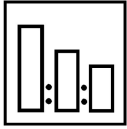


Description

Autoclear III is a National Rule compliant acrylic urethane clearcoat for use with Sikkens basecoats. The product can be used as a high gloss clearcoat or as an ultra productive clearcoat in both air-dry and baking environments with the use of different hardener and activator combinations.



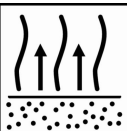
100:50:30
Autoclear III
Standard Hardener
Standard Activator



Use Sikkens Measuring Stick #1 (Black)



2x1
HVLP-Siphon
1.8–2.2 mm
HVLP-Gravity
1.4–1.5 mm



5 minutes at 70°F (20°C)



Sikkens Standard Hardener
Sikkens Standard Activator
10 hours at 70°F (20°C)
30 minutes at 140°F (60°C)



Use suitable respiratory protection

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

Read complete TDS for detailed product information

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Product and additives

- Product:** Autoclear III
- Hardeners:**
- Sikkens Standard Hardener: a general-purpose standard hardener for all repair sizes
 - Sikkens XP Hardener: a general-purpose standard hardener for all repair sizes
Designed to improve the performance of Autoclear III when used in air-dry at cooler temperatures.
- Activators:**
- Sikkens Extra Slow Activator: an extra slow activated reducer for larger areas and overall refinishing in very warm weather. Temperatures of 90°F (32°C) and above.
 - Sikkens Standard Activator: a general-purpose activated standard reducer for larger areas and overall refinishing. Temperatures from 60°F–105°F (16°C–38°C).
 - Sikkens Medium Activator: an activated Medium reducer for medium and spot and panel repairs. Temperatures from 60°F–90°F (16°C–32°C).
 - Sikkens Rapid Activator: an accelerated activated reducer for spot and panel repairs at 55°F-85°F (15°C-28°C)
- Additives:**
- Autocryl Extratop: a catalyst additive, providing faster hardening of Autoclear III.
 - Autocryl Elast-O-Actif: additive to increase flexibility of Autoclear III; for use on flexible and soft foam (PUR) parts.
 - Autoclear Mat: a special clearcoat with a matt finish. The gloss level of Autoclear III can be reduced with the blending of Autoclear Mat. The main application is on plastic parts.

Basic raw materials

- Autoclear III: hydroxyl acrylic resins
- Standard Hardener and XP Hardener: polyisocyanate resins
- Standard Activator: special activated solvent blends
- Medium Activator and Rapid Activator: activated reducers containing special solvent blends and catalyst.

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, see TDS “Spot Repairs with Autobase Plus”.

Mixing ratios

- 100 parts by volume of Autoclear III
- 50 parts by volume of Sikkens Standard Hardener
- 30 parts by volume of Sikkens Standard, Medium or Rapid Activator
- For easy and accurate mixing, use the Sikkens Measuring Stick #1 (Black).

Autoclear® III

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Mixing ratio using XP Hardener

100 parts by volume of Autoclear III
33 parts by volume of Sikkens XP Hardener
50 parts by volume of Sikkens Standard, Medium or Rapid Activator

Note: For easy and accurate mixing, use the Sikkens Measuring Stick # 25 (Light Blue).

Spraying viscosity

12-14 seconds – DIN Cup #4 at 70°F (20°C)

Pot life

4 hours at 70°F (20°C) using Standard Activator
2 hours at 70°F (20°C) using Medium Activator
1 hour at 70°F (20°C) using Rapid Activator

Spray gun and pressure

	Fluid Tip	Spraying Pressure
Siphon Feed	40-50 ps	40-50 psi
Gravity Feed	40-50 psi	40-50 psi
HVLP Siphon	1.8-2.2 mm	max 10 psi (at air cap)
HVLP Gravity	1.4-1.5 mm	max 10 psi (at air cap)

Application method

Apply two single wet coats. If heavy sanding and polishing are required, a third coat may be applied after a stated flash-off time.

Note: For clearcoat spot repair and over reduction (sail panel blends), use Sikkens reducer SRA 7.0. Please see TDS "Spot Repair with Autobase Plus".

Flash times

5–7 minutes at 70°F (20°C) with Extra Slow Activator
3–7 minutes at 70°F (20°C) with Standard Activator
1–5 minutes at 70°F (20°C) with Medium Activator
No flash at 70°F (20°C) with Rapid Activator

Drying times

Autoclear III with Standard Hardener

Metal Temp.	Drying	Extra Slow Activator	Standard Activator	Medium Activator	Rapid Activator
70°F (20°C)	Dust Free	90 min	1 hr	35 min	30 min
	Dry	12 hr	10 hr	7 hr	4 hr
140°F (60°C)	Dust Free	25 min	20 min	15 min	7 min
	Dry	35 min	30 min	20 min	10 min

Autoclear® III

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Below is a table showing the drying times of Autoclear III and Standard Hardener with the addition of Autocryl Extratop.

Metal Temp.	Extra Slow Activator	Standard Activator	Medium Activator	Rapid Activator
70°F (20°C)	9 hr	7 hr	4 hr	NA
140°F (60°C)	30 min	25 min	15 min	NA

Autoclear III with XP Hardener

Metal Temp.	Drying	Extra Slow Activator	Standard Activator	Medium Activator	Rapid Activator
70°F (20°C)	Dust Free	1 hr	50 min	30 min	25 min
	Dry	10 hr	8 hr	5 hr	3 hr
140°F (60°C)	Dust Free	20 min	15 min	10 min	7 min
	Dry	35 min	30 min	20 min	10 min

Below is a table showing the drying times of Autoclear III and XP Hardener with the addition of Autocryl Extratop.

Metal Temp.	Extra Slow Activator	Standard Activator	Medium Activator	Rapid Activator
70°F (20°C)	9 hr	7 hr	4 hr	NA
140°F (60°C)	30 min	25 min	15 min	NA

Note: Immediately after the last coat of Autoclear III, it may be baked. In all cases, minimize flash-off times before bake.

Recoatibility

Autoclear III can be recoated with itself at any stage. Sanding will become necessary after 12 hours.

Film thickness

Approximately 1.2–1.5 mils (30-37µm) per coat.

Cover rate

Approximately 110 sq. ft./liter of unmixed paint at a film thickness of 3.0 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.

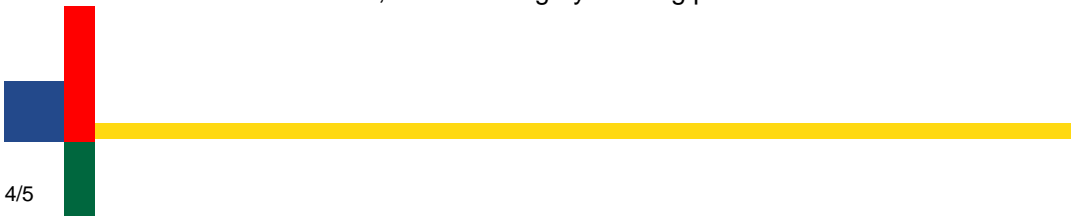
Note: When heavy color sanding and rubbing are required, it may be necessary to apply one extra coat of Autoclear III.

Decals

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

Lettering

Enamel striping or lettering on Autoclear III must be applied within 48 hours for good adhesion. After 48 hours, scuff with a grey scuffing pad.



Cleaning of equipment

Clean equipment with Sikkens Cleaning Solvent 790 or lacquer thinner.

Stock keeping

Color:	Clear	
Container size:	-Autoclear III:	-1 gallon (3.785 lt)
	-Sikkens Standard Hardener:	-1 gallon (3.785 lt)
	-Sikkens XP Hardener :	-1 gallon (3.785 lt)
	-Extra Slow, Standard, Medium and Rapid Activator:	-1 gallon (3.785 lt)
Shelf life:	-Autoclear III:	-One year if stored unopened at room temperature
	-Standard/XP Hardener:	-One year if stored unopened at room temperature
	-Standard, Medium and Rapid Activator:	-One year if stored unopened at room temperature

Safety aspects

Ready to spray VOC:

Autoclear III, when mixed ready to spray, yields a VOC content of:

With Standard Hardener, (100:50:300): 4.0 lb/gal 490 g/liter

With XP Hardener, (100:33:50): 3.8 lb/gal 456 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 protective equipment when mixing and spraying this material. Protect skin with gloves and spray suit, wear safety glasses or goggles when mixing, and wear a full hood fresh air-fed respirator while spraying.

Akzo Nobel 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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