North America

Programmed System Technique (PST)
Clearcoats
03/13/2025

Autoclear 2.0

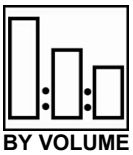
Autoclear 2.0 is a three-component polyurethane coating designed for use over Autowave basecoat. This clearcoat can accommodate a broad range of repair sizes and spraying conditions. This clearcoat technology provides exceptional gloss and robust performance when used over Autowave basecoat.

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	By Volume
3	Parts Autoclear 2.0
3	Parts Autoclear 2.0 Hardener
1	Part Autoclear 2.0 Reducer (Fast, Slow)

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

Spray-Gun Set-Up

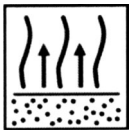
- 1.2 – 1.3mm HVLP Gravity
- 1.2 – 1.3mm Compliant Gravity

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)

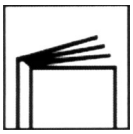
- 3 – 5 minutes

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

- 3 – 5 minutes

Drying

	104°F (40°C)	140°F (60°C)
• Autoclear 2.0 (Reducer Fast)	– 30 minutes	– 15 minutes
• Autoclear 2.0 (Reducer Slow)	– 45 minutes	– 30 minutes



Recoat Information

- After a complete drying cycle, may be recoated with additional Autoclear 2.0 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

Product	• Autoclear 2.0	– Item# 606757 (5 L)
Hardeners	• Autoclear 2.0 Hardener	– Item# 606744 (2.5 L)
Reducers	• Autoclear 2.0 Reducer Fast • Autoclear 2.0 Reducer Slow	– Item# 606748 (1 L) – Item# 606746 (1 L)
Additives		

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

Basic Raw Materials

- Autoclear 2.0
- Autoclear 2.0 Hardener
- Autoclear 2.0 Reducers

– Polyol resins
– Polyisocyanate resins
– Special solvent blends and additives

Existing Finish Substrate Preparation

Pre-Cleaning

- Before sanding, use suitable surface cleaners and techniques to ensure a clean surface.

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

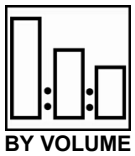
- Clean with M600 Surface Cleaner, Autoprep Ultraprep (VOC compliant) and/or Antistatic Surface Cleaner.

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

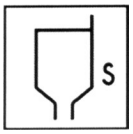
Mix	Standard Temperature Mix
3	Parts Autoclear 2.0
3	Part Autoclear 2.0 Hardener
1	Part Autoclear 2.0 Reducer Fast or Slow

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.

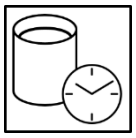
Viscosity – Ready to Spray



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

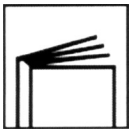
		≈70°F (20°C)	104°F (40°C)	140°F (60°C)
Autoclear 2.0 with Reducer Fast	**Dust dry**	25 minutes	10 minutes	5 minutes
	Dry to polish	16 hours	30 minutes	15 minutes
Autoclear 2.0 with Reducer Slow	**Dust dry**	45 minutes	20 minutes	10 minutes
	Dry to polish	16 hours	45 minutes	30 minutes

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).

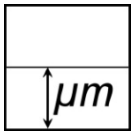
- Allow 5 minutes flash-off before infrared curing.
- Cure 4 minutes on low power followed directly by an 8-minute full-power cure.

Recoating



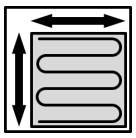
- After a complete drying cycle, may be recoated with Autoclear 2.0 within 24 hours without sanding.
- After 24 hours, sanding becomes necessary.

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^2/gal (≈20.6m^2/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	VOC Pounds per Gallon	VOC Grams per Liter
Autoclear 2.0 (ready to spray)	≤ 3.47	≤ 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.

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