

Autowave Basecoat

Autowave is the basecoat color in the Sikkens waterborne two-stage paint system. It provides color accuracy and easy application. Autowave blends easily to provide an “invisible repair.” When used with a Sikkens clearcoat system, a glossy and durable surface is achieved.



Safety Considerations

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



Surface Preparation

- Complete Panel
- Color Blend Area
- Sand with P500 to P600 dry or P600 to P800 wet
- P1000 on an interface pad and D/A sander or degloss using a gray scuff pad



Mixing – Preparation

- Gently shake toner before each color pour
- Stir completed formula color before reducing



STICK # 1

Mix	By Volume
100	Parts Autowave Color
10 – 50	Parts Activator WB



Spray-Gun Set-Up

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

Application Air Pressure

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

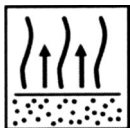


Application Solid Colors

- 2 to 3 x 1 coats

Application Effect Colors

- 2 to 3 x 1 coats
- Apply orientation coat if needed

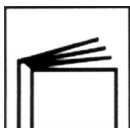


Flash Between Coats at 70°F (21°C)

- Until matte

Flash at 70°F (21°C) Before Clearcoat

- 15 minutes



Recoatable With

- Sikkens clearcoats. Sikkens has a selection of clearcoats for application over Autowave. The selection is based on many considerations including environment, size of the repair, and time

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

Description

Autowave is the basecoat color in the Sikkens waterborne two-stage paint system. It provides color accuracy and easy application. Autowave blends easily to provide an “invisible repair.” When used with a Sikkens clearcoat system, a glossy and durable surface is achieved.

Suitable Substrates



- OEM finishes
- Stable existing finishes
- Sikkens primer surfacers and sealers
- Do not apply over thermoplastic acrylic lacquers
- Do not apply directly over acid containing washprimers or pre-treatments

NOTE: Autowave is not suitable for application directly to e-coat.

Products and Additives

Product	<ul style="list-style-type: none"> • Autowave 	<ul style="list-style-type: none"> – Per color formula
Hardeners	<ul style="list-style-type: none"> • WB Hardener 	<ul style="list-style-type: none"> – Item # 553737 (USA Only) – Item # 484386 (Canada Only)
	<ul style="list-style-type: none"> – WB Hardener is suitable for use in Autowave. The addition of 5% is sufficient to improve system robustness including stone chip resistance, adhesion, and system hardness. WB Hardener is also recommended when multi-layer systems are applied and the recommended layer thickness is exceeded. 	
Activators	<ul style="list-style-type: none"> • Activator WB • Activator WB Dispenser Bottle 	<ul style="list-style-type: none"> – Item # 609978 (gallon) – Item # 2015653
Additives	<ul style="list-style-type: none"> • Autowave Additive LP <ul style="list-style-type: none"> ○ Used to extend the pot life of Autowave metallic colors • Autowave Underhood Additive 	<ul style="list-style-type: none"> – Item # 391192 (liter) – Item # 398179 (quart)
	<ul style="list-style-type: none"> ○ SDS and TDS for products available online at – https://my.anaac.net/ 	

Basic Raw Materials



- Autowave
- WB Hardener
- Autowave Underhood Additive
- Activator WB
- Autowave Additive LP
- Water based acrylic dispersion
- Polyisocyanate resins
- Polyisocyanate resins
- Water / Glycol mixture
- Special chemical blend

Substrate Preparation



Precleaning

- If needed, prewash 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

Existing Finishes Dry

Repair Area

- Initial - #P360-P400
- Final - #P500-P600

Blend Area

- Sand with P1000 on an interface pad and D/A sander

Existing Finishes Wet

- Initial - #P360-P400
- Final - #P600-P800

- Abrade using a gray scuff pad and a quality scuffing paste with water

NOTE: Autowave is not suitable for application directly to e-coat.



Surface Cleaning – Prior to Paint Application

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

Product Agitation



Color Preparation

- Shake paint on a paint shaker or vigorously by hand for 45 seconds before first use
- For metallic, pearl or effect toners, also stir the mixing color before first use
- Gently shake the Autowave toner before each pour
- Once all the toners in a formula have been combined, stir the paint prior to reduction and then stir again after the Activator WB has been added



Mixing Color Formulas and Products



Formulas

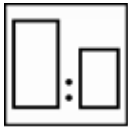
- Formulas are available to match the most popular OEM colors. These are available in MIXIT
 - Ensure when a specified primer color is suggested to use that shade of undercoat primer.
 - For easy mixing of color formulas or products, final mixing including hardening, reduction and the addition of additives can be done using MIXIT

Custom Mixed Colors

- Solid colors can be made with solid MM toners and do not require additional MM666 binder
- For straight metallic colors (no solid toners), mix 1 part MM888 toner with 4 parts MM666 binder

Note: When mixing metallic colors, please follow the recommended mixing directions. This will ensure that the material will function as intended and not produce any unanticipated results

Mixing



BY VOLUME

Mix
100
10 – 50

Standard Mix
 Parts Autowave Color
 Parts Activator WB

- Add Activator WB to all Autowave colors prior to application using the following guidelines
 - Metallic Colors add 30-50 parts Activator WB. Do not exceed 50 parts of Activator WB
 - Pearl Colors add 20-40 parts Activator WB
 - Solid Colors add 10-30 parts Activator WB

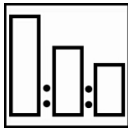


BY WEIGHT

Mix
100
5

Extending Metallic Color Potlife
 Grams Unreduced Autowave Color Formula
 Grams Autowave Additive LP

- Stir together and then reduce as normal
- Do not use Autowave Additive LP in solid colors or in mixtures containing Hardener WB or Autowave Underhood Additive

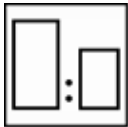


BY VOLUME

Mix
100
10
20-30

Underhood Additive Mix
 Parts Autowave Color
 Parts Autowave Underhood Additive (stir to combine)
 Parts Activator WB (stir to combine)

If improved system robustness including stone chip resistance, adhesion and system hardness is desired, Autowave basecoat may be mixed with WB Hardener before reduction



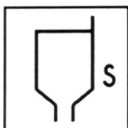
BY VOLUME
 STICK # 9

Mix
100
5

Hardened Basecoat Mix
 Parts Autowave Color
 Parts WB Hardener

- Stir together and then reduce as normal

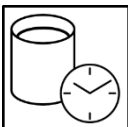
Viscosity – Ready to Spray at 70°F (21°C)



DIN #4

- Autowave – 20-30 seconds

Pot Life When Mixed at 70°F (21°C)



Normal Product Mixes

- Autowave solid and pearl mixed color – 3 months
- Autowave colors containing MM888 or MM338 toner – 1 week
- Autowave colors containing MM888 or MM338 toner with Autowave LP – 3 months
- Autowave MM888 or MM338 colors containing toner MM777 – 1 day

Product Mixes with WB Hardener or Autowave Underhood Additive

- Autowave solid and pearl mixed color – 1-½ hours
- Autowave pearl and solid colors containing 50% or more AW245 – 1 hour
- Autowave colors containing MM888 or MM338 toner – 30 minutes

Equipment Set-Up

Consult spray gun manufacturer instructions for specific pressure specifications.



Spray Gun	Fluid Tip	Application Pressure
HVLP Gravity Feed	1.3 – 1.5 mm	<10 psi (0.7 bar) at cap
Compliant Gravity Feed	1.3 – 1.5 mm	psi per spray gun manufacturer
Paint Strainers	<ul style="list-style-type: none"> Use waterborne suitable 125-micron paint strainers 	

Application



Application – Solid Colors

- Apply 2 medium coats or until opacity is achieved
 - Autowave MM245 applied as pure color can be applied in 2 single layers with flash-off between coats as well as by 2 light wet coats wet-on-wet
- Use increased airflow to flash off between coats until matte in appearance
 - When force drying using a Wind-jet or equivalent equipment, keep a minimum distance of 3 feet



Metallic Color Application

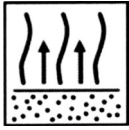
- Apply 1 full coat, 100 % closed. When needed apply intermediate coats, 80% as wet as the first coat until coverage is achieved. Flash dry between coats until the basecoat dries completely to a matte finish
- Apply optional orientation coat –
 - Increase the distance to approximately 12 to 14 inches and apply a damp coat with no wet areas. The finish should look like “satin” when completed



Spot Repair Application

- Autowave MM666 / MM600 (mixed 60:40) may also be used as a clear foundation coat before commencing metallic spot repairs. Reduce 10-20% with Activator WB and apply one thin closed coat of this blending foundation to allow for an easier metallic orientation.
- When making spot repairs apply thin color coats until opacity is achieved extending the area slightly with each coat. Dry until matte between each coat before fading out
- Metallic colors may require air pressure adjustments for the best color match
- Finally apply 1-2 orientation coats fading out well beyond the coverage coats
- To make high hiding colors easier to blend, the color transparency can be increased by adding reduced MM666 to the ready to spray (RTS) mixed color before blending. The recommended ratio is 100 parts RTS color with 50 parts RTS MM666

Flash Drying



Flash Between Coats at 70°F (21°C)

- Until matte
- Flash time will be dependent on ambient temperature, humidity, applied paint wetness/thickness and available airflow
 - Flash can be reduced to a minimum by using air accelerator systems at approximately 3 feet (≈1m) from the repair, thereby increasing the airflow across the repair
 - Introducing heat is also an option. When heat is used for drying, allow object to cool down to application temperature before proceeding with color or clearcoat application
- Maximum flash time is 24 hours at which time the base coat must be abraded and color reapplied

Flash at 70°F (21°C) Before Clearcoat

- 15 minutes

Autowave Underhood Additive Mix - Flash Drying and Cure



Flash Between Coats at 70°F (21°C)

- Until matte

Final Flash at 70°F (21°C) Before Force Dry

- 20-30 minutes

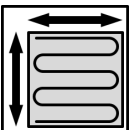
- After final flash, can be force dried at 140°F (60°C) object temperature

Film Thickness – Using Suitable Application



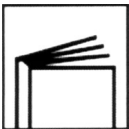
- 1 Coat will achieve a thickness of 0.4 – 0.9mils (10.2 – 22.9μm), dry
- The maximum total thickness is 1.2 mils (30.5μm). If this maximum will be exceeded, the Autowave WB Hardener mix should be used

Theoretical Coverage



- With the recommended application the theoretical material usage is ±256 feet²/gallon (6.3m²/liter) at a 1 mil thickness (25.4μm) and 100% transfer efficiency
- Actual coverage is dependent on many factors. These may include the shape of the object, surface smoothness, application technique and other variables

Recoating



After the stated dry time, Autowave may be recoated with the following materials:

- | | |
|---------------------------------|----------------------------|
| • Autoclear Performance LV | • Autoclear Mix & Matt |
| • Autoclear Superior 250 2 Pack | • Autoclear Mix & Matt 250 |
| • Autoclear Energy Select LV | • Autoclear PC |
| • Autoclear HS+ 2 Pack | • Autoclear Xpress |
| • Autoclear 2.0 | • Autoclear 2121 LV |



North America

Autowave Basecoat

Technical Data Sheet

Basecoat

10/17/2025

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

AkzoNobel Inc., North America

Address: 1845 Maxwell Street – Troy, MI USA

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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