


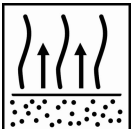




Autoclear® UV

FOR PROFESSIONAL USE ONLY

Description			
Two-pack VOC compliant UV curable clearcoat system designed to enable same day repairs, improving production, energy and material efficiency while delivering a high quality result in combination with Autowave 2.0.			
	100	Autoclear UV	
	100	Autoclear UV Hardener	
	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.		
	Between coats		Before curing
	2-3 minutes at 20°C		2-3 minutes at 20°C
	400 W HID lamp 6 minutes	UV LED 10-12 minutes	Teslacure UV R100 15-20 minutes
	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



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Product and additives

Product Autoclear UV

Hardener Autoclear UV Hardener

No plastiziser (Elast-O-Actif) required

Basic raw materials

Autoclear UV: Thiol functional resins
Autoclear UV Hardener: Poly-isocyanate resins

Suitable substrates

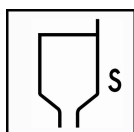
Autowave MM: After a minimum flash-off time of 15 minutes at 25°C
Autowave MM 2.0: Until completely matt and dry

Mixing by weight



100 Autoclear UV
100 Autoclear UV Hardener

Viscosity



15 seconds DIN Cup 4 at 20°C

Spray gun set-up / application pressure



Spray gun

Fluid tip – set-up

Application pressure

Gravity

1.0-1.2 mm

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

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

Pot-life

3-4 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



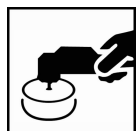
Position the HID lamp or LED approx..40 cm from the surface, ensuring the repair area is covered by the UV foot print.

	Time to full intensity	Exposure time	Drying time
400 W HID lamp	3 minutes	1 - 2 Passes	6 minutes
UV LED	1 minute	10 - 12 minutes	10 - 12 minutes
Teslacure UV R100	-	1 - 2 Passes	15 - 20 minutes

Use the UV unit according recommendation

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

Polishability



Ready to polish after 30 minutes - after curing. (Approximately)

Theoretical Coverage

Ready for use mixture at 1 µm layerthickness: ± 608 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. 400 g/liter.



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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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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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