

# Autoclear 2.0

Autoclear 2.0 is a three-component polyurethane coating designed for use over Autowave basecoat. This clearcoat can accommodate a broad range of repair sizes and spraying conditions. This clearcoat technology provides exceptional gloss and robust performance when used over Autowave basecoat.



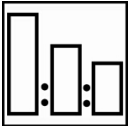
### Safety Considerations

- 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 Autowave 2.0
- Sikkens Autowave Optima
- Existing Clearcoat
- Flash for the TDS indicated time before clearcoat application
- For blend panels, thoroughly abrade with P1000 dry or a gray scuff pad



BY VOLUME  
STICK #21

### Mix

3

3

1

### By Volume

Parts Autoclear 2.0

Parts Autoclear 2.0 Hardener

Part Autoclear 2.0 Reducer (Fast, Slow)

**NOTE:** Do not stir the clearcoat mixture until all components have been added.



### Spray-Gun Set-Up

- 1.2 – 1.3mm HVLP Gravity
- 1.2 – 1.3mm Compliant Gravity

### Application Air Pressure

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



### Application

- Apply 2 x 1 coats
  - The first coat is to be applied as a medium closed coat
  - Observe proper flash, then follow with a full-flowing coat



### Using Reducer Fast or Slow

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

- 3 – 5 minutes

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

- 3 – 5 minutes



### Drying

- Autoclear 2.0 (Reducer Fast)
- Autoclear 2.0 (Reducer Slow)

**104°F (40°C)\***

- 30 minutes
- 45 minutes

**140°F (60°C)\***

- 15 minutes
- 30 minutes

\*Object temperature



### Recoat Information

- When dried according to the recommended parameters, Autoclear 2.0 may be recoated with itself within 24 hours without sanding

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

## Description

Autoclear 2.0 is a three-component polyurethane coating designed for use over Autowave basecoat. This clearcoat can accommodate a broad range of repair sizes and spraying conditions. This clearcoat technology provides exceptional gloss and robust performance when used over Autowave basecoat.

## Suitable Substrates



- Properly prepared existing finishes
- Sikkens Autowave
- Sikkens Autowave 2.0
- Sikkens Autowave Optima

## Products and Additives

<b>Product</b>	<ul style="list-style-type: none"> <li>• Autoclear 2.0</li> </ul>	– Item# 606757 (5 L)
<b>Hardeners</b>	<ul style="list-style-type: none"> <li>• Autoclear 2.0 Hardener</li> </ul>	– Item# 606744 (2.5 L)
<b>Reducers</b>	<ul style="list-style-type: none"> <li>• Autoclear 2.0 Reducer Fast</li> <li>• Autoclear 2.0 Reducer Slow</li> </ul>	<ul style="list-style-type: none"> <li>– Item# 606748 (1 L)</li> <li>– Item# 606746 (1 L)</li> </ul>
<b>Additives</b>		

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

## Basic Raw Materials



- |   |  |
|---|--|
| <ul style="list-style-type: none"> <li>• Autoclear 2.0</li> <li>• Autoclear 2.0 Hardener</li> <li>• Autoclear 2.0 Reducers</li> </ul> | <ul style="list-style-type: none"> <li>– Polyol resins</li> <li>– Polyisocyanate resins</li> <li>– Special solvent blends and additives</li> </ul> |
|---|--|

## Existing Finish 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 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 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

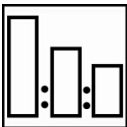
## Mixing Color Formulas and Products



### Formulas

- Easy mixing of products, including hardening, reduction, and the addition of additives, can be performed using MIXIT

## Mixing – By Volume



BY VOLUME  
STICK #21

Mix	Standard Temperature Mix
3	Parts Autoclear 2.0
3	Part Autoclear 2.0 Hardener
1	Part Autoclear 2.0 Reducer Fast or Slow



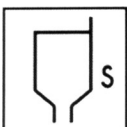
### NOTE:

- Due to the chemistry/technology used in this clearcoat, all individual components should be intermixed simultaneously
- Only stir the clearcoat mixture after all components have been added



- Flex additive is not required for application on plastic substrates

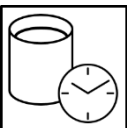
## Viscosity – Ready to Spray



DIN #4

Product Mix	Temperature	Time
• Autoclear 2.0 with Reducer Fast or Slow	– at ≈70°F (20°C)	– 15–17 seconds

## Pot-Life When Mixed



Product Mix	Temperature	Time
• Autoclear 2.0 (Reducer Fast)	– at ≈70°F (20°C)	– 1.5 hours
• Autoclear 2.0 (Reducer Slow)	– at ≈70°F (20°C)	– 2 hours

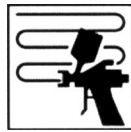
## Spray Gun Set-Up



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

Spray Gun	Fluid Tip	Application Pressure
HVLP Gravity Feed	1.2 – 1.3mm	<10 psi (<0.7 bar) at cap, maximum.
Compliant Gravity Feed	1.2 – 1.3mm	psi per spray gun manufacturer

## Application



- Apply 2 x 1 coats
  - The first coat is to be applied as a medium closed coat
  - Observe proper flash, then follow with a full-flowing coat

## Flash Drying



### Using Reducer Fast or Slow

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

- 3 – 5 minutes

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

- 3 – 5 minutes

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

## Drying / Curing Time



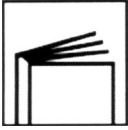
		Object Temperature		
		≈70°F (20°C)	104°F (40°C)	140°F (60°C)
Autoclear 2.0 with Reducer Fast	Dust dry	25 minutes	10 minutes	5 minutes
	Dry to polish	16 hours	30 minutes	15 minutes
Autoclear 2.0 with Reducer Slow	Dust dry	45 minutes	20 minutes	10 minutes
	Dry to polish	16 hours	45 minutes	30 minutes

## Drying / Curing – Infrared

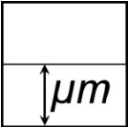


Drying / Curing with short wave light IR equipment and a surface distance of 20 – 27 inches (50 – 70cm). The object temperature must not reach a temperature above 212°F (100°C).

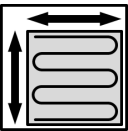
- Allow 5 minutes flash-off before infrared curing
- Cure 4 minutes on low power followed directly by an 8-minute full-power cure

**Recoating**

- When dried according to the recommended parameters, Autoclear 2.0 may be recoated with itself within 24 hours without sanding
- After 24 hours, sanding becomes necessary

**Film Thickness – Using Suitable Application**

- Using the recommended application method, 2 coats will achieve a thickness of 1.8 – 2.4 mils (45-60μm), dry

**Theoretical Coverage**

- The theoretical coverage is ≈838 ft<sup>2</sup>/gal (≈20.6m<sup>2</sup>/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**

Autoclear 2.0 (ready to spray)

**VOC Pounds per Gallon**

≤ 3.47

**VOC Grams per Liter**

≤ 417

- 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. Optimal 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

**AkzoNobel Inc., North America****Address: 1845 Maxwell Street – Troy, MI USA****Telephone: 800.618.1010****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 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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