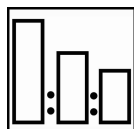


Autoclear Rapid

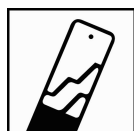
FOR PROFESSIONAL USE ONLY

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 / P Hardeners
10-20 Plus Reducers



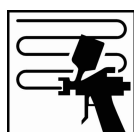
Use Sikkens measuring stick

3 Purple

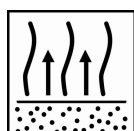


Spray gun set-up:
1.2-1.4 mm

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

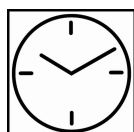


2 x 1 coat



Between coats
3-5 minutes at 20°C

Before curing
3-5 minutes at 20°C



Autoclear Rapid Hardener
P25 Hardener
P35 Hardener

20°C

3 hours
4 hours
6 hours

60°C

9 minutes
20 minutes
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

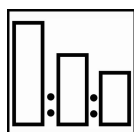
Autoclear Rapid

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
20 Autoclear LV Superior Accelerator



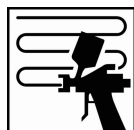
Use Sikkens measuring stick

3 Purple

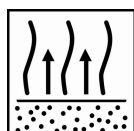


Spray gun set-up:
1.2-1.4 mm

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

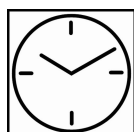


2 x 1 coat



Between coats
3-5 minutes at 20°C

Before curing
3-5 minutes at 20°C



Dry to polish
Autoclear LV Superior Accelerator

20°C
90 minutes

60°C
6 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

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.

Product and additives

Autoclear Rapid

Hardener Autoclear Rapid Hardener

P25 Hardener: spot and panel repairs at 20°C-30°C
P35 Hardener: larger areas and overall refinishing at 20°C-40°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.
Plus Reducer Extra Slow: temperature range: above 35°C.

Additives Autoclear LV Superior Accelerator
Autoclear Mat: See TDS 5.5.1
Elast-O-Actif: See TDS S8.06.03c

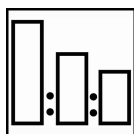
Basic raw materials

Autoclear Rapid: Acrylic and polyester resins
Hardeners: Poly-isocyanate resins

Suitable substrates

Autobase Plus
Autowave
Autowave 2.0

Mixing



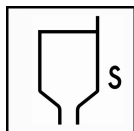
Standard system

100 Autoclear Rapid
50 P Hardeners
10-20 Plus Reducers
Use measuring stick No. 3 Black

Accelerated systems

100 Autoclear Rapid
50 Autoclear Rapid Hardener
10-20 Plus Reducer / LV Superior Accelerator
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

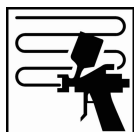


Spray gun
Gravity feed

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, allow for 3-5 minutes flash-off between coats.
Flash off 3-5 minutes before baking.

Recoat with itself within 24 hours
For blending, see TDS S8.01.01.

Pot-life

All combinations without Accelerator
Rapid Hardener + Accelerator

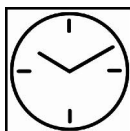
> 4 hours at 20°C
2 hours at 20°C

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 + LV Sup. Accelerator	Rapid Hardener	P25 Hardener	P35 Hardener
---	----------------	--------------	--------------

20°C	Dust dry	5 min	7 min	15 min	25 min
	Dry to handle*	1 hr 30 min	3 hrs	2 hr 45 min	3 hrs
	Hard dry	4 hrs	5 hrs	4 hrs	6 hrs
40°C	Dust dry	3 min	3 min	10 min	15 min
	Dry to handle*	45 min	50 min	1 hr 15 min	1 hr 30 min
	Hard dry	1 hr	1 hr 10 min	2 hr 15 min	3 hrs
60°C	Dust dry	2 min	2 min	4 min	4-5 min
	Dry to handle*	6 min	9 min	15 min	20 min
	Hard dry	7 min	10 min	20 min	25 min

Autoclear Rapid

FOR PROFESSIONAL USE ONLY

Drying times



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

Polishability



Ready to polish after the stated air-dry times or 1 hour after cool down to ambient temperature.

Material usage

By using the recommended application, the theoretical material usage is $\pm 7,8 \text{ m}^2/\text{liter RTS mixture}$.

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

Sikkens Solvent or solvent borne guncleaners

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

AkzoNobel Car Refinish bv.

Address: Rijksstraatweg 31, PO Box 3, 2170 BA Sassenheim

Tel: +31(0)71308-6944

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.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.

Head Office

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com