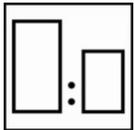


Autoclear® Xpress

FOR PROFESSIONAL USE ONLY

Description

Autoclear® Xpress is a fast drying 2 component clearcoat system, suitable for use on all types of repairs and in most application conditions in combination with Autobase Plus. No extra thinner is needed to get optimum gloss and flow. Good air drying clear with quick flash-off.



100 Autoclear Xpress
50 P Hardeners



Use Sikkens measuring stick

3 Purple

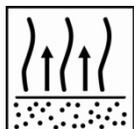


Spray gun set-up:
1.2-1.5mm

Application pressure:
1.7-2.2 bar at the air inlet



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



Between coats
3-5 minutes at 20°C

Before curing
10-15 minutes at 20°C
Flash-off time depending on temperature and air velocity



Drying	20°C	30°C	60°C
P15 Hardener	5 hours	4 hours	20 minutes
P20 Hardener	5 hours	4 hours	20 minutes
P25 Hardener	7 hours	5 hours	25 minutes
P35 Hardener	9 hours	7 hours	30 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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Product and additives

Autoclear Xpress

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

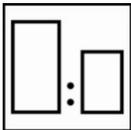
Basic raw materials

Autoclear Xpress: Acrylic resins
 P Hardener: Poly-isocyanate resins

Suitable substrates

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

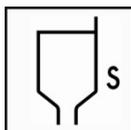
Mixing



100 Autoclear Xpress
 50 P Hardeners

Use measuring stick No. 3 Purple

Viscosity



13-16 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

Application process & blending



Apply a medium closed coat, allowing for a 3-5 minutes flash-off time.
 Next, apply a full coat, allowing for a 10-15 minutes flash-off time before baking at 60°C.
 Flash-off between coats; in case of application to larger areas, flash off between coats is minimal.
 Recoatable with itself after full drying cycle, sanding becomes necessary after 24 hours
 For blending (spot repair and panel blends), see TDS S8.01.01.
 Note: The specified flash-off times depend on temperature and air velocity.

Autoclear[®] Xpress

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Pot-life

P25 Hardener	1.5 hours	at 20°C
P35 Hardener	3.0 hours	at 20°C

Drying times

Allow for a minimum of 10 minutes flash off time 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	15 minutes	30 minutes
	Tack Free	30 minutes	30 minutes	35 minutes	1 hour
	Dry to handle	3 hours	3 hours	6 hours	8 hours
	Hard Dry	>5 hours	>5 hours	7 hours	9 hours

30°C	Dust dry	7 minutes	7 minutes	13 minutes	20 minutes
	Tack Free	17 minutes	17 minutes	25 minutes	45 minutes
	Dry to handle	2 hours	2 hours	4 hours	6 hours
	Hard Dry	4 hours	4 hours	5 hours	7 hours

60°C	Dust dry	5 minutes	5 minutes	6 minutes	8 minutes
	Tack Free	10 minutes	10 minutes	14 minutes	20 minutes
	Dry to handle	15 minutes	15 minutes	20 minutes	25 minutes
	Hard Dry	20 minutes	20 minutes	25 minutes	30 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.

Autoclear[®] Xpress

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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.

Theoretical coverage

By using the recommended application, the theoretical material usage for one layer is ± 8 m²/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 reducers or solvent borne guncleaners

VOC

The VOC content of this product in ready to use form is 565 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

Address: 3 Changi Business Park Vista, #05-01 Akzo Nobel House, Singapore 486051

Tel: +65 6635 5262

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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

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