

Autobase Plus

Autobase Plus solventborne basecoat provides excellent coverage, metallic control, and sprayability when used to duplicate OEM solid, metallic, and pearl effect colors. With the Autobase Plus system, a wide range of popular colors can be created to achieve outstanding repairs in a minimum of time.



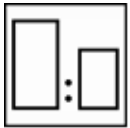
Safety Considerations

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



Surface Preparation

- Sikkens primer surfacers - Repair Area
 - Sand with P500 to P600 dry
- Existing finishes - Color Blend Area
 - Sand with P1000 dry or a grey scuff pad
 - Clean repair before painting



BY VOLUME
STICK # 1

Mix
100
50-80

By Volume

Parts Autobase Plus basecoat color
Parts High Performance Reducer (Fast, Medium, Slow or Extra Slow)



Spray-Gun Set-Up

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

Application Air Pressure

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

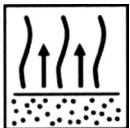


Application – Metallic Colors

- 2 to 3 medium wet coats, or until covered
 - Metallic colors may require an orientation coat

Application – Solid Colors

- 2 to 3 medium wet coats, or until covered

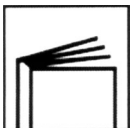


Flash Between Coats at 70°F (21°C)

- 3 – 5 minutes
 - Dependent on film weight and airflow

Flash Before Clearcoat at 70°F (21°C)

- 15 to 20 minutes



Recoatable With

- Autoclear PC
- Autoclear HS+ 2 Pack
- Autoclear Mix and Matt
- Autoclear Xpress
- Autoclear Energy Select LV
- Autoclear Performance LV 2 Pack
- Autoclear Superior 250 2 Pack
- Autoclear 2121 LV

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

Description

Autobase Plus solvent borne basecoat provides excellent coverage, metallic control, and sprayability when used to duplicate OEM solid, metallic, and pearl effect colors. With the Autobase Plus system, a wide range of popular colors can be created to achieve outstanding repairs in a minimum of time.

Suitable Substrates



- Stable existing finishes
 - Sanded Sikkens primer surfacers
 - Sikkens primer sealers after flash drying
 - Autobase Plus Blending Additive after flash drying
- Do not apply over thermoplastic acrylic lacquers. When lacquer is encountered, the entire lacquer finish should be removed or must be sealed with a Sikkens undercoat system
 - Autobase Plus is not suitable for application directly to e-coat

Products and Additives

- | | | |
|----------------|------------------------------|-------------------------|
| Product | • Autobase Plus | – Per pre-mixed formula |
| | • Autobase Plus RM Jet Black | – Item # 611238 (L) |

- | | | |
|------------------|--------------------------------------|-----------------------|
| Hardeners | • Sikkens XP Hardener | – Item # 398766 (Qt) |
| | • Colorbuild Plus Surfacers Hardener | – Item # 393726 (Qt) |
| | • Sikkens RM Midcoat Hardener | – Item # 542675 (Qt) |
| | • Autoclear PC Hardener* | – Item # 391299 (Gal) |
| | • Autoclear HS+ 2 Pack Hardener | – Item # 481305 (Gal) |
| | • Autoclear Xpress Hardener | – Item # 588786 (Gal) |
| | | – Item # 588790 (Qt) |

*To remain compliant with National Rule VOC regulations for 3-stage colors, Autoclear PC Hardener may not be used in Autobase Plus when topcoating with Autoclear Xpress.

- The addition of hardener to Autobase Plus prior to reduction can increase the durability and flexibility of the product. It can also be used to extend the recoat time of Autobase Plus solid colors
- 5% of Hardener should be added to Autobase Plus color prior to the addition of HP Reducer when spraying soft foam parts
- To maintain National Rule VOC for 3 stage colors, 10% hardener must be added to the groundcoat color

- | | | |
|---------------------------------------|-----------------------------------|------------------------|
| Reducers | • High Performance Reducer Fast | – Item #391059, Gallon |
| | ○ 60°F – 75°F (16°C – 21°C) | |
| | • High Performance Reducer Medium | – Item #391062, Gallon |
| | ○ 70°F – 85°F (21°C – 27°C) | |
| | • High Performance Reducer Slow | – Item #391064, Gallon |
| ○ 80°F – 95°F (27°C – 32°C) | | |
| • High Performance Reducer Extra Slow | – Item #391066, Gallon | |
| ○ Above 90°F (32°C) | | |

- | | | |
|------------------|-----------------------------------|-----------------------|
| Additives | • Autobase Plus Blending Additive | – Item #386088, Quart |
|------------------|-----------------------------------|-----------------------|

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

Basic Raw Materials



- Autobase Plus
- Sikkens High Performance Reducers
- Sikkens Clearcoat Hardeners
- Physically drying binders
- Special solvent blends
- Polyisocyanate resins

Substrate Preparation



Pre-Cleaning

- If needed, pre-wash 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

Final Sanding

Additional Notes

Existing Finishes – Repair Area

#P500 to #P600 Dry
#P600 – #P800 Wet



Existing Finishes – Color Blend Area

#P1000 Dry on a soft interface pad and DA

- Alternately, may be prepped with a gray scuff pad and a quality scuff paste with water



Primer Surfacer

#P500 to #P600 Dry
#P600 – #P800 Wet

- Respect a maximum 100 sanding grit step difference throughout a dry sanding process
- Respect a maximum 100 sanding grit step difference throughout a wet sanding process
- Where 2 or more coats of Autobase Plus are applied, ensure the surface is sanded according to the *Existing Finishes – Repair Area* guidance in the table above

Note: Autobase Plus 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



- Because Autobase Plus is high-solids paint, it needs to be agitated before use. Shake toners 10 minutes before first use on a paint shaker
- Stir or shake vigorously before each use

Mixing Color Formulas and Products



Formulas

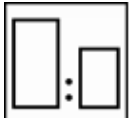
- Formulas are available to match the most popular OEM colors. These are available in MIXIT
 - Ensure when a specified primer color is suggested to use that shade of undercoat primer
 - For easy mixing of color formulas or products, final mixing including hardening, reduction and the addition of additives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

Hand Mixing Colors

- Colors can be custom mixed
- When making a color without using a color formula, it is essential that you incorporate the Autobase Plus MM Q065 Connector into the paint mix. To do this, mix 3 parts Autobase Plus handmade color to 1 part MM Q065. Use the Sikkens Measuring Stick #9 (Grey). Then stir thoroughly, reduce, and apply as normal. Failure to do this will cause poor product performance

NOTE: **Autobase Plus RM Jet Black** is not used in color formulas. It is provided as a ready-mixed product that only requires reducing with Sikkens High Performance (HP) reducer prior to application. Do not add Q065 to Autobase Plus RM Jet Black.

Mixing



BY VOLUME
STICK # 1

Mix

100

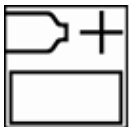
50-80

Standard Mix

- Parts Autobase Plus basecoat color
- Parts High Performance Reducer (Fast, Medium, Slow or Extra Slow)

If improved system robustness including stone chip resistance, adhesion, flexibility and system hardness is desired, Autobase Plus may be mixed with hardener.

- For the first layer of a tri-coat color 10% hardener and no more than 50 parts of reducer may be used to remain compliant with National Rule VOC regulations



Mix

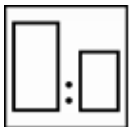
100

5-10%

Hardened Basecoat Mix

- Parts Autobase Plus basecoat color
- Hardener (see list in *Products and Additives* section of this TDS)

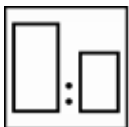
Stir together, then –



BY VOLUME
STICK # 1

50-80

- Parts High Performance Reducer



BY VOLUME
STICK # 1

Mix

100

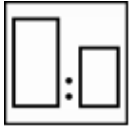
50

Pastel Solid Color Fade-Out Mix – optional over reduction before blending

- Parts Autobase Plus ready to spray basecoat color
- Parts Sikkens Reducer SRA 7.0

Mixing – Autobase Plus RM Jet Black

Autobase Plus RM Jet Black is a ready-mix color for use when an extremely deep black is desired. It exhibits a very jet appearance and only requires proper reduction before application.



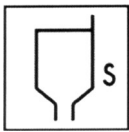
BY VOLUME
STICK # 1

Mix
100
50-80

- Parts Autobase Plus RM Jet Black
- Parts High Performance Reducer (Fast, Medium, Slow or Extra Slow)

Note: An approved hardener may also be added to Autobase Plus RM Jet Black according to the *Hardened Basecoat Mix* instructions in the *Mixing* section above.

Viscosity – Ready to Spray



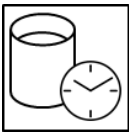
DIN #4

- Autobase Plus (100:50 ratio)
- Autobase Plus (100:80 ratio)
- Autobase Plus RM Jet Black (100:50 ratio)
- Autobase Plus RM Jet Black (100:80 ratio)

At 70°F (21°C)

- 16–17 seconds
- 13–14 seconds
- 19–20 seconds
- 15–16 seconds

Pot-Life When Mixed



Product Mix

- | | |
|--|------------|
| • Autobase Plus RM colors (ready mixed, unreduced) | – 2 years |
| • Autobase Plus solid colors (reduced) | – 6 months |
| • Autobase Plus metallic/effect colors (reduced) | – 6 months |
| • Autobase Plus pearl 2 nd layer colors (reduced) | – 24 hours |
| • Autobase Plus colors (hardened and reduced) | – 4 hours |
| • Autobase Plus RM Jet Black (reduced) | – 3 months |
| • Autobase Plus RM Jet Black (hardened and reduced) | – 4 hours |

70°F (21°C)

Spray Gun Set-Up



Spray-Gun Tip Size

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

Application Air Pressure

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

Application Points to Consider



- Metallic color shade can be influenced by reducer selection, application air pressure, and spray gun distance / technique. The following table provides general guidelines:

Lighter Color Shade (More silver/gray)

- Faster reducer selections
- Higher air pressure
- Less distance and/or trigger pull

Darker Color Shade (More color, less silver)

- Slower reducer selections
- Lower air pressure
- More distance and/or trigger pull

Application



Overall Application

- Apply 2 to 3 coats medium wet coats or until color is covered
 - Allow a flash off time between coats until the paint has a matte appearance



Metallic Color Application

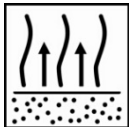
- Apply 2 to 3 coats medium wet coats or until color is covered
 - Apply 1 full coat, 100 % closed. Next apply intermediate coats, 80% as wet as the first coat until coverage is achieved. Flash between coats until the basecoat dries completely to a matte finish.
 - If needed, apply an orientation coat
 - ✓ Lower the air pressure slightly
 - ✓ 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

- Autobase Plus Blending Additive may be used as a clear foundation coat before starting metallic spot repairs
 - Autobase Plus Blending Additive is ready to spray in the can. Apply one thin single flowing coat of this blending foundation to allow for an easier metallic orientation. Flash until dry
- 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
 - Tack the entire repair area between each coat
- Metallic colors may require air pressure adjustments and an orientation coat for the best color match
- Finally, fade-out well beyond the coverage coats

Flash Drying

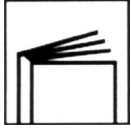


- Flash dry 3 to 5 minutes or until matte
 - Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available airflow
 - Flash can be reduced to a minimum by using air accelerator systems at a 45° angle and approximately 3 feet (≈1m) from the repair, thereby increasing the airflow over the object

Drying / Curing Time



- Allow Autobase Plus to dry for a minimum of 15 to 20 minutes at 70°F (20°C) before applying the clearcoat
- The maximum time Autobase Plus may be left before clearcoating:
 - Autobase Plus Metallic Color: 2 days
 - Autobase Plus Solid Color: 5 hours
 - ✓ Recoat time can be extended to 2 days with the proper addition of hardener
- Drying times are stated at recommended application method, film thickness and object temperature

Recoating

- After the stated dry time Autobase Plus may be recoated with the following materials
 - Sikkens Autoclear PC
 - Autoclear HS+ 2 Pack
 - Autoclear Mix and Matt
 - Autoclear Xpress
 - Autoclear Energy Select LV
 - Autoclear Superior 250 2 Pack
 - Autoclear Performance LV 2 Pack
 - Autoclear 2121 LV

What to Do**Fisheyes / Craters**

- Fisheyes may be caused by silicones or other contamination. In that event apply 2 mist coats of basecoat over the contaminated area and proceed with the repair allowing longer flash times. If severe, it may be necessary to allow a dry time of 20-30 minutes, sand, and continue to spray basecoat
- Adding Anti-Silicon to basecoat is not recommended

Second Repair

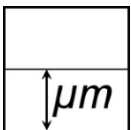
- If during the application of basecoat color, some damage occurs such as dust impregnation or perspiration spots, allow the basecoat to flash off for 20 minutes at 70°F (20°C)
- Lightly sand the damaged area with #P600 grit paper dry. Care must be taken to clean up all sanding residue
- Reapply color to the affected area as needed

Two-Tone Masking

- Basecoat can be taped (i.e. two toning) with fine line masking tape after 20 minutes flash off at 70°F (21°C) after which a second color can be applied
- Increasing temperature, especially in combination with air movement, improves the ability to apply masking. If heat is used, let the object cool down to ambient temperature before masking

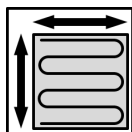
Cleaning of Equipment

- Clean equipment and dispose of waste following local and federal regulations. Use Sikkens Cleaning Solvent to clean spray gun after use
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested

Film Thickness – Using Suitable Application

- 1 Coat will achieve a thickness of 0.3 – 0.4 mils (7.6-10.2µm) dry

Theoretical Coverage



- With the recommended application the theoretical material usage is ±229 feet²/gallon (5.6m²/liter) at a 1 mil thickness (25.4 µm)
- Actual coverage is dependent on many factors. These may include the shape of the object, surface smoothness, application technique and other variables

VOC / Regulatory Information Ready to Spray



Product

- Autobase Plus (all mixtures)

VOC Lbs./Ga.

≤6.50

VOC Gr./Lt.

≤786

- 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. The optimal storage temperature is approximately 70°F (21°C)
- Refer to the 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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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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