

Autoclear Xpress

Autoclear Xpress is a three-component polyurethane clearcoat. It is a cutting-edge, high-performance clearcoat technology for vehicle refinishing and repairs. Autoclear Xpress provides easy application and excellent sag control along with superior gloss and durability. Its quick dry-to-handle times make it an ideal choice for air dry environments.



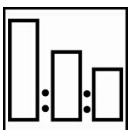
Safety Considerations

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



Surface Preparation

- Existing finishes
 - Autobase Plus
 - Autowave
- Properly sanded and cleaned
 - After observing TDS recommended flash time
 - After observing TDS recommended flash time



STICK # 23*

Mix

5

1

1

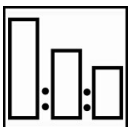
By Volume – only to be used with (60F, 70F, or 80F Reducers)

Parts Autoclear Xpress

Parts Autoclear Xpress Hardener

Parts Autoclear Xpress Reducer (60F, 70F, 80F)

-OR- High Temperature Mix:



STICK # 23*

Mix

5

1

2

By Volume – only to be used with 90F+ Reducer

Parts Autoclear Xpress

Parts Autoclear Xpress Hardener

Parts Autoclear Xpress Reducer (90F+)

*Note: For convenience, **Stick #23** has both ratios listed – ensure the correct side is used for the ratio desired.



Spray-Gun Set-Up

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

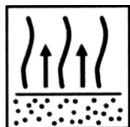
Application Air Pressure

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



Application

- Apply 1.5 (1½) coats with minimal flash time between coats
 - The first coat is to be applied as a thin, closed coat (not sprayed for appearance)
 - 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 recommended



Air Drying at 70°F (21°C)

- Dry to Handle in 50-60 minutes

Force Drying at 120°F (49°C)

- Dry to Handle in 20-25 minutes

Dependent on film weight and airflow.

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

Description

Autoclear Xpress is a three-component polyurethane clearcoat. It is a cutting-edge, high-performance clearcoat technology for vehicle refinishing and repairs. Autoclear Xpress provides easy application and excellent sag control along with superior gloss and durability. Its quick dry-to-handle times make it an ideal choice for air dry environments.

Suitable Substrates



- Properly prepared existing finishes
- Autobase Plus
- Autowave

Products and Additives

Product – Autoclear Xpress – Item # 588785 (1 GL)

Hardeners – Autoclear Xpress Hardener – Item # 588790 (1 QT)
– Item # 588786 (1 GL)

Reducers

– Autoclear Xpress 60F Reducer	– 60° - 70°F	– Item # 588791 (1 QT)
– Autoclear Xpress 70F Reducer	– 70° - 80°F	– Item # 588830 (1 QT)
– Autoclear Xpress 80F Reducer	– 80° - 90°F	– Item # 588792 (1 QT)
– Autoclear Xpress 90F+ Reducer	– ≥90°F	– Item # 588737 (1 QT)

Additives – Flex additive is not required for application on plastic parts

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

Basic Raw Materials



- Autoclear Xpress – Polyacrylic polyol resins
- Autoclear Xpress Hardener – Polyisocyanate resins
- Autoclear Xpress Reducers – Special solvent blends

Mixing – General (60F, 70F, 80F Reducers)



Mix **By Volume – only to be used with (60F, 70F, or 80F Reducers)**

- | | |
|----------|----------------------------------|
| 5 | • Autoclear Xpress |
| 1 | • Xpress Hardener |
| 1 | • Xpress Reducer (60F, 70F, 80F) |



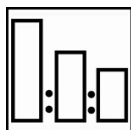
Xpress Reducer Choice

- Xpress 60F Reducer
- Xpress 70F Reducer
- Xpress 80F Reducer

Temperature Range

- 60°-70°F (15°-21°C)
- 70°-80°F (21°-27°C)
- 80°-90°F (27°-32°C)

Mixing – 90°F+ Reducer (High Temperature)



BY VOLUME
STICK # 23

Mix

5
1
2

By Volume – only to be used with 90F+ Reducer

- Autoclear Xpress
- Xpress Hardener
- Xpress 90F+ Reducer



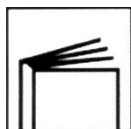
Xpress Reducer Choice

- Xpress 90F+ Reducer

Temperature Range

– ≥ 90°F (≥ 32°C)

Mixing – Points to Consider



- It is advised to remain within the listed temperature range when making the reducer selection.



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

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



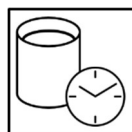
DIN #4

- Autoclear Xpress

At 70°F (21°C)

– 13–15 Seconds

Pot-Life When Mixed



Product Mixed Using

- Xpress 60F Reducer
- Xpress 70F Reducer
- Xpress 80F Reducer
- Xpress 90F+ Reducer

Temperature

- at 60°-70°F (15°-21°C)
- at 60°-80°F (15°-27°C)
- at 60°-90°F (15°-32°C)
- at 60°-100°F (15°-38°C)

Time

- 1.5 – 2 hours
- 1.5 – 2 hours
- 1.5 – 2 hours
- 1.5 – 2 hours

Spray Gun Set-Up

Consult spray gun manufacturer instructions for gun pressure specifications.

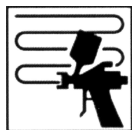


Spray Gun	Fluid Tip	Application Pressure
HVLP Gravity Feed	1.3 – 1.5mm	<10 psi (<0.7 bar) at cap, maximum.
Compliant Gravity Feed	1.3 – 1.5mm	psi per spray gun manufacturer.

NOTE:

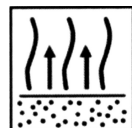
- Larger fluid tip sizes typically provide easier application in higher temperatures or on larger panels.

Application



- Apply 1.5 (1½) coats with minimal flash time between coats.
 - The first coat is to be applied as a thin, closed coat (not sprayed for appearance).
- Follow this coat with a full-flowing coat.

Flash Drying


Flash Between Coats at 70°F (21°C)

- 0-3 minutes

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

- No flash recommended

Drying – Air Dry



- Humidity and airflow influence flash off and drying times.
- Drying times are stated at recommended application method, film thickness and object temperature.

Autoclear Xpress Air Dry	Dust Free	Dry to Handle	Dry to Polish
• 60F Reducer 60°-70°F (15°-21°C)	10 – 20 minutes	50 – 60 minutes	50 – 60 minutes
• 70F Reducer 70°-80°F (21°-27°C)	10 – 20 minutes	50 – 60 minutes	50 – 60 minutes
• 80F Reducer 80°-90°F (27°-32°C)	10 – 20 minutes	50 – 60 minutes	50 – 60 minutes
• 90F+ Reducer ≥ 90°F (≥ 32°C)	10 – 20 minutes	50 – 60 minutes	50 – 60 minutes

Drying / Curing Time – Baked Systems


Autoclear Xpress Bake

Object Temperature	Dust Free	Dry to Handle
• 100° to 120°F (≈38° to 50°C)	0-5 minutes	20-25 minutes

- ✓ Drying times are stated at recommended application method, film thickness and object temperature.
- ✓ **Do not** exceed 120°F (≈50°C) object temperature when baking.
- ✓ Allow the object to cool-down to ambient temperature before handling/polishing.

Drying / Curing Time – Infrared (IR)



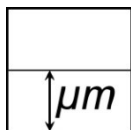
- Drying / Curing with short wave light IR equipment and a surface distance of 20 – 27 inches (50 – 70cm). The object temperature must not reach a temperature above 140°F (60°C).

Autoclear Xpress IR Cure

Object Temperature	Dust Free	Dry to Handle
• 100°F (≈38°C)	-	10-15 minutes
• 120°F (≈50°C)	-	10-15 minutes
• 140°F (60°C)	-	10 minutes

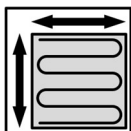
- ✓ Drying times are stated at recommended application method, film thickness and object temperature.
- ✓ **Do not** exceed 140°F (60°C) object temperature when IR curing.
- ✓ Allow the object to cool-down to ambient temperature before handling/polishing.

Film Thickness – Using Suitable Application



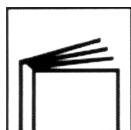
- Using the recommended application (1.5 coats) will achieve a thickness of 1.6 – 2.4 mils (40.6 – 61.4μm), dry.

Theoretical Coverage



- With the recommended application the theoretical material usage is ±540 feet²/gallon (13.2 m²/liter) at a 1 mil thickness (25.4μm) and 100% transfer efficiency.
- Actual coverage is dependent on many factors which may include the shape of the object, surface smoothness, application technique, and other application variables which could affect actual coverage.

Recoating



- After a complete drying cycle, Autoclear Xpress may be recoated with itself. After 24 hours, sanding becomes necessary.

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, use Sikkens Cleaning Solvent.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

VOC / Regulatory Information



Product

- Autoclear Xpress (Ready to Spray)

VOC Pounds per Gallon

– 3.98

VOC Grams per Liter

– 478

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



- 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.

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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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