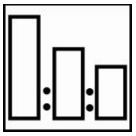
Autoclear® Xcel

FOR PROFESSIONAL USE ONLY

Description

Sikkens Autoclear ® Xcel is a two component clearcoat system which provides excellent flow, gloss and a smooth finish. It is easy to apply and suitable for all types of repairs, in most application conditions.



100 Autoclear ® Xcel
50 P25/P35 Hardeners
10 Plus Reducers

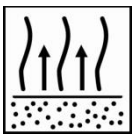
Use Sikkens measuring stick

3 Purple

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
5-10 minutes at 20°C
Reducer selection according temperature

Before curring
10-15 minutes at 20°C
Flash-off time depending on oven type

Product selection	20°C	60°C
P25 Hardener	4.5 hours	30 minutes
P35 Hardener	7 hours	35 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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Product and additives

Clearcoat Autoclear ® Xcel

Hardener P25 Hardener; spot and panel repairs at 20°C-30°C
P35 Hardener; larger areas and overall refinishing at 20°C-40°C

Reducer 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.

Additive Elast-O-Actif; to elasticize Autoclear Xcel making it suitable for plastic parts. See S8.06.03

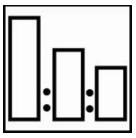
Basic raw materials

Autoclear ® Xcel: Acrylic and polyester resins
P Hardener: Poly-isocyanate resins

Suitable substrates

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

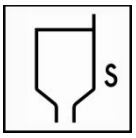
Mixing



100 Autoclear ® Xcel
50 P Hardeners
5-10 Plus Reducers

Use measuring stick No. 3 Purple

Viscosity



16-17 seconds – DIN Cup 4 at 20°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

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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
- When sanding and heavy polishing is required, a third coat may be applied after the stated flash-off times at 20°C.

Pot-life

P25 Hardener	3 hours	at 20°C
P35 Hardener	>3 hours	at 20°C

Film thickness

By using the recommended application: 45-50 µm (2 coats)
Minimum film thickenss for longevity of clearcoat 50 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. Consider the time required for the spraybooth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object.

		P25 Hardener	P35 Hardener
20°C	**Dust dry**	20 minutes	40 minutes
	Dry to handle*	4.5 hours	7 hours
60°C	**Dust dry**	5 minutes	8 minutes
	Dry to handle*	30 minutes	35 minutes

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.

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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.

Theoretical Coverage

By using the recommended application, the theoretical material usage is ± 5.27 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 559 g/liter 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

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