

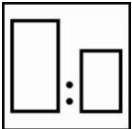
Autosurfacers® WB

FOR PROFESSIONAL USE ONLY

Description

Autosurfacers WB is a water based primer surfacer suitable for all car refinishing systems. This primer surfacer can be used in a sanding or wet-on-wet in combination with all Sikkens topcoat systems with the exception of Autocryl Plus LV.

Sanding application



100 Autosurfacers WB
 10 Activator WB



Use Sikkens measuring stick

14 Blue

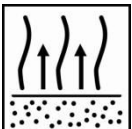


Spray gun set-up:
 1.5-2.0mm

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



3-4 x 1 coat



Between coats:
 10-15 minutes at 25°C
 Allow the surface to flash-off completely matt



2 hours at 25°C
 Relative humidity of 30%
 3½ hours 25°C
 Relative humidity of 75%

30 minutes at 60°C

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Final sanding step: P500
See TDS S8.06.02



Recoatable with all Sikkens topcoats
with the exception of Autocryl Plus LV



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

Read complete TDS for detailed product information

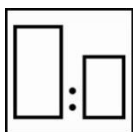
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Wet-on-wet (non sanding) application



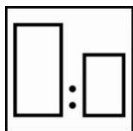
100 Autosurfacers WB
10-20 Autowave MM666



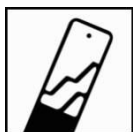
Stir thoroughly

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100 Autosurfacers WB
10-20 Activator WB



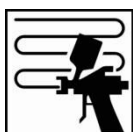
Use Sikkens measuring stick

14 Blue

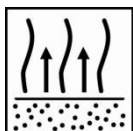


Spray gun set-up:
1.2-1.5mm

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

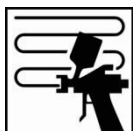


1-2 coats



Between coats:
10-15 minutes at 25°C
Relative humidity of 30%

Before application:
30 minutes at 25°C
Relative humidity of 30%



Recoatable with all Sikkens topcoats
with the exception of Autocryl Plus LV



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Read complete TDS for detailed product information



Autosurfac[®]er WB

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Autosurfacers[®] WB

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Autosurfacers WB is a water based primer surfacer suitable for all car refinishing systems. This primer surfacer can be used in a sanding or wet-on-wet in combination with all Sikkens topcoat systems with the exception of Autocryl Plus LV.

Suitable substrates

Existing finishes	OEM electro coat (sanded)
Steel	Glass Reinforced Polyester laminates (GRP)
Aluminium	Washprimer 1K CF
Galvanized steel	Primer Surfacer EP

Autosurfacers WB will provide adequate adhesion if applied directly to steel.

However, it is advised to use Sikkens Washprimer 1K CF in the following cases:

- a. When the system is required to meet the highest standard
- b. Repairs that requires an extensive metal priming such as complete panel

Allow for a minimum of 15 minutes flash-off time at 20°C after Washprimer application.

Prior to application of the Autosurfacers WB, any polyester bodyfiller or Polysurfacers must be previously being sealed with a suitable primer. Allow for sufficient flash-off time at 20°C after primer application.

Autosurfacers WB can be applied on plastics parts which have been preceded by; 1K All Plastic Primer

Product and additives

Autosurfacers WB

Activator Activator WB

Additives Autowave MM666
Autowave solid MM toners (for tinting purpose) with the exception of MM245

Basic raw materials

Autosurfacers WB: Water soluble acrylic resin

Autosurfacers® WB

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Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using an appropriate surface cleaner.
 Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.



Sanding; final dry sanding steps; P220 - P320
 Rigid OEM electro coated parts; final dry sanding steps; P220 - P320
 Sikkens polyester bodyfillers and Polysurfacers; finished with; P120 - P220
 Featheredge sanding for spot repair, finish outer area with P400
 For detailed surface preparation see TDS S8.06.02



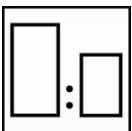
Surface cleaning, remove any surface contamination prior to the application of Autosurfacers WB using appropriate surface cleaner. Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

Stir before use



Autosurfacers WB must be stirred thoroughly before use.

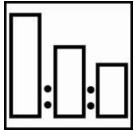
Tinting



If necessary, Autosurfacers WB can be tinted with up to 10 parts by volume with any solid Autowave MM color with the exception of MM245.

For tinting in case of a wet-on-wet (non sanding) application; replace Autowave MM666 by any solid Autowave color.

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Mixing

Sanding:

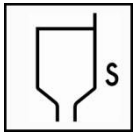
100 Autosurfacers WB
10 Activator WB

Wet-on-wet (non sanding):

100 Autosurfacers WB
10-20 Autowave MM666/ solid MM color
 Stir thoroughly
10-20 Activator WB


Flexible parts

Once elasticized to the required level, Autosurfacers Rapid can be applied on plastic parts. All flexible plastic parts should be pre-coated with a suitable plastic primer (in the case of virgin plastic), or OEM finish.
 See TDS S8.06.03

Viscosity


20-25 seconds DIN cup 4 at 20°C

Spray gun set-up / application pressure

Spray gun	Fluid tip-set-up	Application pressure
 Gravity feed inlet cap	<u>Sanding</u> 1.5-2.0 mm	1.7-2.2 bar at the spray gun air HVLP max 0.6-0.7 bar at the air
	<u>Wet on wet</u> 1.2-1.5 mm	1.7-2.2 bar at the spray gun air HVLP max 0.6-0.7 bar at the air
Gravity feed inlet cap		

For maximum build use widest fluid tip and lower application pressure.

Pot-life

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All Autosurfacers WB mixtures

3 months at 20°C.

Application

*Flush the spray gun thoroughly with Autowave Guncleaner prior to using Autosurfacers WB.

Sanding

Apply one coat over the total sanded area. Next apply the 2nd, 3rd and 4th coat within each preceding coat. Where a full panel application is required apply 3-4 coats over the total panel dependent on the required film build.



Humidity and airflow will influence the Autosurfacers WB Flash-off and drying times. These times can be reduced to a minimum by using air accelerator systems with a minimum distance of 3 feet (1 meter) from the object, thus increasing the airflow over the object. Flash-off until the surface is completely matt, supports to achieve higher film build.

Wet on wet (non sanding/sealer)

Apply 1-2 full wet coats over the total area.

Film thickness

By using the recommended application;

Sanding (4 coats); 60-80 µm

Wet on wet (2 coat); 20-40 µm

Drying times sanding



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2 hours at 25°C 30% RH

3½ hours 25°C 75% RH

30 minutes at 60°C

2 hours at 25°C in case the relative humidity is approximately 30%

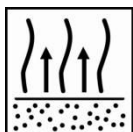
3½ hours 25°C in case the relative humidity is approximately 75%



Air acceleration in combination with temperature increase secures optimum drying. When heat is used for drying, allow object to cool down to application temperature before proceeding with color or clearcoat application. Acceleration by the means of increasing the airflow over the surface with an air accelerator at a minimum distance of 3 feet (1 meter).

I.R. drying is not recommended!

Flash-off time wet-on-wet (non sanding)



Allow for a minimum Flash-off time of 30 minutes at 25°C with an approximate RH of 30% prior to any topcoat application. Apply the topcoat within 24 hours at 25°C with an approximate RH of 30%. Allow for longer Flash-off times in case the RH is higher.

Should this maximum time be exceeded, abrade by P500 dry or P1000 wet sanding paper.

Denibbing wet-on-wet (non sanding)

For minor defects (e.g. dust) Autosurfacers WB can be denibbed with either P500 dry or P1000 wet sanding paper. After a drying time of longer than 24 hours thorough sanding is necessary!

Final sanding



Final sanding step P500

Initial sanding steps may be executed with a coarser sanding grit; P360 - P400

Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.

For detailed surface preparation see TDS S8.06.02



Final sanding step P1000

Initial sanding steps may be executed with a coarser sanding grit P600 - P800

Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.

For detailed surface preparation see TDS S8.06.02



Surface cleaning; remove any surface contamination prior to the application of the topcoat using an appropriate surface cleaner.

Recoat with

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All Sikkens topcoats with the exception of Autocryl Plus LV

Theoretical Coverage

By using the recommended application the theoretical material usage is ± 12 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

Clean and rinse the spray gun thoroughly after use with waterborne Guncleaner. Purge the spray gun with Activator WB prior to Autosurfacers WB use. Do not use any conventional thinner unless removing dried Autowave deposits. Do not soak the spray gun for long periods either with Autowave Guncleaner or Activator WB.

VOC

The VOC content of this product in ready to use form is max. 245 g/liter.

Product storage



Product shelf-life is determined when products are stored unopened at 20°C. Avoid extreme temperature fluctuation. For optimal performance, store opened products at application temperature. Maximum transport and storage temperatures between 2°C-35°C. Frost causes gelling / lumps in Autosurfacers WB after which it no longer can be used. Product shelf life data see TDS S9.01.02

Autosurfacers[®] WB

FOR PROFESSIONAL USE ONLY

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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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