

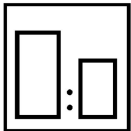
Autoclear[®] PC

For use with the Sikkens Manual Proportioning Unit

FOR PROFESSIONAL USE ONLY

Description

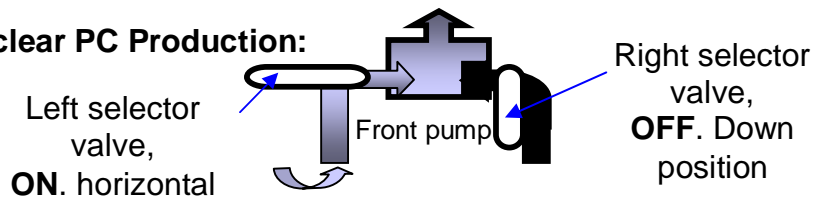
Autoclear PC is a series of clearcoat products that is national rule VOC compliant when combined with Sikkens Autobase Plus. An acrylic urethane clearcoat system, for use with the Sikkens Manual Proportioning Unit. Because of the Akzo Nobel Coatings Inc. proprietary packaging and equipment, very accurate product blending and automated mixing is obtainable with very little waste. This equipment allows the technician to choose within seconds, a high gloss clearcoat, an ultra productive clearcoat or something in between.



100 Autoclear PC Production or Autoclear PC Standard
50 Autoclear PC Hardener

Product selector:

Example for Autoclear PC Production:



Having dispensed the material.
- Stir or shake the proportioned material thoroughly.

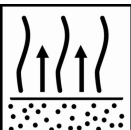


Spray gun set-up:
1.3-1.5 mm

Application pressure:
40–50 psi (2.7-3.4 bar) at the air inlet
HVLP max 10 psi (0.7 bar) at the air cap



2 x 1 coat



Autoclear PC selection
Autoclear PC Production
Autoclear PC Standard
Combination Production/Standard

Between Coats
No flash off
3-7 min at (20°C) 70°F
1-5 min at (20°C) 70°F

Before Curing
Minimum flash off



Autoclear PC selection
Autoclear PC Production
Autoclear PC Standard
Combination Production/Standard

70°F (20°C)
4 hours
10 hours
7 hours

140°F (60°C)
10 minutes
30 minutes
20 minutes



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends to use fresh air supply respirator.

Read complete TDS for detailed product information



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Product and additives

- Products:** -Autoclear PC; Item # 391297
-Autoclear PC Production; Item # 391298
- Hardener:** -Autoclear PC Hardener; Item # 391299
- Additives:** -Autocryl Extratop; a catalyst additive, providing faster through hardening.
-Elast-o-Actif; additive to increase flexibility level for use on flexible plastic parts.

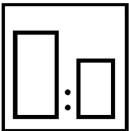
Basic raw materials

- Autoclear PC Standard and Production: hydroxyl acrylic resins
-Autoclear PC Hardener: polyisocyanate resins

Suitable surfaces

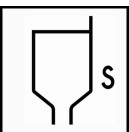
- Autobase Plus; after a minimum flash off time of 15 minutes at 70°F (20°C)
-Existing finish, in the case of spot repair and blending. See TDS
"Spot Repairs with Autobase Plus"

Mixing ratios



- A/-** 2 parts Autoclear PC Production = [Left valve on, right valve off]
1 part Autoclear PC Hardener
- B/-** 2 parts Autoclear PC Standard = [Right valve on, left valve off]
1 part Autoclear PC Hardener
- C/-** 1 part Autoclear PC Production = [Left valve on]
1 part Autoclear PC Standard = [Right valve on]
1 part Autoclear PC Hardener

Viscosity



13-14 seconds. DIN Cup #4, 70°F (20°C)

Spray gun and pressure



Spray gun	Fluid tip – set up	Application pressure
Gravity	1.3-1.5 mm	40–50 psi at the spray gun air inlet
Suction feed	1.4-1.7 mm	HVLP max 10 psi at the air cap
*High Transfer Gravity	1.3-1.5 mm	*35 psi at the spray gun air inlet

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Application process & blending



Apply two single wet coats; flash-off time between coats and before bake related to clear selection.

- Recoatable with itself at any stage, sanding becomes necessary after 12 hours.
- Fade out (sail panel blends). Apply two coats, extend the second coat into the sail panel, allow 2 to 5 minutes after the last coat and spray pure Sikkens Reducer SRA 7.0. Apply one up to two medium coats with approximately 15 seconds flash time. See TDS Sikkens Reducer SRA 7.0.

When sanding and heavy polishing is required, a third coat may be applied after the stated flash-off times.

Flexible plastic parts

Having dispensed the required amount of proportioned Autoclear PC into a cup. Add 10% Autocryl Elast-O-Actif to the ready to spray mixture. Use the #14 measuring stick; stir this mixture thoroughly before application.

Pot-life

Autoclear PC Production;	1 hour at 70°F (20°C)
Autoclear PC Standard;	4 hours at 70°F (20°C)
Combination of Autoclear Production/Standard;	2 hours at 70°F (20°C)

- *As temperature increases 18°F (10°C) the pot-life decreases 50%*

Film thickness

For recommended application: 2.4-3.0 mils (60-70 µm)

Drying times




		Autoclear PC Production	Combination of Autoclear PC Production/Standard	Autoclear PC Standard
70°F 20°C	Dust dry	30 minutes	35minutes	1 hour
	Dry to handle	4 hours	7 hours	10 hours
140°F 60°C	Dust dry	7 minutes	15 minutes	20 minutes
	Dry to handle	10 minutes	20 minutes	30 minutes

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Autoclear PC with the addition of Autocryl Extratop

		Autoclear PC Production	Combination of Autoclear PC Production/ Standard	Standard Activator
70°F (20°C)	Dry to handle	NA	4 hours	7 hours
140°F (60°C)	Dry to handle	NA	15 minutes	25 minutes



Distance between short wave IR unit and object. 20 –27 inch (50-70 cm)

Allow 3 to 5 minutes flash off before Infra red curing

Cure 6 minutes low power setting and 6 minutes high power setting

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) object temperature, followed by a cool down of the object to ambient temperature.

Carefully sand out dust particles and restore the surface according to polishing recommendations.

Decals - striping

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

Material usage

With recommended application, the theoretical material usage is approximately; 77 sq.ft./liter (7 m²/liter) ready to spray mixture.

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

Cleaning of equipment

–Clean spray equipment with Sikkens Cleaning Solvents or laquer thinner.

–Sikkens Manual Proportioning Unit. After each use make sure the pump handle is in the lowest position, keep ¼ to ½ “of solvent in the wetting cup and screw to the dispensing head assembly.

For a description on the use of the dispensing equipment, please see the “Set Up and Functions of the Sikkens Manual Proportioning Unit” instructional manual.

Stock keeping

Autoclear PC (100:50):

4.0 lb/gal (490 g/l) ready to spray mixture.

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Product storage

Store products unopened between 70°F and 95°F (10°C and 35°C)
Avoid too much temperature fluctuation, optimal storage temperature \pm 70°C (20°C).

Shelf Life:

- Autoclear PC Standard and Autoclear PC Production:
1 year if stored unopened.
- Autoclear PC Hardener:
6 months if stored unopened.

Akzo Nobel Car Refinishes Inc. North America**Address: 3587 Parkway Lane, Norcross. GA 30092 USA****Tel: 770-662-8464****FOR PROFESSIONAL USE ONLY**

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 OfficeAkzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com