
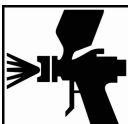

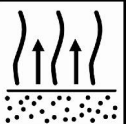




Autoclear Aerodry

FOR PROFESSIONAL USE ONLY

Description					
<p>Two-pack VOC compliant ambient drying clearcoat showing excellent properties like an oven cured clearcoat. Autoclear Aerodry offers optimum application properties and easy blending. Its innovative technology offers multiple drying methods while insuring a constant premium finish. Fast ambient drying at a wide range of temperature or 5min at 60°C, outstanding polishability, Autoclear Aerodry is the perfect partner enabling the bodyshop to lower energy and resource costs per repair by diversifying workflows.</p>					
	100 100	Autoclear Aerodry Autoclear Aerodry Hardener (Fast / Standard)			
	Spray gun set-up: 1.2-1.3 mm		Application pressure: 2.0-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap		
	2 x 1 coat		One visit application ½ + 1 coat First apply a light closed coat. Followed by a full coat without flash off time		
	Between coats 0-3 minutes at 20°C		Before curing 0-3 minutes at 20°C		
	Autoclear Aerodry Autoclear Aerodry Hardener Std		Dust dry Dry to handle	20°C 20-30 min 40-60 min	40°C 15-35 min 30-55 min
	Autoclear Aerodry Autoclear Aerodry Hardener Fast		Dust dry Dry to handle	15-25 min 35-55 min	60°C X 5 min X 5 min
	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

Clearcoat	Autoclear Aerodry
Hardener	Autoclear Aerodry Hardener Fast Autoclear Aerodry Hardener Standard

Basic raw materials

Autoclear Aerodry	Polyaspartic resins
Autoclear Aerodry Hardener (Fast / Standard):	Poly-isocyanate resins

Suitable substrates

-Autowave MM 2.0 + **5% Autowave 2.0 Hardener*** (+5-10% Activator WB**)

* Addition of hardener is mandatory.

(In case of three stage application the advised amount of hardener must be added to each of the coats.)

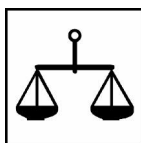
Note: If a pre-coat as described below is applied before applying the Autowave 2.0 basecoat it is **not** mandatory to add the 5% Autowave 2.0 Hardener in the Autowave 2.0 basecoat colour

-**Pre-coat** MM666 / MM600 (60:40) + **5% Autowave 2.0 Hardener **** (+5-10% Activator WB**)

** As with all mixed Autowave MM 2.0 formula's a larger amount of Activator WB can be added for application at higher temperatures and/or at low humidity (please refer to the Autowave TDS S1.09.03)

Restriction: It is not possible to apply Autoclear Aerodry to ready mixed Autowave colors containing 338NA, 338NB, 338ND, 338NS in combination with Additive LP

Mixing



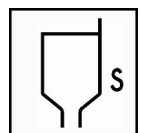
14-20°C

100 parts by weight of Autoclear Aerodry
100 parts by weight of Autoclear Aerodry Hardener Fast

20-30°C

100 parts by weight of Autoclear Aerodry
100 parts by weight of Autoclear Aerodry Hardener Fast / Hardener Standard

Viscosity



12-14 seconds – DIN Cup 4 at 20°C.

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Spray gun set-up / application pressure



Spray gun
Gravity feed

Fluid tip – set-up
1.2-1.3 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



Apply two single coats, allowing for a 0-3 minutes flash-off time at 20°C between coats

Alternatively:

One visit-application: ½ + 1 coat

- First apply a light closed coat.
- Next apply a full coat without flash off time .

Pot-life

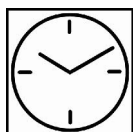
Autoclear Aerodry + Autoclear Aerodry Hardener Fast
Autoclear Aerodry + Autoclear Aerodry Hardener Standard

45 minutes at 20°C
35 minutes at 20°C

Film thickness

By using the recommended application: 45-60 µm.

Drying times



		20°C	40°C	60°C
Autoclear Aerodry	Dust dry	20-30 min	15-35 min	X
Autoclear Aerodry Hardener Std	Dry to handle	40-60 min	30-55 min	5 min
Autoclear Aerodry	Dust dry	15-25 min	X	X
Autoclear Aerodry Hardener Fast	Dry to handle	35-55 min	X	5 min



Allow 5 minutes flash off prior to infra red curing
The panel temperature should not exceed 100°C.

For additional information, see TDS S9.01.01

Note: In combination with temperature, drying speed is dependent on humidity levels. In general drying will be faster the higher the humidity. Increasing temperature/s may lower humidity levels and deter drying speed.

Drying at humidity levels under 30% should be avoided as TDS drying times cannot be guaranteed.

Blending

For blending, see TDS S8.01.01.

Recoatability

Recoatable with itself within 48 hours, after which sanding is mandatory

Polishability



Ready to polish 15 minutes after the indicated drying times

Note: For an optimal result, polish within 3 hours after curing.

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Material usage

Ready for use mixture at 1 μm layer thickness: m^2/liter
 $\pm 494 \text{ m}^2/\text{liter}$

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstance

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

2004/42/IB(d)(420)420

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/l VOC.
The VOC content of this product in ready to use form is max. 420 g/liter.

Product storage

Product shelf-life is currently 1 year when stored unopened at 20°C
After opening the can, product shelflife is limited to 1 month at 20°C
Avoid extreme temperature fluctuation and high humidity levels

- Product shelf life data see TDS S9.01.02

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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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