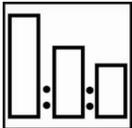


# Autoclear® Xcel

FOR PROFESSIONAL USE ONLY

## Description

Sikkens Autoclear® Xcel is a two component clearcoat system which provides excellent flow, gloss and a smooth finish. It is easy to apply and suitable for all types of repairs, in most application conditions.



100 Autoclear® Xcel  
50 P15/P20 Hardeners  
5 Plus Reducers

100 Autoclear® Xcel  
50 P25/P35 Hardeners  
10 Plus Reducers



Use Sikkens measuring stick

**3** Purple

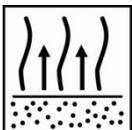


Spray gun set-up:  
1.2-1.5mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



2 x 1 coat  
First apply a medium closed coat, next apply a full coat after indicated flash off time



Between coats  
5-10 minutes at 20°C  
Reducer selection according temperature

Before curing  
10-15 minutes at 20°C  
Flash-off time depending on oven type



Product selection  
P15 Hardener  
P20 Hardener  
P25 Hardener  
P35 Hardener

Product selection	20°C	60°C
P15 Hardener	2 hours	25 minutes
P20 Hardener	2 hours	25 minutes
P25 Hardener	4.5 hours	30 minutes
P35 Hardener	7 hours	35 minutes



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

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## Description

Sikkens Autoclear<sup>®</sup> Xcel is a two component clearcoat system which provides excellent flow, gloss and a smooth finish. It is easy to apply and suitable for all types of repairs, in most application conditions.

## Product and additives

**Clearcoat** Autoclear<sup>®</sup> Xcel

**Hardener** P15 Hardener; spot and panel repairs at 15°C-20°C  
P20 Hardener; spot and panel repairs at 20°C-25°C  
P25 Hardener; spot and panel repairs at 20°C-30°C  
P35 Hardener; larger areas and overall refinishing at 20°C-40°C

**Reducer** Plus Reducer Fast; spot and panel repairs, temperature range: 15°C-25°C.  
Plus Reducer Medium; spot and panel repairs and large areas, temperature range: 20°C-30°C.  
Plus Reducer Slow; larger areas and complete paint jobs, temperature range: 25°C-35°C.  
Plus Reducer Extra Slow; to use in extremely hot temperatures, temperature range: above 35°C.

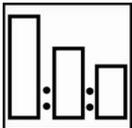
## Basic raw materials

Autoclear<sup>®</sup> Xcel: Acrylic and polyester resins  
P Hardener: Poly-isocyanate resins

## Suitable substrates

Autobase Plus; after a minimum flash off time of 15 minutes at 20°C  
Autowave; after a minimum flash off time of 15 minutes at 25°C

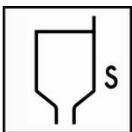
## Mixing



**100** Autoclear<sup>®</sup> Xcel  
**50** P Hardeners  
**5-10** Plus Reducers

Use measuring stick No. 3 Purple

## Viscosity



16-17 seconds – DIN Cup 4 at 20°C.

## Spray gun set-up / application pressure



**Spray gun**  
Gravity feed

**Fluid tip – set-up**  
1.2-1.5 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

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## Application process & blending



Apply a medium closed coat, allowing for a 5-10 minutes flash-off time at 20°C.  
Next, apply a full coat, allowing for a 5-10 minutes flash-off time at 20°C before baking.  
Flash-off between coats; in case of application to larger areas, flash off between coats is minimal.  
Recoat with itself after full drying cycle, sanding becomes necessary after 24 hours  
When sanding and heavy polishing is required, a third coat may be applied after the stated flash-off times at 20°C.

## Pot-life

P15 Hardener	2.5 hours	at 20°C
P20 Hardener	2.5 hours	at 20°C
P25 Hardener	3 hours	at 20°C
P35 Hardener	>3 hours	at 20°C

## Film thickness

By using the recommended application: 45-50 µm (2 coats)  
Minimum film thickness for longevity of clearcoat 50 µm

## Drying times

Allow for a minimum of 5 minutes flash-off time at 20°C before moving the car into a pre-heated drying oven (booth) at 60°C. All drying times relate to standard application and object temperature. Consider the time required for the spraybooth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object.



	P15 Hardener	P20 Hardener	P25 Hardener	P35 Hardener
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20°C	Dust dry	11 minutes	11 minutes	20 minutes	40 minutes
	Dry to handle*	2 hours	2 hours	4.5 hours	7 hours

60°C	Dust dry	5 minutes	5 minutes	5 minutes	8 minutes
	Dry to handle*	25 minutes	25 minutes	30 minutes	35 minutes



Dry to handle after approximately 10 minutes.  
Allow 5 minutes flash off prior to infra red curing.  
The panel must not reach a temperature above 100°C while curing.

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## Polishability



Dust and minor imperfections can be polished out after the stated air-dry times have been reached, or after a full bake at 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 polishing recommendations.

Ready to polish approximately 1 hour after cool down to ambient temperature.  
3M: standard Sikkens polishing procedure

## Theoretical Coverage

By using the recommended application, the theoretical material usage is  $\pm 5.27$  m<sup>2</sup>/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

Sikkens Solvents or solvent borne guncleaners

## VOC

The VOC content of this product in ready to use form is 559 g/liter RTS mixture.

## Product storage

Product shelf-life is determined when products are stored unopened at 20°C.  
Avoid extreme temperature fluctuation.  
Product shelf life data see TDS S9.01.02

### Akzo Nobel Car Refinishes (Singapore) Pte Ltd

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#### 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 Office

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