

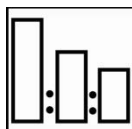
# Autoclear Expert HS

FOR PROFESSIONAL USE ONLY

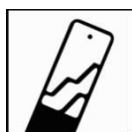
## Description

Sikkens Autoclear Expert HS is two component clearcoat system provides excellent flow, gloss and smooth finish. It is easy to apply and suitable for all types of repairs, in most application conditions.

## P Series Hardeners / Plus Reducers



100 Autoclear Expert HS  
50 P Hardeners - P25 / P35  
10 Plus Reducer (Fast/Medium/Slow/Extra Slow) OR Xpress Dry Reducer



Use Sikkens measuring stick

**3** Purple

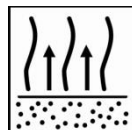


Spray gun set-up:  
1.3-1.4mm

Application pressure:  
1.7-2.0 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap

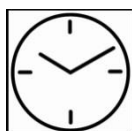


2 x 1 coat  
First apply a medium closed coat, next apply a full coat after indicated flash off time



Between coats  
3-5 minutes at 25°C  
Reducer selection according temperature

Before curing  
10-15 minutes at 25°C  
Flash-off time depending on oven type



Product selection  
P25 / Xpress Dry Reducer  
P35 / Xpress Dry Reducer  
P25 / Plus Reducer Medium  
P35 / Plus Reducer Slow

	25°C	60°C
P25 / Xpress Dry Reducer	70 minutes	15 minutes
P35 / Xpress Dry Reducer	80 minutes	25 minutes
P25 / Plus Reducer Medium	180 minutes	33 minutes
P35 / Plus Reducer Slow	210 minutes	40 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 Expert HS

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## Description

Sikkens Autoclear Expert HS is two component clearcoat system provides excellent flow, gloss and smooth finish. It is easy to apply and suitable for all types of repairs, in most application conditions.

## Product and additives

Autoclear Expert HS

**Hardener** P25 Hardener; spot, panel and large repairs at 20°C-30°C  
P35 Hardener; spot, panel and large repairs at 25°C-40°C

**Plus Reducers** Plus Reducer Fast; spot and panel repairs at 15°C-20°C  
Plus Reducer Medium; spot and panel repairs and large areas at 15°C- 40°C  
Plus Reducer Slow; larger areas and complete paint jobs at 15°C- 40°C  
Plus Reducer Extra Slow; hot temperatures at 25°C - 40°C

**Xpress Dry Reducer** Xpress Dry Reducer; spot and panel repairs at 15°C-25°C.

**Additives** Elast-O-Actif

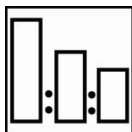
## Basic raw materials

Basic Clear: Acrylic and polyester resins  
P Hardener: Poly-isocyanate resins  
Plus Reducers – A blend of organic solvents  
Xpress Dry Reducer: A blend of organic solvents, additives and catalysts

## Suitable substrates

Autobase Plus; after a minimum flash off time of 15 minutes at 25°C

## Mixing



### Standard systems

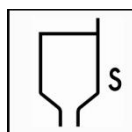
100 Autoclear Expert HS  
50 P Hardeners  
10 Plus Reducers

### Accelerated system

100 Autoclear Expert HS  
50 P Hardeners  
10 Xpress Dry Reducer

Use measuring stick No. 3 – Purple

## Viscosity



14-16 seconds – DIN Cup 4 at 25°C.

# Autoclear Expert HS

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## Spray gun set-up / application pressure

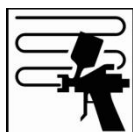


**Spray gun**  
Gravity feed

**Fluid tip – set-up**  
1.3-1.4 mm

**Application pressure**  
1.7-2.0 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

## Application process & blending



Apply a medium closed coat, allowing for a 3-5 minutes flash-off time at 25°C.  
Next, apply a full coat, allowing for a 10-15 minutes flash-off time at 25°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 the stated flash-off times at 25°C.

## Pot-life

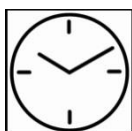
P25 Hardener	2.5 hours	at 25°C
P35 Hardener	>3 hours	at 25°C
P25 Hardener with Xpress Dry Reducer	1.5 hours	at 25°C

# Autoclear Expert HS

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## Drying times

Allow for a minimum of 10 minutes flash off time at 20°C - 30°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 spray booth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object.



P25 Xpress Dry Reducer	P25 / Plus Reducer Med	P25 / Plus Reducer Slow	P35 /Plus Reducer Med	P35 /Plus Reducer Slow
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15°C	Dust dry	18 minutes	40 minutes	45 minutes	47 minutes	50 minutes
	Dry to handle*	95 minutes	360 minutes	380 minutes	400 minutes	420 minutes
25°C	Dust dry	15 minutes	25 minutes	27 minutes	30 minutes	35 minutes
	Dry to handle*	70 minutes	180 minutes	200 minutes	205 minutes	210 minutes
35°C	Dust dry	12 minutes	23 minutes	25 minutes	28 minutes	30 minutes
	Dry to handle*	45 minutes	70 minutes	85 minutes	90 minutes	100 minutes
60°C	Dust dry	5 minutes	15 minutes	20 minutes	22 minutes	25 minutes
	Dry to handle*	15 minutes	33 minutes	35 minutes	38 minutes	40 minutes

\*Dry to handle; Following the drying cycle at 60°C object temperature, allow the Autoclear Expert HS to cool down fully to ambient temperature. Dry to handle after approximately 10 minutes



Allow 5 minutes flash off prior to infra-red curing  
The panel must not reach a temperature above 100°C while curing.  
For additional infra-red drying information; see TDS S9.01.

## 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 approximately 30 minutes after cool down to ambient temperature.

## Theoretical coverage

By using the recommended application, the theoretical material usage is  $\pm 7 \text{ m}^2/\text{liter}$  RTS mixture.  
The theoretical material usage at  $1\mu\text{m}$  dry film thickness is:  $376 - 394 \text{ m}^2/\text{liter}$

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

## Film thickness

By using the recommended application: 50-60 $\mu\text{m}$

# Autoclear Expert HS

**FOR PROFESSIONAL USE ONLY****Cleaning of equipment**

Sikkens Solvents or solvent borne Gun cleaners

**VOC**

The VOC content of this product in ready to use form is 547 - 553 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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**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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