

# Autowave Special Effect Colors (SEC)

Autowave 3-step Special Effect Colors (SEC) provide unique color and flip/flop effects when viewed from different angles. The special characteristics of these colors require that they be pre-packaged as ready-mix colors. Autowave Special Effect Colors are designed for custom finishing and are normally applied over a black foundation coat, followed by Sikkens clearcoat for protection and durability. In some cases, these colors are also required to match recent special option OEM colors and may be required as part of Autowave formulas.



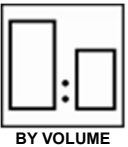
### Safety Considerations

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

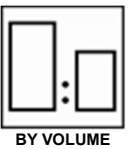


### Surface Preparation

- Sand the repair area using #P500 – #P600, dry.



- |            |                              |
|------------|------------------------------|
| <b>Mix</b> | <b>Deep Black Foundation</b> |
| <b>100</b> | Autowave MM400 Deep Black    |
| <b>10</b>  | Autowave Activator WB        |



- |            |                               |
|------------|-------------------------------|
| <b>Mix</b> | <b>Special Effect</b>         |
| <b>100</b> | Autowave Special Effect Color |
| <b>30</b>  | Autowave Activator WB         |
- Note: Up to 40 parts of WB Activator can be used in the effect for the best sprayability.



### 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 spray gun manufacturer specifications.

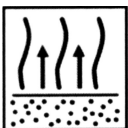


### Foundation Application

- 2-3 single coats or until covered.

### Special Effect Application

- 3-4 single coats or until covered or effect is achieved.

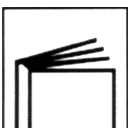


### Foundation Flash at 70°F (21°C)

- 3-5 minutes between coats
- 15-20 minutes prior to Special Effect.

### Special Effect Flash at 70°F (21°C)

- 5-7 minutes between coats.
- 20 minutes prior to clear coat.



### Recoating

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

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

**Description**

Autowave 3-step Special Effect Colors (SEC) provide unique color and flip/flop effects when viewed from different angles. The special characteristics of these colors require that they be pre-packaged as ready-mix colors. Autowave Special Effect Colors are designed for custom finishing and are normally applied over a black foundation coat, followed by Sikkens clearcoat for protection and durability. In some cases, these colors are also required to match recent special option OEM colors and may be required as part of Autowave formulas.

**Suitable Substrates**



- OEM finishes
- Stable existing finishes
- Sikkens primer surfacers and sealers.
- Do not apply over thermoplastic acrylic lacquers, in the case of lacquer, the entire lacquer finish should be removed or must be sealed with a Sikkens undercoat system.

**Products and Additives**

Product			
• AWMM 337BA 0.5L	–	SEC Blue to Red	– Item #555935
• AWMM 337BB 0.5L	–	SEC Cyan to Purple	– Item #556003
• AWMM 337GA 0.5L	–	SEC Green to Purple	– Item #556004
• AWMM 337RA 0.5L	–	SEC Red to Gold	– Item #555994
• AWMM 337RB 0.5L	–	SEC Magenta to Gold	– Item # 555939
• AWMM 337WA 0.5L	–	SEC Silver to Green	– Item #555929
• AWMM 337YA 0.5L	–	SEC Gold to Silver	– Item #555928
• AWMM 338NB 0.5L	–	SEC Orange to Red Metallic	– Item #555936
• AWMM 338NC 0.5L	–	SEC Coarse Sparkling Silver	– Item #555940
• AWMM 338ND 0.5L	–	SEC Blue Metallic	– Item #555938
• AWMM 338NF 0.5L	–	SEC Fine Sparkling Silver	– Item #556006
• AWMM 338NM 0.5L	–	SEC Medium Sparkling Silver	– Item #556008
• AWMM 338NS 0.5L	–	SEC Sparkling Silver Rainbow	– Item #556068
• AWMM 338SA 0.75L	–	SEC Silver Argentum	– Item #369093
• AWMM 339NA 0.5L	–	SEC Lilac to Blue	– Item #556069
• AWMM 339NC 0.5L	–	SEC Green to Orange	– Item #556071
• AWMM 339ND 0.5L	–	SEC Lilac Sparkle	– Item #556072
• AWMM 339NE 0.5L	–	SEC Green Sparkle	– Item #556073
• AWMM 339NG 0.5L	–	SEC Turquoise to Gold	– Item #556075
• AWMM 339NJ 0.5L	–	SEC Gold to Blue	– Item #556074

**Products and Additives, Continued**

**Hardeners**

- Sikkens WB Hardener WB (0.5 Liter) – Item #553737, #484386

**Activator**

- Autowave Activator WB – Item # 391196
  - Suitable for all temperatures.

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

**Basic Raw Materials**

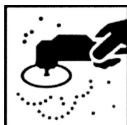
- Autowave – Physically drying binders
- Hardener WB – Polyisocyanate resins
- Autowave Activator WB – Water / Glycol mixture

**Substrate Preparation**



**Pre-Cleaning**

- If needed, prewash the repair with warm soap and water. Rinse completely with clean water.
- Regulated VOC locations: thoroughly clean the surface and remove contamination with Autoprep Ultraprep Surface Cleaner.
- National Rule locations: thoroughly clean the surface with Autoprep Ultraprep followed by M600 Surface Cleaner.



**Sanding Preparation**

**Sanding**

**Additional Information**

	Sanding	Additional Information
Existing Finishes - Dry	<ul style="list-style-type: none"> <li>● Initial - #P360-P400</li> <li>● Final - #P500-P600</li> </ul>	– Respect a maximum 100 sanding grit step difference or less throughout the sanding process.
Existing Finishes - Wet	<ul style="list-style-type: none"> <li>● Initial - #P360-P400</li> <li>● Final - #P500-P600</li> </ul>	– Respect a maximum 200 sanding grit step difference or less throughout the sanding process.



**Surface Cleaning – Prior to Paint Application**

- Regulated VOC locations: thoroughly clean the surface and remove contamination with Autoprep Ultraprep Surface Cleaner.
- National Rule locations: thoroughly clean the surface with Autoprep Ultraprep followed by M600 Surface Cleaner.



## Product Agitation



### Mixing Toner Prep and Use

- 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 Autowave toner before each pour.
- Once all of the toners in a formula have been combined, stir the paint prior to reduction and then stir again after the WB Activator has been added.



## Mixing



BY VOLUME

Mix  
100  
10

### Deep Black Foundation

Autowave MM400 Deep Black  
Autowave Activator WB



BY VOLUME

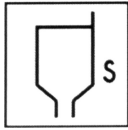
Mix  
100  
30

### Special Effect

Autowave Special Effect Color  
Autowave Activator WB

Note: Up to 40 parts of WB Activator can be used in the effect for the best sprayability.

## Viscosity – Ready to Spray



DIN #4

25-35  
Seconds

Measured with a DIN #4 viscosity cup at 70°F (21°C).

## Pot-Life When Mixed



### Product Mix

- Sikkens MM400 Deep Black Foundation
- Autowave Special Effect Colors

### At 70°F (21°C)

- 3 Months
- 1 Week

## Spray Equipment



Consult spray gun manufactures instructions for specific spray gun pressure specifications.

### Spray Gun

- HVLP Gravity Fed
- Compliant Gravity Fed

### Fluid Tip

1.3 – 1.5mm  
1.3 – 1.5mm

### Application Pressure

<10 psi (0.68 bar) at cap.  
PSI Per spray gun manufacturer.

**Application**



**Foundation Application**

- 2-3 single coats or until covered.

**Special Effect Application**

- 3-4 single coats or until covered or effect is achieved.



**Effect color application notes:**

- Apply 1 full coat, 100 % closed. Next apply an intermediate coat, 80% as wet as the first coat.
- As there is some transparency with the Special Effect Color, it is advised to apply as evenly as possible trying to avoid repeating overlaps.
- Flash dry between coats by increasing airflow and/or heat until the basecoat dries completely to a matt finish.
- If needed, apply an 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.



**Foundation Flash at 70°F (21°C)**

- 3-5 minutes between coats
- 15-20 minutes prior to special effect.

**Special Effect Flash at 70°F (21°C)**

- 5-7 minutes between coats.
- 20-30 minutes prior to clear coat.



**Flash and Drying notes:**

- Humidity and airflow influence the Autowave flash off and drying times.
- Flash can be reduced to a minimum by using air accelerator systems at approximately 3 feet (.91m) from the repair, thus increasing the airflow over the object.
- 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.
- Infra-Red heating is not recommended for flash drying of Autowave.

**Recoating**

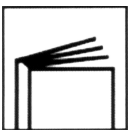


- May be clear-coated with Sikkens Clear-Coat after a minimum of 20-30 minutes.
- May be taped for two-tone after a 30-minute flash using accelerated airflow and additional heat.
- Maximum flash before clear coat of 24 hours. After 24 hours the base coat must be sanded and the color reapplied.



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

**Second Repair**



If a second repair is necessary due to surface damage during the application of the Autowave Special Effect Color system, please do the following.

- Allow the applied Autowave to flash for 20 minutes at 70°.
- Lightly dry sand the damaged area with #P600 grit paper.
- Take extra care to clean up any sanding residue.
- Reapply system as needed.

**Special Circumstances**



**Fisheyes or Cratering**

- Spray mist coats over the contaminated area flash drying between each. Proceed as normal when cratering subsides. If severe, it may be necessary to allow a dry time of 20-30 minutes, sand and continue to spray.

**Cleaning of Equipment**



- Clean equipment following local and federal regulations.
- Clean and rinse the spray gun thoroughly after use with Sikkens WB Gun Cleaner. Do not soak the spray gun for long periods with Sikkens WB Gun Cleaner or Activator WB.
- For efficient cleaning and less evaporated cleaning compounds, an enclosed automatic gun cleaning machine is suggested.
- Use compressed air to carefully dry the air passages, air cap and fluid passages as the final cleaning step.

**Film Thickness – Using Suitable Application**



- 1 Coat will achieve a thickness of 0.4-0.9 mils. (10-20µm).
- The total dry layer thickness of Autowave should never exceed 1.2 mils (30 µm).

**Theoretical Coverage**



- With the recommended application the theoretical material usage is ±334ft<sup>2</sup>/gal RTS (8.2m<sup>2</sup>/lt RTS) 1 mil at 100% transfer efficiency.
- Theoretical coverage is dependent on many factors. These may include the shape of the object, surface smoothness, application technique and other application variables among others.

**VOC / Regulatory Information**



Product	VOC Pounds per Gallon	VOC Grams per Liter
• Autowave with Autowave Activator WB:	3.50	<420

**Product Storage**



- Stock unopened or used products in approved closed containers with 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 Product Shelf Life TDS or the current price list for the most up-to-date shelf-life information. Product shelf-life is determined when products are stored unopened at 70°F (21°C).



North America

**Autowave**

**Special Effect Colors (SEC)**

FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

Technical Data Sheet

Basecoats

02/02/2024

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**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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