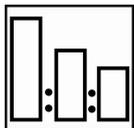


# Autoclear® 2.0

FOR PROFESSIONAL USE ONLY

## Description

Two-pack VOC compliant clearcoat concept, designed for optimum application properties. This concept covers all sizes of repairs at optimum quality levels under all application conditions. The clearcoat technology will ensure a very robust and reliable product performance combined with high gloss level on Autowave 2.0.



3 Autoclear 2.0  
3 Autoclear 2.0 Hardener  
1 Autoclear 2.0 Reducer Fast / Slow



Use Sikkens measuring stick

**21** Pink

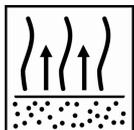


Spray gun set-up:  
1.2-1.3 mm

Application pressure:  
2.0-2.2 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

Before curing  
3-5 minutes at 20°C



Reducer Fast  
Reducer Slow

40°C

30 minutes

45 minutes

60°C

15 minutes

30 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

Autoclear 2.0

**Hardener** Autoclear 2.0 Hardener

**Reducers** Autoclear 2.0 Reducer Fast  
Autoclear 2.0 Reducer Slow

*No plasticiser (Elast-O-Actif) required for application on plastic car parts.*

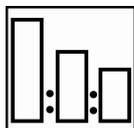
## Basic raw materials

Autoclear 2.0: Polyol resins  
Autoclear 2.0 Hardener; Poly-isocyanate resins

## Suitable substrates

Autowave 2.0: until completely matt and dry

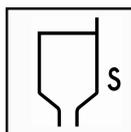
## Mixing



**3** Autoclear 2.0  
**3** Autoclear 2.0 Hardener  
**1** Autoclear 2.0 Reducer Fast / Slow

*Use measuring stick No. 21 Pink*

## Viscosity



15-17 seconds – DIN Cup 4 at 20°C

## Spray gun set-up / application pressure



**Spray gun**  
Gravity feed

**Fluid tip – set-up**  
1.2-1.3 mm

**Application pressure**  
2.0-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

# Autoclear<sup>®</sup> 2.0

FOR PROFESSIONAL USE ONLY

## 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 3-5 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
  - For blending (spot repair and panel blends), see TDS S8.01.01.
  - *When sanding and heavy polishing is required, a third coat may be applied after 5 minutes flash-off at 20°C*

## Pot-life

Autoclear 2.0 (Reducer Fast)	1.5 hours at 20°C
Autoclear 2.0 (Reducer Slow)	2 hours at 20°C

## Drying times



		20°C	40°C	60°C
<b>Reducer Fast</b>	<b>Dust dry</b>	25 minutes	10 minutes	5 minutes
	<b>Dry to polish</b>	16 hours	30 minutes	15 minutes
<b>Reducer Slow</b>	<b>Dust dry</b>	45 minutes	20 minutes	10 minutes
	<b>Dry to polish</b>	16 hours	45 minutes	30 minutes



Dry to handle after approximately 10 minutes.  
Allow 5 minutes flash off prior to infra red curing  
The panel should 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 directly after cool down to ambient temperature.*

## Film thickness

By using the recommended application (2 coats)	45-60 µm
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# Autoclear<sup>®</sup> 2.0

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## Theoretical Coverage

Ready for use mixture at 1 µm layer thickness

522 m<sup>2</sup>/liter

## Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

## VOC

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. 417 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*

### AkzoNobel Coatings LTD

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Long Mile Road, Dublin 12  
**Tel:** 00 353 (0)1450 1344

## FOR PROFESSIONAL USE ONLY

**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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