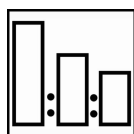


Autoclear® LV

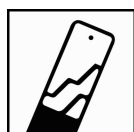
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Description

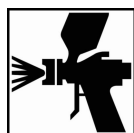
Autoclear LV and Autoclear LV Slow are two-component VOC compliant clearcoats with one dedicated hardener and reducer resulting in a simple mixing ratio. The Autoclear LV Slow is recommended to use from 30°C upwards. The application window of the Autoclear LV and Autoclear LV Slow covers all sizes of repairs in the Car Refinishing and has been designed for application on the Autowave basecoat.



100 Autoclear LV
50 Autoclear LV Hardener
10 Autoclear LV Reducer

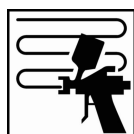


Use Sikkens measuring stick
No. 3 Purple

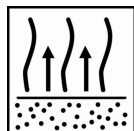


Spray gun set-up:
1.2-1.4 mm

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

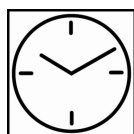


2 x 1 coat
First apply a medium closed coat, next apply a full coat after indicated flash off time



Between coats
5-10 minutes at 20°C

Before curing
5-10 minutes at 20°C
Flash-off time depending on oven type



Drying	20°C	60°C
Autoclear LV	1 ½ hour	20 minutes
Autoclear LV Slow	4 hours	30 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® LV

FOR PROFESSIONAL USE ONLY

Description

Autoclear LV and Autoclear LV Slow are two-component VOC compliant clearcoats with one dedicated hardener and reducer resulting in a simple mixing ratio. The Autoclear LV Slow is recommended to use from 30°C upwards. The application window of the Autoclear LV and Autoclear LV Slow covers all sizes of repairs in the Car Refinishing and has been designed for application on the Autowave basecoat.

Product and additives

- Clearcoat** Autoclear LV; standard clearcoat for all repair sizes, to be used at temperatures up till 30°C. Autoclear LV Slow; clearcoat to be used at higher temperatures and larger object sizes.
- Hardener** Autoclear LV Hardener; a general purpose hardener for all repair sizes.
- Reducer** Autoclear LV Reducer; a general purpose reducer for all repair sizes.
- Additives** Autoclear Mat; a matt clearcoat finish to create different clearcoat gloss levels (TDS 5.1.1)
- No plasticiser (Elast-O-Actif) required for application on plastic car parts.*

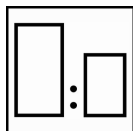
Basic raw materials

Autoclear LV (Slow); Polyol resins
Autoclear LV Hardener; Poly-isocyanate resins

Suitable substrates

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

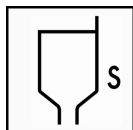
Mixing



100 Autoclear LV (Slow)
50 Autoclear LV Hardener
10 Autoclear LV Reducer

Use measuring stick No. 3 Purple

Viscosity



15-18 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



Autoclear® LV

FOR PROFESSIONAL USE ONLY

Application process & blending



Apply a medium closed coat, allowing for a 5-10 minutes flash-off time at 20°C.

Next, apply a full coat, allowing for a 5-10 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

30 minutes at 20°C

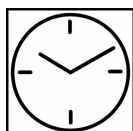
Autoclear LV Slow

45 minutes at 20°C

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 air temperature and object to reach 60°C.



Autoclear LV

Autoclear LV Slow

20°C	Dust dry	45 minutes	60 minutes
	Dry to handle*	1 ½ hour	4 hours
50°C	Dust dry	15 minutes	30 minutes
	Dry to handle*	30 minutes	45 minutes
60°C	Dust dry	10 minutes	20 minutes
	Dry to handle*	20 minutes	30 minutes

*Dry to handle

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



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.

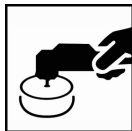
For additional infra red drying information; see TDS S9.01.01



Autoclear® LV

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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.

Film thickness

	µm	
By using the recommended application:	45-60	

Theoretical coverage

Ready for use mixture at 1 µm layer thickness:	522 m²/liter	
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Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

2004/42/IIb(d)(420)420

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

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

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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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