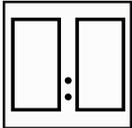


Autoclear Plus HS HSR

FOR PROFESSIONAL USE ONLY

Description

High-build, two-pack clearcoat designed for universal application and optimal appearance in Autowave and Autobase 2-and 3 coat systems. Autoclear Plus HS HSR shows excellent flow, gloss and optimum scratch resistance.



100 Autoclear Plus HS

100 P25/P35 Hardener



Use any Sikkens measuring stick

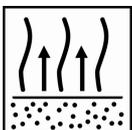


Spray gun set-up:
1.2-1.4 mm

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



Between coats
5-10 minutes at 20°C

Before curing
5-10 minutes at 20°C



P25 Hardener
P35 Hardener

	20°C	60°C
P25 Hardener	3 ½ hours	40 minutes
P35 Hardener	7 hours	45 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

Autoclear Plus HS HSR

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Description

High-build, two-pack clearcoat designed for universal application and optimal appearance in Autowave and Autobase 2-and 3 coat systems. Autoclear Plus HS HSR shows excellent flow, gloss and optimum scratch resistance.

Product and additives

Autoclear Plus HS

Hardener	P25 Hardener:	spot and panel repairs at 20°C-30°C
	P35 Hardener:	larger areas and overall refinishing at 20°C-40°C
Plus 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:	temperature range: above 35°C.
Additives	Autoclear Mat:	See TDS 5.5.1
	Elast-O-Actif:	See TDS S8.06.03c

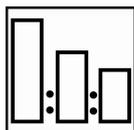
Basic raw materials

Autoclear Plus HS: Acrylic and polyester resins
 P Hardener: Poly-isocyanate resins

Suitable substrates

Autobase Plus
 Autobase Classic
 Autowave
 Autowave 2.0

Mixing

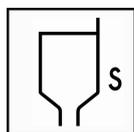


P25 Hardener
100 Autoclear Plus HS
100 P25 Hardener
10% Plus Reducers

P35 Hardener
100 Autoclear Plus HS
100 P35 Hardener
10% Plus Reducer

For optimum sprayability and flow an additional 10% of Plus Reducer can be added.

Viscosity



15-18 seconds – DIN Cup 4 at 20°C.

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

Autoclear Plus HS HSR

FOR PROFESSIONAL USE ONLY

Application process & blending



Apply a medium closed coat, allow for 5-8 minutes flash-off and apply a full coat.
Flash off 5-10 minutes before baking.
Recoat with itself within 24 hours
For blending, see TDS S8.01.01

Pot-life

P25 Hardener	5 hours at 20°C	2 ½ hours at 35°C
P35 Hardener	6 hours at 20°C	4 ½ hours at 35°C

Film thickness

By using the recommended application: 60-80 µm.

Drying times

Allow for a minimum of 10 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
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20°C	Dust dry	1 ¼ hour		2½ hour
	Dry to handle*	3 ½ hours		7 hours

60°C	Dust dry	10 minutes		15 minutes
	Dry to handle*	40 minutes		45 minutes

Complete through hardening of the clearcoat will be realized after approximately 2 weeks at 20°C



Allow 5 minutes flash off prior to infra red curing
The panel temperature should not exceed 100°C.
For additional information, see TDS S9.01.01

Autoclear Plus HS HSR

FOR PROFESSIONAL USE ONLY

Polishability



Ready to polish after the stated air-dry times or 1 hour after cool down to ambient temperature.

Material usage

By using the recommended application, the theoretical material usage is $\pm 4,7$ 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 Solvent or solvent borne guncleaners

VOC

The VOC content of this product in ready to use form is 560 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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Tel: +31(0)71308-6944

FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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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