

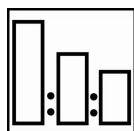
Autoclear® UV

FOR PROFESSIONAL USE ONLY

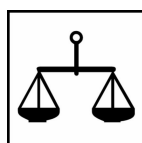
Description

Two-pack VOC compliant UV curable clearcoat system designed for an optimum appearance and with an high gloss level over Autowave. Autoclear UV provides the ultimate in production capability, capitalising on throughput while reducing energy and material usage.

Note: Autoclear UV is only released for use with UV-A (handlamp or UV-LED)



100 grams	Autoclear UV
150 grams	Autoclear UV Hardener
10 grams	Autoclear UV Activator
7 grams	Autoclear UV Reducer

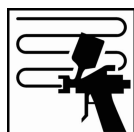


Ratio by weight

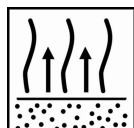


Spray gun set-up:
1.0-1.2 mm

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
Apply two flowing closed coats, respecting the indicated flash off time.



Between coats
2-3 minutes at 20°C

Before curing
2-3 minutes at 20°C



Minimum 6 minutes
After the surface is evenly exposed by one or two passes with a UV lamp
For UV safety and UV equipment handling see TDS S8.01.02



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

Read complete TDS for detailed product information



Autoclear® UV

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Description

Two-pack VOC compliant UV curable clearcoat system designed for an optimum appearance and with an extreme high gloss level over Autowave. Autoclear UV provides the ultimate in production capability, capitalising on throughput while reducing energy and material usage.

Product and additives

Product	Autoclear UV
Hardener	Autoclear UV Hardener
Activator	Autoclear UV Activator
Reducer	Autoclear UV Reducer; for optimum wetting and improved flow characteristics, especially on horizontal surfaces.
<i>No plastiziser (Elast-O-Activ) required</i>	

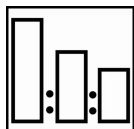
Basic raw materials

Autoclear UV: Thiol functional resins
Autoclear UV Hardener: Poly-isocyanate resins
Autoclear UV Activator: Special additives

Suitable substrates

Autowave; after a minimum flash-off time of 15 minutes at 25°C.

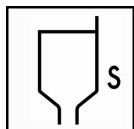
Mixing by weight



Standard system:

100	grams	Autoclear UV
150	grams	Autoclear UV Hardener
10	grams	Autoclear UV Activator
7	grams	Autoclear UV Reducer

Viscosity



15 seconds – DIN Cup 4 at 20°C

Spray gun set-up / application pressure



Spray gun
Gravity

Fluid tip – set-up
1.0-1.2 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



400 Watt handlamp

Apply two flowing closed coats, allowing for a 2-3 minutes flash-off time at 20°C. Next, allow for a 2-3 minutes flash-off time at 20°C before UV light exposure.

UV LED gun

Apply two flowing closed coats, allowing for a 2-3 minutes flash-off time at 20°C, directly followed by UV led exposure (2-3 passes).

- In case of application to larger areas, flash-off between coats is minimal.
- If the spray gun is to be left for a longer period of time, wipe the fluid tip with solvent

For blending (spot repair and panel blends), see TDS S8.01.01a.

Application on OEM clearcoat

Basefix WB with 20% Activator WB can be used as a pre-coat for Autoclear UV. Apply one full flowing closed coat over the entire OEM surface that will ultimately be coated with Autoclear UV. Flash-off and apply the Autowave color coat to the repair area and fade into the dried pre-coat. Ensure flash-off times of subsequent colors coats are observed.

Basefix WB is optimized for application as a pre-coat prior to Autowave application for easier fade-out and colour blending for application with Autoclear UV. Basefix WB also secures an even flow and even curing characteristic with Autoclear UV.

Pot-life

8 hours at 20°C (in a closed container away from direct UV exposure).

Film thickness

By using the recommended application: 50-60 µm

Cure specification



By using a 400 watt UV lamp
Use the UV unit according recommendation

Approximately 6 minutes after UV exposure

Move the 400W UV lamp / UV LED gun (directly after spraying) evenly over the painted area ensuring good overlaps and constant speed at a distance of 10-15 cm. ensuring areas like wheel arches are completely exposed to the light source.

Curing speed is influenced by several factors such as:

- Applied Autowave colour (light reflection)
- Clearcoat layer thickness
- Lamp intensity and UV spectra (400 Watt lamp)
- Bulb life (400 Watt lamp)
- Distance between lamp and the substrate (400 Watt lamp)
- Contamination of the overspray protection foil (UV LED gun)

For UV safety and UV equipment handling see TDS S8.01.02

Ensure all areas coated with Autoclear UV are exposed to the light source, areas not exposed to the UV-light source will not dry within the indicated time.

*Autoclear UV is Recoatable with itself at approximately 1 hour after curing. The surface must be sanded with minimum P1000 - P1200 dry sanding paper (i.e. 3M 260L) prior to clearcoat application.

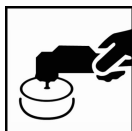
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Personal protection equipment

When curing Autoclear UV, it is necessary to use suitable UV protection equipment which covers all skin areas on hand, arm and face. Wear long sleeves, gloves and cover the face with suitable full face shield.

Polishability



Dust and minor imperfections can be polished out after approximately 30 minutes after curing. Carefully sand out dust particles and restore the surface according polishing recommendations.

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Film thickness by using recommended application

50-60 µm

Theoretical Coverage

Ready for use mixture (standard system) at 1 µm layerthickness:	± 608 m²/liter
Ready for use mixture (10% diluted) at 1 µm layerthickness:	± 581 m²/liter

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

2004/42/IIb(d)(420)350

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/liter VOC. The VOC content of this product in ready to use form is max. 350 g/liter.

Product storage

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

o 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 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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