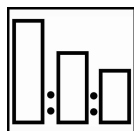


# Autoclear Plus HS

## FOR PROFESSIONAL USE ONLY

### Description

High-build, two-component clearcoat designed for universal application and optimal appearance for both Autowave and Autobase Plus 2-and 3 coat systems which secures excellent flow and gloss.



100 Autoclear Plus HS  
50 P Hardeners  
10 Plus Reducers



Use Sikkens measuring stick

**3** Purple

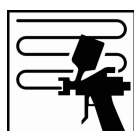


Spray gun set-up:  
1.2-1.4 mm

Application pressure:

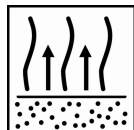
1.7-2.2 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



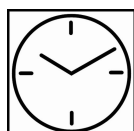
2 x 1 coat

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



P15 Hardener  
P25 Hardener  
P35 Hardener  
P45 Hardener

**20°C**

4 hours

6 hours

10 hours

10 hours

**60°C**

15 minutes

35 minutes

45 minutes

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

**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. Excellent flow and gloss.

## Product and additives

Autoclear Plus HS

|                      |                          |   |
|----------------------|--------------------------|---|
| <b>Hardener</b>      | P15 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                     |
|                      | P45 Hardener:            | larger areas and overall refinishing above 40°C                       |
| <b>Plus Reducers</b> | 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.  |
| <b>Additives</b>     | Autoclear Mat:           | See TDS 5.5.1   |
|                      | Elast-O-Actif:           | See TDS S8.06.03c   |

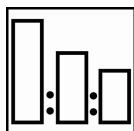
## Basic raw materials

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

## Suitable substrates

Autobase Plus  
Autobase Classic  
Autowave  
Autowave 2.0

## Mixing

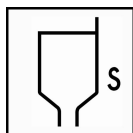


### Standard systems

|            |                   |
|------------|-------------------|
| <b>100</b> | Autoclear Plus HS |
| <b>50</b>  | P Hardeners       |
| <b>10</b>  | Plus Reducers     |

Use measuring stick No. 3 Purple.

## 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  
HVLV max 0.6-0.7 bar at the air cap

# Autoclear Plus HS

FOR PROFESSIONAL USE ONLY

## Application process & blending



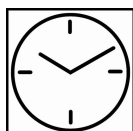
Apply a medium closed coat, allow for 5-10 minutes flash-off and apply a full coat.  
Flash off 5-10 minutes before baking.  
Recoat with itself within 24 hours  
For blending, see TDS S8.01.01.

## Pot-life

|              |         |         |
|--------------|---------|---------|
| P15 Hardener | 3 hours | at 20°C |
| P25 Hardener | 4 hours | at 20°C |
| P35 Hardener | 6 hours | at 20°C |
| P45 Hardener | 7 hours | at 20°C |

## Drying times

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 Hardener | P25 Hardener | P35 Hardener | P45 Hardener |
|--------------|--------------|--------------|--------------|
|--------------|--------------|--------------|--------------|

|      |                |            |            |            |            |
|------|----------------|------------|------------|------------|------------|
| 20°C | Dust dry       | 15 minutes | 45 minutes | 45 minutes | 45 minutes |
|      | Dry to handle* | 4 hours    | 6 hours    | 10 hours   | 10 hours   |

|      |                |            |            |            |            |
|------|----------------|------------|------------|------------|------------|
| 60°C | Dust dry       | 5 minutes  | 5 minutes  | 10 minutes | 10 minutes |
|      | Dry to handle* | 15 minutes | 35 minutes | 45 minutes | 45 minutes |

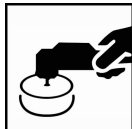


Allow 5 minutes flash off prior to infra red curing  
The panel temperature should not exceed 100°C.  
*For additional information, see TDS S9.01.01*

# Autoclear Plus HS

**FOR PROFESSIONAL USE ONLY**

## Polishability



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

## Film thickness

By using the recommended application (2 coats)

$\mu\text{m}$   
60-80

## Theoretical Coverage

The theoretical material usage at 1  $\mu\text{m}$  dry film thickness is:

377 m<sup>2</sup>/liter

## 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.

## 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*

**Akzo Nobel Car Refinish bv.**

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## 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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