

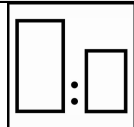
Autosurfacer WB

FOR PROFESSIONAL USE ONLY

Description

Autosurfacer WB is a water based primer surfacer suitable for all car refinishing systems. This primer surfacer can be used in a sanding or wet-on-wet in combination with all Sikkens topcoat systems with the exception of Autocryl Plus LV.

Sanding application



100 Autosurfacer WB
10 Activator WB

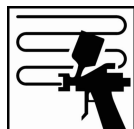


Use Sikkens measuring stick
No. 14 Blue

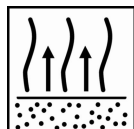


Spray gun set-up:
1.5-1.8 mm

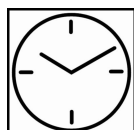
Application pressure:
1.7-2.2 bar at the air inlet.
HVLP max 0.6-0.7 bar at the air cap.



3-4 x 1 coat



Between coats:
10-15 minutes at 25°C
Allow the surface to flash-off completely matt

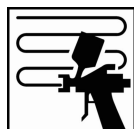


2 hours at 25°C
Relative humidity of 30%
3½ hours 25°C
Relative humidity of 75%

30 minutes at 60°C



Final sanding step: P500
See TDS S8.06.02



Recoatable with all Sikkens topcoats
with the exception of Autocryl Plus LV



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information



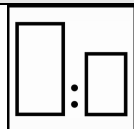
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Wet-on-wet (non sanding)

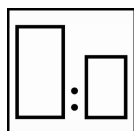


100 Autosurfacer WB

10-20 Autowave MM666

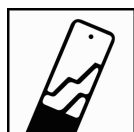


Stir thoroughly



100 Autosurfacer WB

10-20 Activator WB

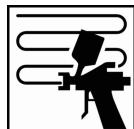


Use Sikkens measuring stick
No. 14 Blue

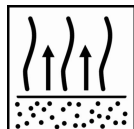


Spray gun set-up:
1.2-1.4 mm

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

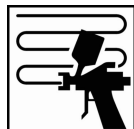


1-2 coats



Between coats:
10-15 minutes at 25°C
Relative humidity of 30%

Before application:
30 minutes at 25°C
Relative humidity of 30%



Recoat with all Sikkens topcoats
with the exception of Autocryl Plus LV.



Use suitable respiratory protection
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Autosurfacer WB is a water based primer surfacer suitable for all car refinishing systems. This primer surfacer can be used in a sanding or wet-on-wet in combination with all Sikkens topcoat systems with the exception of Autocryl Plus LV.

Suitable substrates

Existing finishes	Glass Reinforced Polyester laminates (GRP)
Steel	Washprimer EM CF
Aluminium	Washprimer 1K CF
Galvanized steel	Primer Surfacer EPII
OEM electro coat (sanded)	

Autosurfacer WB will provide adequate adhesion if applied directly to steel, however, we advise for systems which should meet the highest standards to apply Autosurfacer WB over Sikkens Washprimer. Allow for a minimum of 15 minutes flash-off time at 20°C after Washprimer application.

Prior to application of the Autosurfacer WB, any polyester bodyfiller or Polysurfacer must be previously being sealed with a suitable primer. Allow for sufficient flash-off time at 20°C after primer application.

Autosurfacer WB can be applied on plastics parts which have been preceded by, Plastoflex Primer or 2K Plastic Primer.

Product and additives

	Autosurfacer WB
Activator	Activator WB
Additives	Autowave MM666 Autowave solid MM toners (for tinting purpose) with the exception of MM245

Basic raw materials

Autosurfacer WB: Water soluble acrylic resin

Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using an appropriate surface cleaner. *Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.*



Sanding; final dry sanding steps; P180 – P280
Rigid OEM electro coated parts; final dry sanding steps; P180 – P280
Sikkens polyester bodyfillers and Polysurfacer; finished with; P180 - P220
Featheredge sanding for spot repair, finish outer area with P400
For detailed surface preparation see TDS S8.06.02



Surface cleaning, remove any surface contamination prior to the application of Autosurfacer WB using appropriate surface cleaner. *Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*



Autosurfacer WB

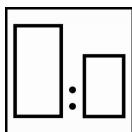
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Stir before use



Autosurfacer WB must be stirred thoroughly before use.

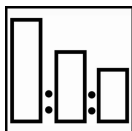
Tinting



If necessary, Autosurfacer WB can be tinted with up to 10 parts by volume with any solid Autowave MM colour with the exception of MM245.

For tinting in case of a wet-on-wet (non sanding) application; replace Autowave MM666 by any solid Autowave colour.

Mixing



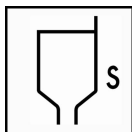
Sanding:

100 Autosurfacer WB
10 Activator WB

Wet-on-wet (non sanding):

100 Autosurfacer WB
10-20 Autowave MM666/ solid MM colour
Stir thoroughly
10-20 Activator WB

Viscosity



20-25 seconds DIN cup 4 at 20°C.

Spray gun set-up / application pressure



Spray gun

Fluid tip- set-up

Application pressure

Gravity feed

Sanding
1.5-1.8 mm

1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

Gravity feed

Wet on wet
1.3-1.4 mm

1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

For maximum build use widest fluid tip and lower application pressure.

Pot-life

All Autosurfacer WB mixtures

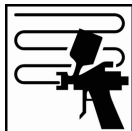
3 months at 20°C.



Autosurfacer WB

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Application



**Flush the spray gun thoroughly with Autowave Guncleaner prior to using Autosurfacer WB.*

Sanding

Apply one coat over the total sanded area. Next apply the 2nd, 3rd and 4th coat within each preceding coat. Where a full panel application is required apply 3-4 coats over the total panel dependent on the required film build.

Humidity and airflow will influence the Autosurfacer WB Flash-off and drying times. These times can be reduced to a minimum by using air accelerator systems with a minimum distance of 1 meter from the object, thus increasing the airflow over the object. Flash-off until the surface is completely matt, supports to achieve higher film build.

Wet on wet (non sanding/sealer)

Apply 1-2 full wet coats over the total area.

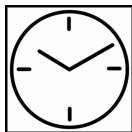
Film thickness

By using the recommended application;

Sanding (4 coats); 60-80 µm

Wet on wet (2 coat); 20-40 µm

Drying times sanding



2 hours at 25°C-30% RH

3½ hours 25°C-75% RH

30 minutes at 60°C

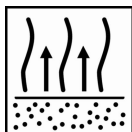
2 hours at 25°C in case the relative humidity is approximately 30%

3½ hours 25°C in case the relative humidity is approximately 75%

Air acceleration in combination with temperature increase secures optimum drying. When heat is used for drying, allow object to cool down to application temperature before proceeding with color or clearcoat application. Acceleration by the means of increasing the airflow over the surface with an air accelerator at a minimum distance of 3 feet (1 meter).

I.R. drying is not recommended!

Flash-off time wet on wet (non sanding)



Allow for a minimum Flash-off time of 30 minutes at 25°C with an approximate RH of 30% prior to any topcoat application. Apply the topcoat within 24 hours at 25°C with an approximate RH of 30%. Allow for longer Flash-off times in case the RH is higher.

Should this maximum time be exceeded, abrade by P500 dry or P1000 wet sanding paper.

Denibbing wet on wet (non sanding)

For minor defects (e.g. dust) Autosurfacer WB can be denibbed with either P500 dry or P1000 wet sanding paper. After a drying time of longer than 24 hours thorough sanding is necessary!

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Final sanding



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Surface cleaning; remove any surface contamination prior to the application of the topcoat using an appropriate surface cleaner.

Recoatable with

All Sikkens topcoats with the exception of Autocryl Plus LV.

Material usage

By using the recommended application the theoretical material usage is $\pm 12 \text{ m}^2/\text{liter}$ 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

Clean and rinse the spray gun thoroughly after use with waterborne Guncleaner.

Purge the spray gun with Activator WB prior to Autosurfacer WB use.

- Do not use any conventional thinner unless removing dried Autowave deposits.
- Do not soak the spray gun for long periods either with Autowave Guncleaner or Activator WB.

VOC

2004/42/IIb(C)(540)245

The EU limit value for this product (product category: IIb. C) in ready to use form is max. 540 g/liter of VOC.
The VOC content of this product in ready to use form is max. 245 g/liter.

Product storage



Product shelf-life is determined when products are stored unopened at 20°C.

Avoid extreme temperature fluctuation.

- For optimal performance, store opened products at application temperature
- Maximum transport and storage temperatures between 2°C-35°C.
- Frost causes gelling / lumps in Autosurfacer WB after which it no longer can be used.
- Product shelf life data see TDS S9.01.02



Autosurfacer WB

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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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