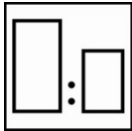


Autoclear[®] 4:1

FOR PROFESSIONAL USE ONLY

Description

Autoclear 4:1 is a fast drying urethane clear which can be used for spot -, panel repair and overall refinishing in combination with Autobase at a temperature range from 25° – 35° C. Autoclear 4:1 is supplied as a set with its own hardener. No extra thinner is needed to get optimum gloss and flow. With care, Autoclear 4:1 can be polished within 3 hours at 30° C.



4 Autoclear 4: 1
1 Autoclear 4: 1 Hardener



Use Sikkens measuring stick
Any applicable measuring stick

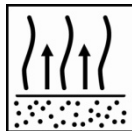


Spray gun set-up:
1.2-1.5 mm

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

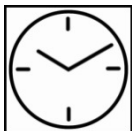


2 x 1 coat



Between coats
5-7 minutes at 20°C
Reducer selection according temperature

Before curing
5-7 minutes at 20°C
Flash-off time depending on oven type



20 hours at 20°C
30 minutes at 60°C



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

Hardener Autoclear 4:1 Hardener

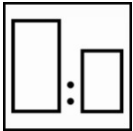
Basic raw materials

Autoclear 4:1 : acrylic resins
Autoclear Hardener 4:1 : polyisocyanate resins

Suitable substrates

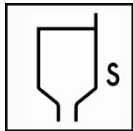
To be applied over Autobase Plus

Mixing



4:1
Autoclear 4:1
Autoclear 4:1 Hardener

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

Application process & blending



Apply 2 single flowing coats, allowing for a flash-off time of 5-7 minutes between coats. The first coat should be applied with sufficient flow, but should not be too heavy. After flash-off time, apply the second coat.

Lettering: Within 24 hours, Autocryl can be applied directly to Autoclear 4:1. After this 24 hour-period, scuffing with Scotch Brite Type S Ultra Fine is required.

Autoclear[®] 4:1

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Pot-life

When mixed, 2 hours at 20°C

Drying times



Autoclear 4:1 Hardener

20°C	Dust dry	30 minutes
	Dry to handle	12 hours
30°C	Dust dry	10 minutes
	Dry to handle	2 hours
60°C	Dust dry	5 minutes
	Dry to handle	20 minutes

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