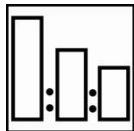


Autocryl® Plus

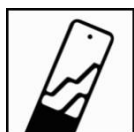
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Description

Two-pack acrylic enamel for passenger cars, commercial vehicles and equipment. For new work and repairs.



100 Autocryl Plus
50 P Hardeners
30 Plus Reducers



Use Sikkens measuring stick

1 Black

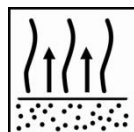


Spray gun set-up:
1.2-1.4 mm

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
3-5 minutes at 20°C
Reducer selection according temperature

Before curing
5-7 minutes at 20°C
Flash-off time depending on oven type



Product selection	20°C	60°C
P15/20 Hardener	4 hours	15 minutes
P25 Hardener/Plus Accelerator 2	1½ hours	10 minutes
P25 Hardener	10 hours	25 minutes
P35 Hardener	11 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

Autocryl® Plus

FOR PROFESSIONAL USE ONLY

Description

Two-pack acrylic enamel for passenger cars, commercial vehicles and equipment. For new work and repairs.

Suitable substrates

Existing finishes
Glass Reinforced Polyester laminates
All Sikkens preparatory products

Product and additives

Autocryl Plus

Hardener P15/20 Hardener; spot and panel repairs at 20°C-25°C
P25 Hardener; spot and panel repairs at 20°C-30°C
P35 Hardener; larger areas and overall refinishing at 20°C-40°C

Plus Plus Reducer Extra Fast; to use in extremely cold temperatures, temperature range: 10°C-15°C.
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; to use in extremely hot temperatures, temperature range: above 35°C.

Accelerator Plus Accelerator; spot and panel repairs, temperature range: 15°C-25°C.

Additives Matting Paste; for creating different gloss levels appearances from high gloss to matt see TDS S1.08.01
Elast-O-Actif; to elasticize Autocryl Plus making it suitable for plastic parts. See S8.06.03

Basic raw materials

Autocryl Plus : Acrylic resins
P Hardener: Poly-isocyanate resins

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Surface preparation



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.



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

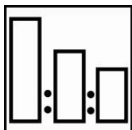


Final sanding step P1000
Initial sanding steps may be executed with a coarser sanding grit P600 - P800
Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
For detailed surface preparation see TDS S8.06.02



Surface cleaning, remove any surface contamination prior to the application of Autocryl Plus using an appropriate surface cleaner.

Mixing



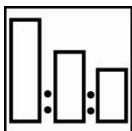
Standard system

100 Autocryl Plus
50 P Hardeners
30 Plus Reducers
Use measuring stick No. 1 Black

Accelerated systems

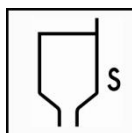
100 Autocryl Plus
50 P25 Hardener
30 Plus Accelerator
Use measuring stick No. 1 Black

Blender mixing



100 Autocryl Plus Blender A065
50 P Hardeners
30 Plus Reducers/Plus Accelerator
Use measuring stick No. 1 Black

Viscosity



15-18 seconds – DIN Cup 4 at 20°C.

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Spray gun set-up / application pressure



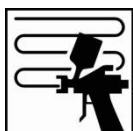
Spray gun
Gravity feed

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 a medium closed coat, allowing for a 3-5 minutes flash-off time at 20°C.
Next, apply a full coat, allowing for a 5-7 minutes flash-off time at 20°C before baking.
In case of application to larger areas a minimal flash-off time between coats is required
Recoatable with itself after full drying cycle, sanding becomes necessary after 24 hours at 20°C.



Panel blending with Autocryl Plus A065.

Apply the color until achieving opacity, extend the 2nd coat slightly beyond the 1st coat covering all sanding scratches. Next apply a thin coat of the A065 Blender RTS mixture over the fade-out area of the previous applied color. This will dissolve the color and create a better transition from the color into the blender.

Allow for a one minute flash-off before applying one full coat of the A065 Blender over the total panel.

Use similar P Hardener/Plus Reducer and Plus Accelerator as in the previous applied color.
For blending (spot repair and panel blends), see TDS S8.01.01

Pot-life

P15/20 Hardener	1 ½ hour	at 20°C
P25 Hardener/Plus Accelerator	1 ½ hour	at 20°C
P25 Hardener	2 hours	at 20°C
P35 Hardener	3 hours	at 20°C

Film thickness

By using the recommended application: 50 µm.

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Drying time sanding

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.



	P15/P20 Hardener	P25 Hardener Plus Accelerator	P25 Hardener	P35 Hardener
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20°C	Dust dry	15 minutes	15 minutes	15 minutes	20 minutes
	Dry to handle*	4 hours	1.5 hours	10 hours	11 hours

60°C	Dust dry	5 minutes	5 minutes	5 minutes	5 minutes
	Dry to handle*	15 minutes	10 minutes	25 minutes	35 minutes

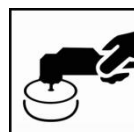
*Dry to handle

Following the drying cycle at 60°C object temperature, allow the Autocryl Plus 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 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 ± 10.5 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

Product storage

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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

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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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