

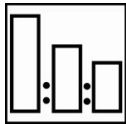
Autoclear Pro Xpress

FOR PROFESSIONAL USE ONLY

Description

Autoclear Pro Xpress is a two component clearcoat system that provides excellent flow, gloss and smooth finish. It is easy to apply and is suitable for all types of repairs, in most application conditions. When mixed with specially-formulated Plus Reducer Xpress Dry, users can achieve a dust free surface in a shorter time span. With the same reducer and the right combination of hardener, the clearcoat can also be polished in as fast as 30 minutes at higher room temperatures.

3:1 mixing ratio



3 Autoclear Pro Xpress
1 Hardener P20 / P25 / P35
10% Plus Reducers



Use Sikkens measuring stick

9 Grey

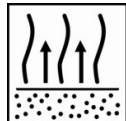


Spray gun set-up:
1.2-1.5mm

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



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



Between coats
5 minutes at 25°C
Reducer selection according temperature

Before curing
10-15 minutes at 25°C
Flash-off time depending on oven type



Product selection
Hardener P20
Hardener P25
Hardener P35

	20°C	60°C
Hardener P20	75 minutes	20 minutes
Hardener P25	80 minutes	25 minutes
Hardener P35	100 minutes	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

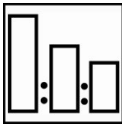
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3:1 mixing ratio with Plus Reducer Xpress Dry



3 Autoclear Pro Xpress
1 Hardener P20 / P25
10% Plus Reducer Xpress Dry



Use Sikkens measuring stick

9 Grey

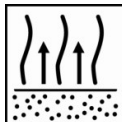


Spray gun set-up:
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Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



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



Between coats
2-5 minutes at 25°C
Reducer selection according temperature

Before curing
5 minutes at 25°C
Flash-off time depending on oven type



Product selection	20°C	30°C	60°C
P20 + Plus Reducer Xpress Dry	40 minutes	30 minutes	15 minutes
P25 + Plus Reducer Xpress Dry	45 minutes	35 minutes	20 minutes

Note: The clearcoat can still be polished at the above-mentioned times even though it might still feel slightly tacky.



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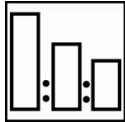
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4:1 mixing ratio



4 Autoclear Pro Xpress
1 Hardener P20 / P25
0.5 Plus Reducers



Use Sikkens measuring stick

34 Orange

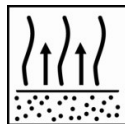


Spray gun set-up:
1.2-1.5mm

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



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



Between coats	Before curing
5 minutes at 25°C	10-15 minutes at 25°C
Reducer selection according temperature	Flash-off time depending on oven type



Product selection	20°C	60°C
Hardener P20	78 minutes	25 minutes
Hardener P25	85 minutes	30 minutes



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Autoclear Pro Xpress

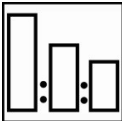
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Description

Autoclear Pro Xpress is a two component clearcoat system that provides excellent flow, gloss and smooth finish. It is easy to apply and is suitable for all types of repairs, in most application conditions. The clearcoat can also be polished in as fast as 30 minutes at higher room temperatures with the right combination of hardener and reducer.

When mixed with specially-formulated Plus Reducer Xpress Dry, users can achieve a dust free surface in a shorter time span.

4:1 mixing ratio with Plus Reducer Xpress Dry



4 Autoclear Pro Xpress
1 Hardener P20 / P25
0.5 Plus Reducer Xpress Dry



Use Sikkens measuring stick

34 Orange

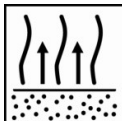


Spray gun set-up:
1.2-1.5mm

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



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



Between coats
2-5 minutes at 25°C
Reducer selection according temperature

Before curing
5 minutes at 25°C
Flash-off time depending on oven type



Product selection
P20 + Plus Reducer Xpress Dry
P25 + Plus Reducer Xpress Dry

	20°C	30°C	60°C
P20 + Plus Reducer Xpress Dry	60 minutes	35 minutes	20 minutes
P25 + Plus Reducer Xpress Dry	65 minutes	40 minutes	25 minutes

Note: The clearcoat can still be polished at the above-mentioned times even though it might still feel slightly tacky.



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When mixed with specially-formulated Plus Reducer Xpress Dry, users can achieve a dust free surface in a shorter time span.

Product and additives

Autoclear Pro Xpress

Hardener P20 Hardener; spot and panel repairs at 15°C-20°C
P25 Hardener; spot and panel repairs at 20°C-30°C
P35 Hardener; panel repairs at 25°C-35°C

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.

Additives Plus Reducer Xpress Dry; spot and panel repairs at 15°C-35°C

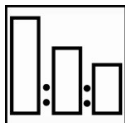
Basic raw materials

Autoclear Pro Xpress: Acrylic and polyester resins
P Hardener: Poly-isocyanate resins
Plus Reducers: A blend of organic solvents
Plus Reducer Xpress Dry: Blend of solvents and additives

Suitable substrates

Autobase Plus; after a minimum flash off time of 15 minutes at 20°C
Autowave 2.0: until completely matt and dry

Mixing



3:1 mixing ratio

3 Autoclear Pro Xpress
1 P Hardeners
10% Plus Reducers or Plus Reducer Xpress Dry

Use measuring stick No. 9 Grey.

Autoclear Pro Xpress

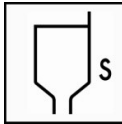
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4:1 mixing ratio

- 4 Autoclear Pro Xpress
- 1 P Hardeners
- 0.5 Plus Reducers or Plus Reducer Xpress Dry

Use measuring stick No. 34 Orange

Viscosity



13-15 seconds – DIN Cup 4 at 25°C.

Spray gun set-up / application pressure



Spray gun
Gravity feed

Fluid tip – set-up
1.2-1.5 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 a medium closed coat, allowing for a 2-5 minutes flash-off time at 25°C.
Next, apply a full coat, allowing for a 10-15 minutes flash-off time at 25°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 25°C.

Pot-life

3:1 mixing ratio

P20 Hardener	1½ hours	at 25°C
P25 Hardener	2½ hours	at 25°C
P35 Hardener	4 hours	at 25°C
P20 Hardener with Plus Reducer Xpress Dry	1 hour	at 25°C
P25 Hardener with Plus Reducer Xpress Dry	1½ hours	at 25°C

Autoclear Pro Xpress

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4:1 mixing ratio

P20 Hardener	3 hours	at 25°C
P25 Hardener	3 hours	at 25°C
P20 Hardener with Plus Reducer Xpress Dry	1½ hours	at 25°C
P25 Hardener with Plus Reducer Xpress Dry	2 hours	at 25°C

Drying times

Allow for a minimum of 5 minutes flash off time at 70°F - 86°F (20°C - 30°C) before moving the car into a pre-heated drying oven (booth) at 140°F (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 140°F (60°C) to the object.

3:1 mixing ratio



	P20 Hardener + Xpress Dry	P25 Hardener + Xpress Dry	P20 Hardener	P25 Hardener	P35 Hardener
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20°C	Dust dry	11 minutes	15 minutes	15 minutes	20 minutes	25 minutes
	Dry to handle*	40 minutes	45 minutes	75 minutes	80 minutes	100 minutes

30°C	Dust dry	9 minutes	12 minutes	11 minutes	18 minutes	23 minutes
	Dry to handle*	30 minutes	35 minutes	40 minutes	50 minutes	60 minutes

60°C	Dust dry	3 minutes	4 minutes	5 minutes	6 minutes	10 minutes
	Dry to handle*	15 minutes	20 minutes	20 minutes	25 minutes	30 minutes

4:1 mixing ratio



	P20 Hardener + Xpress Dry	P25 Hardener + Xpress Dry	P20 Hardener	P25 Hardener
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20°C	Dust dry	12 minutes	15 minutes	16 minutes	23 minutes
	Dry to handle*	60 minutes	65 minutes	78 minutes	85 minutes

Autoclear Pro Xpress

FOR PROFESSIONAL USE ONLY

30°C	Dust dry	10 minutes	11 minutes	13 minutes	20 minutes
	Dry to handle*	35 minutes	40 minutes	50 minutes	60 minutes

60°C	Dust dry	3 minutes	4 minutes	6 minutes	7 minutes
	Dry to handle*	20 minutes	25 minutes	25 minutes	30 minutes

*Dry to handle; Following the drying cycle at 140°F (60°C) object temperature, allow the Autoclear Pro Xpress 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

Polishability



Dust and minor imperfections can be easily removed with polishing after stated air-drying times have been reached. A car that has undergone a full bake at 60°C needs to be cooled down to ambient temperature (20°C-30°C) prior to polishing – cooling time takes approximately 30 minutes.

When polishing at ambient temperature, carefully sand out dust particles and restore the surface according to polishing recommendations. Polishing times may vary slightly depending on body shop conditions

3:1 mixing ratio

	P20 Hardener + Xpress Dry	P25 Hardener + Xpress Dry	P20 Hardener	P25 Hardener
20°C	40 minutes	45 minutes	70 minutes	80 minutes
30°C	30 minutes	35 minutes	40 minutes	50 minutes

4:1 mixing ratio

Autoclear Pro Xpress

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	P20 Hardener + Xpress Dry	P25 Hardener + Xpress Dry	P20 Hardener	P25 Hardener
20°C	55 minutes	65 minutes	80 minutes	85 minutes
30°C	35 minutes	40 minutes	50 minutes	60 minutes

Autoclear Pro Xpress

FOR PROFESSIONAL USE ONLY**Theoretical coverage**

By using the recommended application, the theoretical material usage is ± 7 m²/litre RTS mixture.
The theoretical material usage at 1 μ m dry film thickness is: 300-350 m²/litre.

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 581-592 g/litre RTS mixture.

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

Akzo Nobel Car Refinishes (Singapore) Pte 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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