

# Autoclear HS+ 2 Pack

FOR PROFESSIONAL USE ONLY

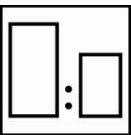
## Description

Autoclear HS+ 2 Pack is a high solids acrylic urethane clearcoat for use over Autobase Plus® and Autowave. Autoclear HS+ 2 Pack offers high gloss and is designed for baking conditions. It can be used with the Manual Proportioning Unit (MPU) at 2:1 mix ratio. It is designed to be sprayed over small or large areas in various temperature ranges.



### Use suitable respiratory protection

Contains acrylic resins, xylene and other ingredients. When mixed, Autoclear Mat also contains isocyanates.



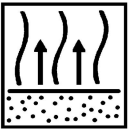
2:1:  
Autoclear HS + 2 PK Fast/Slow  
Autoclear HS + 2 PK Hardener



Use the Sikkens Measuring Stick #1



2 x 1  
HVLP Siphon – 0.070"-0.090 (1.8 – 2.2mm)  
HVLP Gravity – 0.055"-0.060 (1.4 – 1.5mm)  
Max 10 psi (max 0.8 bar)



6-10 minutes at 70°F (20°C)



Autoclear HS + 2 PK Hardener (Slow)  
7 hours at 70°F (20°C)  
35 minutes at 140°F (60°C)

Read complete TDS for detailed product information



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## Product and additives

<b>Product:</b>	-Autoclear HS+ 2PK (Fast) -Autoclear HS+ 2PK (Slow)
<b>Hardeners:</b>	-Autoclear HS + 2 PK Hardener: General purpose hardener for all repair sizes.
<b>Additives</b>	-Autocryl Elast-o-Actif: Added to increase flexibility on flexible parts -Sikkens LV 250 Accelerator

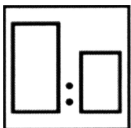
## Basic raw materials

- Autoclear HS + 2PK Fast: hydroxyl acrylic resins
- Autoclear HS + 2PK Slow: hydroxyl acrylic resins
- Autoclear HS + 2PK Hardener: polyisocyanate resins
- Elast-o-Actif : Special polyester resin

## Suitable surfaces

- Sikkens Autobase Plus® Solid, Metallic and Pearl Colors: after a flash-off time of 15–20 minutes at 70°F (20°C).
- Existing finishes that have been sanded and degreased. In the case of spot repairs and blending.
- Autowave, after flash-off time of 15-20 minutes at 70°F(20°C)

## Mixing ratio



### Standard Ratio:

2 parts by volume of Autoclear HS + 2 PK Fast or Slow to accommodate spraying conditions  
1 part by volume of Autoclear HS + 2 PK Hardener

### Flexible parts – Post Addition of Elast-O-Actif:

2 parts by volume of Autoclear HS + 2 PK Fast or Slow to accommodate spraying conditions  
1 part by volume of Autoclear HS + 2 PK Hardener  
+10% Autocryl Elast-O-Actif

### Flexible parts – Pre Addition of Elast-O-Actif:

1 part by volume of Autoclear HS + 2 PK Fast or Slow plus 20% Autocryl Elast-O-Actif.  
Then  
2 parts by volume of Autoclear HS + 2 PK/ Autocryl Elast-O-Actif mixture  
1 parts part by volume of Autoclear HS + 2 PK Hardener

### Accelerated System:

2 parts by volume of Autoclear HS + 2 PK Fast or Slow to accommodate spraying conditions  
1 part by volume of Autoclear HS + 2 PK Hardener  
+0.50 oz. (15 ml) Sikkens LV250 Accelerator per ready to spray quart

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## Spraying viscosity

13-15 sec. DIN cup #4 at 70°F (20°C)

## Potlife

2 hours at 70°F (20°C) using Autoclear HS + 2 PK Fast  
2 hours at 70°F (20°C) using Autoclear HS + 2 PK Slow

## Spray gun & pressure

	Fluid Tip	Spraying Pressure
HVLP Siphon	0.071"–0.087" (1.8–2.2 mm)	8 – 10 psi at cap (0 .65 – 0.8 bar at cap)
HVLP Gravity	0.055"–0.059" (1.3 - 1.5 mm)	8 – 10 psi at cap (0 .65 – 0.8 bar at cap)

## Application method

Apply 2 single wet coats. If heavy sanding and polishing is required, a third coat may be applied after the stated flash off time.

## Flash Times

6–10 minutes at 70°F (20°C) between coats

## Dry Times

Below is a table showing the drying times of Autoclear HS + 2PK with Autoclear HS+ 2 PK Hardener. The air-dry times stated may increase with insufficient airflow.

Metal Temp.	Drying	Autoclear HS + 2PK (Slow)	Autoclear HS + 2PK (Slow) w/EOA	Autoclear HS + 2PK (Slow) w/.050 LV250 Accel
70°F (20°C)	Dust Free	1 hr	2 hr	1 hr 15 min
	Dry	7 hr	8 hr	4.5 hr
140°F (60°C)	Dust Free	20 min	20 min	18 min
	Dry	35 min	45 min	25 min

Metal Temp.	Drying	Autoclear HS + 2PK (Fast)	Autoclear HS + 2PK (Fast) w/EOA	Autoclear HS + 2PK (Fast) w/.050 LV250 Accel
70°F (20°C)	Dust Free	45 min	60 min	45 min
	Dry	5 hr	6 hr	3.5 hr
140°F (60°C)	Dust Free	10 min	12 min	10 min
	Dry	20 min	25 min	15 min

# Autoclear HS+ 2 Pack

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**Recoatability**

Autoclear HS + 2 PK can be re-coated with itself at any stage. Sanding will become necessary after 12 hours.

**Film thickness**

1.2–2.0 mils per single coat

**Coverage rate**

Approximately 103 sq. ft./liter of unmixed paint at a film thickness of 2.5 mils

**Polishing**

Dust and minor damage can be polished out after the stated air-dry times have been reached, or after a full bake at 140°F(60°C) metal temperature followed by a cool down of panel to ambient temperature. Carefully sand out dust particles with #10 micron (#1500) grit paper wet, and then polish the area manually or mechanically.

**Note:** When heavy color sanding and rubbing are required, it may be necessary to apply one extra coat of Autoclear HS + 2PK.

**Decals**

Decals can be applied after 48 hours at 70°F (20°C)

**Lettering**

Hand striping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a gray scuffing pad.

**Cleaning of Equipment**

Clean equipment with Sikkens Cleaning Solvent 790 or lacquer thinner.

**Stock Keeping**

**Color:** Clear

**Shelf life:**

Autoclear HS + 2PK Fast/Slow Two years if stored unopened at room temperature.

Autoclear HS + 2PK Hardener One year if stored unopened at room temperature.

**VOC / Regulatory Information****Ready to Spray VOC**

(2:1)

When mixed ready to spray

Autoclear HS + 2PK yields a VOC content of: 4.25 lb/gal 510 g/liter

**Notice:** Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-





North America

Technical Data Sheet S1.05.13

Clear Coat  
January 4, 2013

# Autoclear HS+ 2 Pack

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supplied respirator when exposed to vapors or spray mist.

**AkzoNobel Car Refinishes Inc. North America**

**Address: 3587 Parkway Lane, Norcross. GA 30092 USA**

**Tel: 770-662-8464**

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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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### Head Office

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