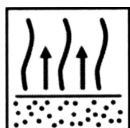
## Application Air Pressure

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



## Application

- 5 – 6 x 1 Coats (5 to 6 single coats).

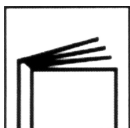


## Flash Between Coats at 70°F (21°C)

- Until matte.

## Flash at 70°F (21°C) Before Clearcoat

- 30 minutes.



## Clearcoating

- To ensure compliance with VOC regulations, Autowave MM 338SA must be clearcoated with a Sikkens low VOC clearcoat.
- Refer to the TDS for the clearcoat being used for detailed application instructions.

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

## Description

Autowave MM 338SA (Argentum) is a single component, ready to spray basecoat with a high metallic gloss that appears like polished aluminum. Autowave MM 338SA (Argentum) is a waterborne basecoat and should be finished with a Sikkens low VOC clearcoat to ensure VOC compliance.

## Suitable Substrates



- Colorbuild Plus
- Colorbuild Plus 250

## Products and Additives

**Product** • Autowave MM 338SA – Item # 369093

**Hardeners** • WB Hardener – Item # 553737

○ SDS and TDS for products available online at – <http://my.anaac.net/>

## Basic Raw Materials



- Autowave MM 338SA – Water based polyurethane dispersion

## Product Agitation



### Stirring

- Stir thoroughly before each use.

## Mixing



BY VOLUME

### Mix

100  
5

### By Volume

Parts Autowave MM 338SA<sup>1</sup>  
Parts Sikkens WB Hardener<sup>2</sup>

<sup>1</sup> Autowave MM 338SA is ready to spray – addition of Activator WB is not needed.

<sup>2</sup> Adding hardener is necessary for VOC compliance.

## Viscosity – Ready to Spray at 70°F (21°C).



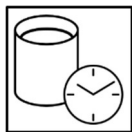
DIN #4

- Autowave MM 338SA

At 70°F (21°C)

– 14–20 Seconds

## Pot-Life When Mixed



Product Mix

70°F (21°C)

- Autowave MM 338SA

3 months

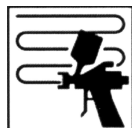
## Spray Gun Set-Up



Consult spray gun manufacturer instructions for spray gun pressure specifications.

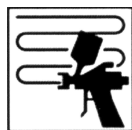
| Spray Gun         | Fluid Tip   | Application Pressure            |
|-------------------|-------------|---------------------------------|
| HVLP Gravity      | 1.2 – 1.5mm | <10 psi (<0.7 bar) at cap.      |
| Compliant Gravity | 1.2 – 1.5mm | psi per spray gun manufacturer. |

## Application Process



### Pre-coat Application

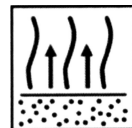
- Apply Colorbuild Plus or Colorbuild Plus 250 according to product TDS specifications and make sure that surface is completely flat. Any irregularity will be immediately visible after basecoat application.
- For spot repairs dissolve overspray with SRA Reducer.
- Do not sand or abrade the applied topcoat.



### Autowave MM 338SA Application

- First apply one single thin coat. Continue application with three or four single coats, and finish with an orientation (mist) coat.
- Allow a flash-off time between coats until basecoat dries completely to a matte /semi-gloss finish and is dry to touch.
- Do not apply these coats too wet – maximum 70% per coat.
- Spraying distance should be at least 12 inches.

## Flash Drying



### Flash Between Coats at 70°F (21°C)

- Until matte.
- Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available airflow.
- Note that de-nibbing of any inclusions is needed to achieve the proper appearance.

### Flash at 70°F (21°C) Before Clearcoat

- 30 minutes, minimum.

## Masking



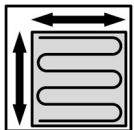
- Autowave MM Solid, Metallic and Pearl colors can be taped with fine line masking tape after 30 minutes flash off at 140°F (60°C) after which a second coat of Autowave MM can be applied.
  - Temperature increase in combination with air movement increases the ability for masking.
  - Let the object cool down to ambient temperature before masking.
  - After application gently remove masking to avoid damaging the basecoat.

## Film Thickness – Using Suitable Application



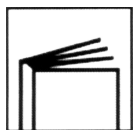
- 1 coat will achieve a thickness of 0.08 – 0.16 mils (2 – 4μm) dry.

## Theoretical Coverage



- With the recommended application the theoretical material usage is 16.2-32.3 sq/ft per liter.
- Actual coverage is dependent on many factors which may include the shape of the object, surface smoothness, application technique, and other application variables.

## Recoating and Clearcoat



- Autowave MM 338SA must be recoated within 24 hours @ 70°F (21°C)
- Autowave MM 338SA is recoatable with Sikkens low VOC clearcoats

## Cleaning of Equipment



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



- Clean equipment and dispose of waste following local and federal regulations.
- Clean and rinse the spray gun thoroughly after use with water from a squirt or spray bottle.
- Finish cleaning with Autowave Gun Cleaner.
  - Do not use any conventional thinner unless removing dried waterborne paint deposits.
  - Do not soak the spray gun for long periods either with Autowave Gun Cleaner or WB Activator.
- Purge the spray gun with Autowave WB Activator and blow dry as a final step.

## VOC / Regulatory Information



### Product

- Autowave MM 338SA (Ready to Spray)
- 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.

### VOC Pounds per Gallon

– 3.5

### VOC Grams per Liter

– 420

## Product Storage



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

## AkzoNobel Inc., North America

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### FOR PROFESSIONAL USE WITH SUITABLE HSE 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 Safety 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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