

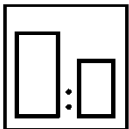
Autosealer WB

FOR PROFESSIONAL USE ONLY

Description

Autosealer WB is a water-based sealer suitable for vehicle refinishing systems in combination with all Sikkens topcoat systems. Autosealer WB is intended to be used as a wet-on-wet sealer over areas of primed or painted metal or plastic. This product is not intended for use over large areas of bare metal.

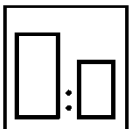
Wet-on-wet (non sanding)



100 Autosealer WB
10-20 Autowave MM666/ or AW solid MM color



Stir thoroughly



100 Autosealer WB
10 Activator WB



Use Sikkens Measuring Stick #14 (Blue)



Spray gun set-up:
1.2-1.5 mm

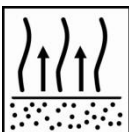
Application pressure:

1.7-2.2 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



1-2 coats



Between coats:
10-15 minutes at 75°F/25°C
Relative humidity of 30%

Before application:

30 minutes at 75°F/25°C

Relative humidity of 30%



Recoat with all Sikkens topcoats.



Use suitable respiratory protection

AkzoNobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information



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Suitable substrates

Existing finishes	Glass Reinforced Polyester laminates (GRP)
OEM electro coat	Washprimer EM CF
(sanded)	Washprimer 1K CF
Colorbuild Plus	Colorbuild Plus 250

Autosealer WB - Allow for a minimum of 15 minutes flash-off time at 70°F/20°C after Washprimer application.

Prior to application of the Autosealer WB, any polyester bodyfiller or Polysurfacer must be previously sealed with a suitable primer. Allow for sufficient flash-off time at 70°F/20°C after primer application.

Autosealer WB can be applied on plastics parts which have been preceded by Primer PO.

Product and additives

Product:	Autosealer WB
Activator:	Activator WB
Additives:	Autowave MM666 Autowave solid MM toners (for tinting purpose) <u>with the exception of MM245</u>

Basic raw materials

Autosealer WB : Water soluble acrylic resin

Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using an appropriate surface cleaner.
Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.



Sikkens primers and topcoats; finished with P500
Rigid OEM electro-coated parts; final dry sanding steps P400 – P500



Surface cleaning, remove any surface contamination prior to the application of Autosealer WB using appropriate surface cleaner. *Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser)*

Stir before use



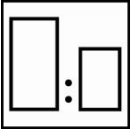
Autosealer WB must be stirred thoroughly before use.



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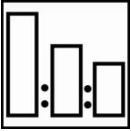
Tinting



If necessary, Autosealer WB can be tinted with up to 10-20 parts by volume with any solid Autowave MM color with the exception of MM245.

For tinting in case of a wet-on-wet (non sanding) application; replace Autowave MM666 by any solid Autowave color.

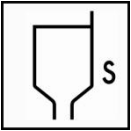
Mixing



Wet-on-wet (non sanding):

100 Autosealer WB
10-20 Autowave MM666/ AW solid MM color
Stir thoroughly
10 Activator WB

Viscosity



20-25 seconds DIN cup 4 at 70°F/20°C.

Spray gun set-up / application pressure



Spray gun

Gravity feed

Fluid tip- set-up

Wet on wet
1.3-1.5 mm

Application pressure

1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

For maximum film build use widest fluid tip and lower application pressure.

Pot-life

All Autosealer WB mixtures: 3 months at 70°F/20°C.

Application



Flush the spray gun thoroughly with Autowave Guncleaner prior to using Autosealer WB.

Wet on wet (non sanding/sealer)

Apply 1-2 full wet coats over the total area.

Film thickness

By using the recommended application
Wet on wet (2 coat); 1.0 -1.5 mils

Flash-off time wet on wet (non sanding)



Allow for a minimum Flash-off time of 30 minutes at 75°F/25°C with an approximate RH of 30% prior to any topcoat application. Apply the topcoat within 24 hours at 75°F/25°C with an approximate RH of 30%.

Allow for longer Flash-off times in case the RH is higher.

Should this maximum time be exceeded, abrade by P500 dry or P1000 wet sanding paper.

Denibbing wet on wet (non sanding)

For minor defects (e.g. dust) Autosealer WB can be denibbed with either P500 dry or P1000 wet sanding paper after the required minimum flash-off time of 30 minutes at 75°F (25°C).



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Recoatable with

All Sikkens topcoats.

Material usage

By using the recommended application the theoretical material usage is $\pm 130\text{ft}^2/\text{liter}$ RTS mixture.

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

Clean and rinse the spray gun thoroughly after use with waterborne Guncleaner.

Purge the spray gun with Activator WB prior to Autosealer WB use.

- Do not use any conventional thinner unless removing dried Autowave deposits.

Do not soak the spray gun for long periods either with Autowave Guncleaner or Activator WB.

VOC

The VOC content of this product in ready to use form is max. 1.575 lb/gal

Product storage

Product shelf-life is determined when products are stored unopened at 70°F/20°C.

Avoid extreme temperature fluctuation.

- For optimal performance, store opened products at application temperature
- Maximum transport and storage temperatures between 36°F/2°C-95°F/35°C.
- Frost causes gelling / lumps in Autosealer WB after which it no longer can be used.

Shelf Life

Autosealer WB 1 year at 70°F (20°C)

Activator WB: 3 years at 70°F (20°C)

Autowave MM 666: 2 years at 70°F (20°C)

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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 Material 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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