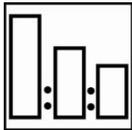


Autoclear® Rapid

FOR PROFESSIONAL USE ONLY

Description

Autoclear Rapid is a quick drying, two pack medium solid clearcoat especially designed for application on Autobase Plus. In addition to standard application inside a spraybooth, this user friendly clearcoat also delivers excellent results in less-than-ideal application conditions like cross flow spraybooths and preparation area. Very quick dust free surface eliminates the need for keeping the vehicle for longer time in the spraybooth which enhances the spraybooth utilization. Autoclear Rapid is polishable in as fast as 1 hour at higher room temperatures even though it might still feel sticky.



100 Autoclear Rapid
50 Autoclear Rapid Hardener/Hardener P25/P35
10-20 Plus Reducers



Use Sikkens measuring stick
No. 3 Black

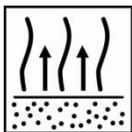


Spray gun set-up:
1.2-1.4 mm

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



Product selection
Autoclear Rapid Hardener
P25 Hardener
P35 Hardener

| | 20°C | 60°C |
|--------------------------|---------|------------|
| Autoclear Rapid Hardener | 3 hours | 9 minutes |
| P25 Hardener | 4 hours | 20 minutes |
| P35 Hardener | 6 hours | 25 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

Autoclear[®] Rapid

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Description

Autoclear Rapid is a quick drying, two pack medium solid clearcoat especially designed for application on Autobase Plus. In addition to standard application inside a spraybooth, this user friendly clearcoat also delivers excellent results in less-than-ideal application conditions like cross flow spraybooths and preparation area.

Very quick dust free surface eliminates the need for keeping the vehicle for longer time in the spraybooth which enhances the spraybooth utilization. Autoclear Rapid is polishable in as fast as 1 hour at higher room temperatures even though it might still feel sticky.

Product and additives

Autoclear Rapid

Hardener Autoclear Rapid Hardener; (over Autobase Plus, (Autowave (urgent spot up to a single panel))

P25 Hardener; spot and panel repairs at 20°C-30°C (over Autobase Plus)

P35 Hardener; larger areas and overall refinishing at 20°C-40°C (over Autobase Plus)

Plus Reducers Plus Reducer Fast; spot and panel repairs, temperature range: 15°C-25°C.
 Plus Reducer Medium; spot and panel repairs and large areas, temperature range: 20°C-30°C.
 Plus Reducer Slow; larger areas and complete paint jobs, temperature range: 25°C-35°C.
 Plus Reducer Extra Slow; to use in extremely hot temperatures, temperature range: above 35°C.

Additives Autoclear Mat; a matt clearcoat finish to create different clearcoat gloss levels (TDS S5.5.1)
 Elast-O-Actif; to elasticize Autoclear Rapid making it suitable for plastic parts. See S8.06.03

Basic raw materials

Autoclear Rapid: Acrylic and polyester resins

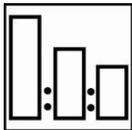
Hardeners: Poly-isocyanate resins

Suitable substrates

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

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

Mixing



Standard System

100 Autoclear Rapid

50 Hardener P25/P35

10-20 Plus Reducers

Use measuring stick No. 3 Black

Accelerated System

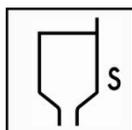
100 Autoclear Rapid

50 Autoclear Rapid Hardener

10-20 Plus Reducer

Use measuring stick No. 3 Black

Viscosity



13-15 seconds – DIN Cup 4 at 20°C.

Autoclear® Rapid

FOR PROFESSIONAL USE ONLY

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

Application process & blending



Apply two single coats, allowing for a 3-5 minutes flash-off time at 20°C between coats.

Allow 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.

Pot-life

All system combinations

> 4 hour

at 20°C

Film thickness

By using the recommended application: 50-60 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.



| | | Rapid Hardener | | P25 Hardener | P35 Hardener |
|------|----------------|-------------------|--|-------------------|-------------------|
| 20°C | Dust dry | 5 minutes | | 15 minutes | 25 minutes |
| | Dry to handle* | 1 hour 15 minutes | | 2 hour 40 minutes | 3 hours |
| | Hard dry | 3 hours | | 4 hours | 6 hours |
| 40°C | Dust dry | 3 minutes | | 10 minutes | 15 minutes |
| | Dry to handle* | 50 minutes | | 1 hour 10 minutes | 1 hour 30 minutes |
| | Hard dry | 1 hour 10 minutes | | 2 hour 20 minutes | 3 hours |
| 60°C | Dust dry | 2 minutes | | 4 minutes | 4-5 minutes |
| | Dry to handle* | 8 minutes | | 15 minutes | 20 minutes |
| | Hard dry | 9 minutes | | 20 minutes | 25 minutes |

Autoclear[®] Rapid

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Drying times (continued)



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 30 minutes after the end of the drying cycle.

Material usage

By using the recommended application, the theoretical material usage is $\pm 7,8$ 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 Solvents or solvent borne guncleaners

VOC

The VOC content of this product in ready to use form is max. 512 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
Address: PO Box 5086 Garden City, VIC, 3207 Australia
Tel: 0396441711

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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