North America

Programmed System Technique (PST)
Clearcoats
05/21/2026

# Autoclear PC

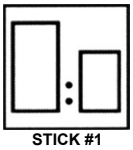
Autoclear PC is a high-solids acrylic urethane clearcoat for use over Sikkens basecoats. Autoclear PC offers high gloss and is designed for various conditions. It can be used with a Manual Proportioning Unit (MPU) at a 2:1 mixing ratio. It is designed to be sprayed over small or large areas in a variety of environments.

**Safety Considerations**

- Use suitable personal protection
- AkzoNobel recommends the use of a fresh air supply respirator
- Refer to the product Safety Data Sheet (SDS) for more complete safety information

**Suitable Substrates**

- Autowave – After the TDS prescribed flash dry time
- Autobase Plus – After the TDS prescribed flash dry time
- Existing Clearcoat – Abraded with P1000 dry or a gray scuff pad, then cleaned




| MIX | By Volume |
|---|---|
| 2 | Parts Autoclear PC Production and/or Autoclear PC Standard |
| 1 | Parts Autoclear PC Hardener |

**Spray-Gun Set-Up**

- 1.3 – 1.5 mm HVLP Gravity
- 1.3 – 1.5mm Compliant Gravity

**Application Air Pressure**

- HVLP – 10 psi at the air cap maximum.
- Consult manufacturer specifications.

**Application**

- 2 x 1 Coat (2 single wet coats)

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

- 0 – 7 minutes

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

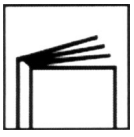
- 0 – 5 minutes

**Drying at 70°F (21°C)**

- 4 – 10+ hours, depending on mix.
  - ✓ Reference tables within the TDS
  - ○ *Dependent on film weight, airflow, and choice of clearcoat mixture*

**Drying at 140°F (60°C)**

- 10 – 40 minutes, depending on mix.
  - ✓ Reference tables within the TDS



**Recoatable With**

- Autoclear PC can be recoated with itself after a full drying cycle. Sanding becomes necessary after 12 hours.

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

## Description

Autoclear PC is a high-solids acrylic urethane clearcoat for use over Sikkens Basecoats. Autoclear PC offers high gloss and is designed for various conditions. It can be used with a Manual Proportioning Unit (MPU) at a 2:1 mixing ratio. It is designed to be sprayed over small or large areas in a variety of environments.

## Suitable Substrates

- Existing finishes that have been properly sanded and cleaned
- Sikkens Autowave - after the TDS prescribed flash dry time
- Sikkens Autobase Plus - after the TDS prescribed flash dry time
- Sikkens Autoclear PC

## Products and Additives

| | | |
|---|---|---|
| **Product** | • Autoclear PC Production | – Item # 391298 |
| | • Autoclear PC | – Item # 391297 |
| **Hardeners** | • Autoclear PC Hardener | – Item # 391299 |
| **Additives** | • Sikkens Elast-o-Actif | – Item # 386100 |
| | • Sikkens ExtraTop | – Item # 605328 |
| | • Sikkens High Temperature Additive | – Item # 589142 |

- SDS and TDS for products available online at – https://my.anaac.net/

## Basic Raw Materials

- Sikkens Autoclear PC and PC Production – Hydroxyl acrylic resins
- Sikkens Autoclear PC Hardener – Polyisocyanate resins

## Substrate Preparation

**Pre-Cleaning**

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- The appropriate surface cleaners in the AkzoNobel assortment (M600, Autoprep Ultraprep, Antistatic) should be used for initial cleaning steps

**Note:** For comprehensive surface cleaning information, refer to the Technical Service Bulletin *TSB AN23.01 AkzoNobel Surface Cleaning Recommendations and Best Practices* at https://my.anaac.net/

**Sanding Preparation**

- Abrade existing clearcoat with #P1000 dry and a soft interface pad or use a gray scuffing pad with a quality scuffing paste and water

**Surface Cleaning – Prior to Paint Application**

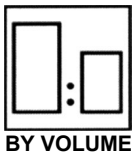
- Clean with M600 Surface Cleaner, Autoprep Ultraprep (VOC compliant), or Antistatic surface cleaners, as appropriate
- Use M200 or M25 Surface Cleaner as a final wipe-down before refinishing

## Mixing Formulas and Products

**Formulas**

- For easy mixing of products, final mixing - including hardening, reduction, and the addition of additives, can be done through MIXIT

## Mixing

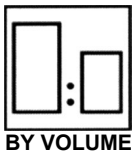


BY VOLUME
STICK #1

**Mix**
**2**
**1**

**Standard Mix**

- Autoclear PC or PC Production
- Autoclear PC Hardener



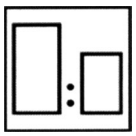
BY VOLUME
STICK #1

**Mix**
**2**
**1**
**1% – 10%**
**(BY VOLUME)**

**High Temp / High Humidity Mix**

- Autoclear PC
- Autoclear PC Hardener
- High Temperature Additive

**NOTE:** High Temperature Additive should only be used with Autoclear PC (not PC Production) and is not recommended for use at temperatures below 85°F (≈29°C).



BY VOLUME
STICK #1

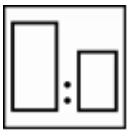
**Mix**
**2**
**1**
**+15 ml**
**(MAXIMUM)**

**Accelerated Mix**

- Autoclear PC or PC Production
- Autoclear PC Hardener
- ExtraTop per ready to spray quart

## Mixing by Stick – Flexible Substrates

If the part to be painted can be deformed by hand, increase the flexibility of Autoclear PC as follows:

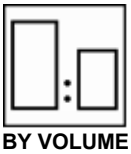


BY VOLUME
STICK #9

**Mix**
**100**
**10**
**(BY VOLUME)**

- Autoclear PC or PC Production
- Elast-o-Actif

**STIR, THEN MIX**



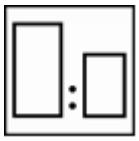
BY VOLUME
STICK #1

**2**
**1**

- Autoclear PC + Elast-o-Actif
- Autoclear PC Hardener

## Mixing by MPU – Flexible Substrates

If the part to be painted can be deformed by hand, increase the flexibility of Autoclear PC as follows:



**2**
**1**

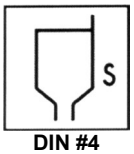
- Autoclear PC or PC Production
- Autoclear PC Hardener

Dispense clear and hardener from the MPU then add flex additive:

**+**
**55 grams**

- Elast-o-Actif per dispensed quart of PC Clear + Hardener

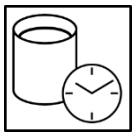
## Viscosity – Ready to Spray at 70°F (21°C).




**DIN #4**

| | At 70°F (21°C) |
|---|---|
| • Autoclear PC | – 13–14 Seconds |

## Pot-Life When Mixed



| Product Mix | At 70°F (21°C) |
|---|---|
| • Autoclear PC | – 4 hours |
| • Autoclear PC + 10% High Temperature Additive | – 4 hours |
| • Autoclear PC Production / Slow Combinations | – 2 hours |
| • Autoclear PC Production | – 1 hour |

## Spray Gun Set-Up

**Consult spray gun manufactures instructions for specific spray gun pressure specifications.**

| Spray Gun | Fluid Tip | Application Pressure |
|---|---|---|
| **HVLP Gravity Feed** | 1.3-1.5 mm | Max 10 psi (<0.7 bar) at the air cap |
| **Compliant Gravity Feed** | 1.3-1.5 mm | Consult manufacturer recommendations |

## Application

- Apply 2 single wet coats
  - If heavy polishing is required a third coat may be applied after observing proper flash time

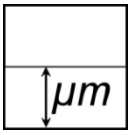
## Flash Drying

**Flash Between Coats at 70°F (21°C)**
- 0-7 minutes

**Flash at 70°F (21°C) Before Force Drying**
- 0-5 minutes

  - Flash time will be dependent on selected clearcoat speed/mixture, ambient temperature, applied paint wetness/thickness, and available airflow

## Film Thickness – Using Suitable Application




- 1 coat will achieve a thickness of 1.2-1.5 mils (30 – 38µm)
- The minimum clearcoat film thickness to provide suitable protection and appearance over base-coat is 2.4 mils (60 µm)

## Drying / Curing Time

Drying times are stated at recommended application method, film thickness, and object temperature. Drying temperatures provided are for metal or object temperature.

**Drying Table at 70°F (21°C) Object Temperature:**

| Mix | 70°F (21°C) | | Accelerated Mix 70°F (21°C) |
|---|---|---|---|
| | Dust Free | Dry to Handle | Dry to Handle |
| **Standard** | 1 hour | 10 hours | 7 hours |
| **Standard +10% High Temp Additive** | 90 min | 10+ hours | Not Recommended |
| **Production** | 30 min | 4 hours | Not Recommended |
| **75 parts Standard / 25 parts Production** | 50 min | 8 hours | 4.5 hours |
| **50 parts Standard / 50 parts Production** | 35 min | 7 hours | 4 hours |
| **25 parts Standard / 75 parts Production** | 35 min | 5.5 hours | Not Recommended |

**Drying Table at 140°F (60°C) Object Temperature:**

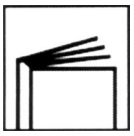
| Mix | 140°F (60°C) | | Accelerated Mix 140°F (60°C) |
|---|---|---|---|
| | Dust Free | Dry to Handle | Dry to Handle |
| **Standard** | 20 min | 30 min | 25 min |
| **Standard +10% High Temp Additive** | 25 min | 40 min | Not Recommended |
| **Production** | 7 min | 10 min | Not Recommended |
| **75 parts Standard / 25 parts Production** | 20 min | 25 min | 20 min |
| **50 parts Standard / 50 parts Production** | 15 min | 20 min | 15 min |
| **25 parts Standard / 75 parts Production** | 15 min | 20 min | Not Recommended |

## 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 212°F (100°C).

- Allow 5-minute flash off before infrared curing
- Cure 6 minutes on low power followed directly by a 6-minute full-power cure

## Recoating



- Autoclear PC can be recoated with itself at any stage. Sanding will become necessary after 12 hours.

## Polishing

- Dust and minor damage can be polished out after the stated air-dry times have been reached or after a full bake at 140°F (60°C) metal temperature followed by a cool down to ambient temperature
- When heavy sanding is required, it may be necessary to apply one extra coat of Autoclear PC

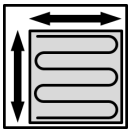
## Decals / Lettering

- 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 grey pad and clean before application.

## Cleaning of Equipment

- Clean equipment following local and federal regulations. For national rule regions, use Sikkens Cleaning Solvent or high quality lacquer thinner.

## Theoretical Coverage



Actual coverage is dependent on many factors. These may include the shape of the object, surface smoothness, application technique and other application variables.

- 644 $ft^2$ / gallon or 16 $m^2$/liter of ready to use clearcoat at 1 mil dry film thickness and 100% transfer efficiency

## VOC / Regulatory Information

- Ready to spray clearcoat (all mixtures) VOC ≤4.1 lb/gal (492 g/L)

## Product Storage

Stock unopened or used products in approved closed containers with 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.

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