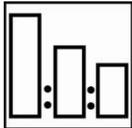


Autoclear® LV Superior

FOR PROFESSIONAL USE ONLY

Description

Two-pack VOC compliant clearcoat concept, consisting of three clearcoats, one dedicated hardener and three reducers, designed for optimum application properties. This concept covers all sizes of repairs at optimum quality levels under all application conditions. The clearcoat technology will ensure a very robust and reliable product performance combined with high gloss level on Autowave.



100 Autoclear LV Superior Clearcoats
60 Autoclear LV Superior Hardener
20 Autoclear LV Superior Reducers



Use Sikkens measuring stick

31 Blue



Spray gun set-up:
1.2-1.4 mm

Application pressure:

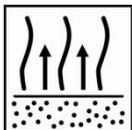
1.7-2.2 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



2 x 1 coat

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



Between coats

3-5 minutes at 20°C

Reducer selection according temperature

Before curing

3-5 minutes at 20°C

Flash-off time depending on oven type



Clearcoat selection

Autoclear LV Superior Fast
Autoclear LV Superior Medium
Autoclear LV Superior Slow

50°C

30 minutes
50 minutes
60 minutes

60°C

15 minutes
25 minutes
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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Product and additives

Autoclear LV Superior Fast: 15 minutes drying time at 60°C
 Autoclear LV Superior Medium: 25 minutes drying time at 60°C
 Autoclear LV Superior Slow: 35 minutes drying time at 60°C

Hardener Autoclear LV Superior Hardener; a general purpose hardener for all repair sizes.

Reducers Autoclear LV Superior Reducer Fast; spot and panel repairs below 20°C
 Autoclear LV Superior Reducer Medium; spot and panel repairs at 20°C-35°C
 Autoclear LV Superior Reducer Slow; larger areas and overall refinishing at 25°C-45°C

Accelerator Autoclear LV Superior Accelerator; for spot and panel repair application at temperatures **below 30°C**.

Additives Autoclear Mat; a matt clearcoat finish to create different clearcoat gloss levels

No plasticiser (Elast-O-Actif) required for application on plastic car parts.

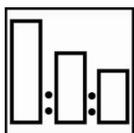
Basic raw materials

Autoclear LV Superior; Polyol resins
 Autoclear LV Superior Hardener; Poly-isocyanate resins

Suitable substrates

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

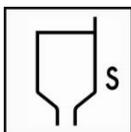
Mixing



100	Autoclear LV Superior(s)	100	Autoclear LV Superior <u>Fast/Medium</u>
60	Autoclear LV Superior Hardener	60	Autoclear LV Superior Hardener
20	Autoclear LV Superior Reducer(s)	20	Autoclear LV Superior Accelerator

Use measuring stick No. 31 Blue.

Viscosity



15-17 seconds – DIN Cup 4 at 20°C.

Spray gun set-up / application pressure



Spray gun
Gravity feed

Fluid tip – set-up
1.2-1.4 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 3-5 minutes flash-off time at 20°C.

Next, apply a full coat, allowing for a 3-5 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.
- 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
- *When sanding and heavy polishing is required, a third coat may be applied after the stated flash-off times at 20°C.*

Pot-life

Autoclear LV Superior Fast	30 minutes	at 20°C
Autoclear LV Superior Fast + Autoclear LV Superior Accelerator	30 minutes	at 20°C
Autoclear LV Superior Medium	1 hour	at 20°C
Autoclear LV Superior Medium + Autoclear LV Superior Accelerator	1 hour	at 20°C
Autoclear LV Superior Slow	1½ hour	at 20°C

Film thickness

By using the recommended application: 45-60 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.

		LV Superior Fast	LV Superior Medium	LV Superior Fast	LV Superior Medium	LV Superior Slow
		LV Superior Accelerator	LV Superior Accelerator			
20°C	Dust dry	50 minutes	50 minutes	1 hour	1 ½ hours	2 ½ hours
	Dry to handle*	3 hours	3 hours	6 hours	7 hours	8 hours
50°C	Dust dry	7 minutes	10 minutes	10 minutes	20 minutes	25 minutes
	Dry to handle*	20 minutes	25 minutes	30 minutes	50 minutes	60 minutes
60°C	Dust dry	4 minutes	6 minutes	7 minutes	10 minutes	20 minutes
	Dry to handle*	12 minutes	15 minutes	15 minutes	25 minutes	35 minutes

*Dry to handle

Following the drying cycle at 60°C object temperature, allow the Autoclear LV Superior to cool down fully to ambient temperature.

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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.
For additional infra red drying information; see TDS S9.01.01

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.

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

The VOC content of this product in ready to use form is max. 419 g/liter.

Product storage

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

Akzo Nobel Car Refinishes Australia Pty Ltd
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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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