

Description

Autowave waterborne basecoat provides excellent coverage, metallic control and sprayability when used to duplicate OEM solid, metallic and pearl color effects. Autowave must be used in conjunction with a Sikkens clearcoat in order to provide protection from the environment.

Suitable substrates

- All Existing OEM finishes, with the exception of thermoplastic acrylic finishes.
- All current Sikkens preparatory products.
With the exception of direct application on acid containing washprimers and Sikkens aerosol Spot Primers.

Product and additives

- Product:** Autowave MM (Mixing Machine) colors
 - Activator:** Activator WB, the Autowave waterborne basecoat activator to use for all repair sizes and all application conditions. (approximately 75°F (24°C) and higher with a relative humidity range between 20% to 80%).
 - Hardener** Hardener WB – Addition of 5 – 10% is sufficient to improve system robustness or in the case of multi-layer application. Required for OEM warranty repairs.
 - Additives:**
 - Autowave Additive LP, to extend the pot-life of Autowave metallic colors.
 - Autowave Gun cleaner
 - Autowave Separator
- o *No plasticizer required for application on plastic car parts.*

Basic raw materials

Water based acrylic dispersion

Surface preparation



- Dry sanding with final sanding step #P500 to #P600
- o Initial sanding steps may be executed with a coarser sanding grit; for example, #P360 - #P400
 - o Respect a maximum 100 sanding grit step difference or less throughout the taken sanding steps.



- Wet sanding with final sanding step #P800 to #P1000
- o Initial sanding steps may be executed with a coarser sanding grit #P600
 - o Respect a maximum 200 sanding grit step difference or less throughout the sanding steps.



- Surface Cleaning:
- Remove any surface contamination prior to topcoat application using appropriate surface cleaners.



Material preparation and mixing

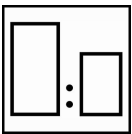


Agitate/ gently shake Autowave several times before use for optimal pour viscosity of the MM toners prior to mixing.

- o Autowave MM 888 Metallic toners must be shaken or stirred thoroughly before using for the first time; thereafter they should be agitated / shaken as recommended for all other MM toners.



The Autowave MM colors must be stirred thoroughly, directly after mixing the formula.



Add 20 parts Activator WB as standard mixing ratio to all Autowave colors.

For accurate mixing always use the Sikkens measuring stick #14 (blue) or mix on the scale using Addit.

- o Mix Deep Black, MM245 with up to a maximum of 10 parts Activator WB.

Climate condition; high temperature / low humidity (*humidity is considered low @ RH 40% or less*)

- o Add up to 50 parts of Activator WB to Autowave metallic colors for optimal sprayability.
- o Do not add more than a maximum of 20 parts Activator WB to Autowave solid colors.
- o At 40% or higher relative humidity, a minimum amount (10 parts) of Activator WB can be added to Autowave solid colors.

Color mixing by hand: If a pure Autowave Metallic MM888 toner is used for application, mix 4 parts MM666 with 1 part of the metallic MM888 toner.

Autowave MM solid toners do not require the addition of MM666 binder for application.

Points of attention

Filtering:

Use waterborne suitable paint strainers for optimal filtering, use a 125 micron filter. (125µm).

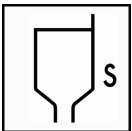
Application:

In the event of a black pre-coat requirement i.e. Special Effect Colors, use deep black MM400 (RTS)

Solvents:

Avoid contact between waterborne products and any conventional solvents.

Spray viscosity



20–30 seconds DIN cup #4 at 70°F (20°C).

Spray gun set-up / application pressure



Spray gun

Gravity feed

Fluid tip –set up

1.4 – 1.5mm

Application pressure

29 psi at the spray gun air inlet

HVLP max 10 psi at the air cap

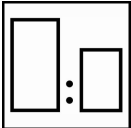
Check gun manufacturer specification

Pot-life

All mixed solid and pearl Autowave colors:	3 months at 70°F (20°C).
Autowave Metallic colors, containing toner MM888:	1 week at 70°F (20°C).
Autowave Metallic colors containing MM777:	1 day at 70°F (20°C).

To obtain a 3 month pot-life for all Autowave metallic colors add Autowave Additive LP.

Adding Autowave Additive LP: Thoroughly stir the MM toners after mixing, then add 5 parts (by weight) Autowave Additive LP. Stir thoroughly before adding Activator WB, stir once more prior to use.



- o Do not use Autowave Additive LP in solid colors.

Application process



Solid colors

Apply 2 single coats or until opacity is achieved. Flash off between coats by increasing airflow and or heat until the basecoat dries completely to a matt finish. If necessary allow the surface to cool. Dry for a minimum of 15 minutes (max. 24 hours) at 75°F (24°C) prior to clearcoat application.

Metallic / pearl colors

Apply 1 full coat, 100 % closed coat,. Next apply an intermediate coat, 80 % of the first coat, Flash off between coats by increasing airflow and or heat until the basecoat dries completely to a matt finish. If necessary allow the surface to cool.

When needed, apply an orientation coat . Increase the distance to approximately 12 to 14 inches and apply a light coat with no wet areas.

Dry for a minimum of 15 minutes (max. 24 hours) at 75°F (24°C) prior to clearcoat application.

- o Thorough drying after basecoat application is necessary.

Spot repairs (for detailed information on spot repair. please see TDS Autowave Spot Repairs)

When making spot repairs apply thin coats until opacity is achieved. Dry until matt between each coat before fading out well beyond the edges.

In case of metallic colors lower air pressure may be needed for color control. Extend each coat until coverage is obtained. Finally apply an orientation coats fading out well beyond the coverage coats.

- o In the case of high hiding colors and fading out, the color transparency can be increased by adding MM 666 RTS to the RTS mixed color, at a ratio of 100 parts color and 50 parts MM666.

Drying and air acceleration

Humidity and airflow will influence the Autowave flash off and drying times. These times can be reduced to a minimum by using air accelerator systems with a distance of 3 feet from the object, thus increasing the airflow over the object.

When heat is used for drying, allow object to cool down to application temperature before proceeding with color or clearcoat application.

Film thickness

Autowave solid, metallic and pearl colors: 0.4-0.9 mils.
The total dry layer thickness of Autowave should never exceed 1.2 mils.

Masking

Autowave colors can be taped (i.e. two toning) after 20 minutes flash-off at 75°F (24°C).

- *Increasing temperature especially in combination with air movement improves the ability to apply masking on Autowave.*
- *Let the object cool down to ambient temperature before masking.*

Denibbing

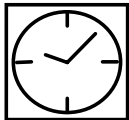
Allow Autowave to dry sufficiently, at least 20 minutes at 75°F (24°C). Then lightly dry sand the damaged area with #P600 to #P1000 free-cut sanding paper. Thoroughly remove sanding dust residue before continuing Autowave application.

Recoatable with

-Autoclear HS + LV.
-Autoclear Superior 250.
-Autoclear HS + (national VOC rule)

Recoat time

Prior to clearcoat application:



Minimum 15 minutes at 75°F (24°C).

Maximum 24 hours at 75°F (24°C).

- *After the final coat has flashed off increase airflow for the 15 minutes at 75°F (24°C)*
- *Thorough drying after basecoat application is necessary.*
- *Should this maximum time be exceeded, abrade the surface and apply another coat.*

Material usage

Theoretical material usage is ± 64 sq.ft./litre 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 Autowave Gun Cleaner.

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

- *Do not use any conventional thinner unless removing dried Autowave deposits.*
- *Do not soak the spray gun for long periods either with Autowave Gun cleaner or Activator WB.*

VOC

Autowave, unreduced: 2.9 lb. / gallon (348 gr/lit)



The VOC content of this product in ready to use form is <3.5 lb. /gallon. (<420 gr/lit)

Storage

Product shelf-life is determined when products are stored unopened at 70°F (20°C).
Avoid too much temperature fluctuation.



- o *For optimal performance, allow the ready to spray material to reach the application temperature before application*
- o *Maximum transport and storage temperatures between 36°F-95°F (2°C and 35°C).*
- o *Frozen Autowave toners causes gelling / lumps after which these toners can no longer be used.*
- o *Product shelf life data see TDS S9.02.01*

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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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