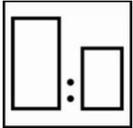


Autobase[®] Plus RM SEC

FOR PROFESSIONAL USE ONLY

Description

Autobase Plus SEC (Special Effect Colors) are specially designed ready mix (RM) colors for the Autobase Plus system.



100 Autobase Plus SEC
50 Plus Reducers



Use Sikkens measuring stick

1 Black

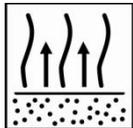


Spray gun set-up:
1.2-1.4 mm

Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



Application Autobase Plus SEC colors:
Full coat – intermediate coat – drop coat



Between coats
3 – 5 minutes at 20°C

Before clearcoat application
15 minutes at 20°C



Clearcoat application
See clearcoat T.D.S



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

Autobase[®] Plus RM SEC

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Description

Autobase Plus SEC (Special Effect Colors) are specially designed ready mix (RM) colors for the Autobase Plus system.

Suitable substrates

Depending on the Autobase Plus SEC color, most will require a specific groundcoat/Colorbuild Plus color, either to achieve the best color match or help promote better coverage.

Many Autobase Plus SEC colors can be applied over existing OEM finishes and all Sikkens preparatory products.

With the exception of thermoplastic acrylic finishes and direct application on acid containing Washprimers

Product and additives

Autobase Plus SEC colors

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; to use in extremely hot temperatures, temperature range: above 35°C.

Additives Blending Agent: Additive specially developed for easier application of spot repairs and fade-outs

Basic raw materials

Autobase Plus SEC Color: Physical drying binders

Surface preparation



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Surface cleaning; remove any surface contamination prior to the application of Autobase Plus SEC using an appropriate surface cleaner.

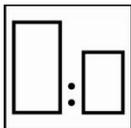
Autobase[®] Plus RM SEC

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Mixing



Stir the Autobase Plus SEC colors thoroughly prior to use.

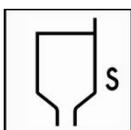


100 Autobase Plus SEC color
50 Plus Reducers

Use measuring stick No. 1 Black

Note: Elast-O-Actif should not be added into the Autobase Plus color.

Viscosity



14–15 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

Pot-life

3 Months when stored in a closed can at 20°C.
 4 hours at 20°C in a closed can when mixed with hardener.
Stir the ready to spray mixture thoroughly before use.

Autobase[®] Plus RM SEC

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Application process

Apply 1 full wet coat allowing for a 3-5 minutes flash-off time at 20°C until the basecoat dries completely to a matt /semi gloss finish.

Next apply an intermediate coat until achieving opacity and allow again a 3-5 minutes flash-off time at 20°C until the basecoat dries completely to a matt /semi gloss finish.

When needed, apply a drop coat (metallic orientation coat) by reducing the pressure to 1-1 ½ bar at the gun inlet and apply the drop coat with full trigger, increase the distance to approximately 30 cm.

**Allow for a minimum of 15 minutes final flash-off time at 20°C before clearcoat application.*

Spot repairs:

When making spot repairs, use lower application pressure and apply thin coats until reaching opacity.

Allow for a 3-5 minutes flash-off time at 20°C between coats. Next, fade out, by extending beyond the edges, using similar application pressure.

In case of metallic colors apply a drop coat (metallic orientation coat) when needed by increasing the spray gun distance.

**Allow for a minimum of 15 minutes final flash-off time at 20°C before clearcoat application.*

Blending Agent:

If required, Autobase Plus Blending Agent can be used ready to spray as a pre-coat (wet-bed) to reduce the halo effect.

Apply 1 full wet coat to the maximum fade-out area and allow for the pre-coat to flash off until fully dried before proceeding with the color application.

Apply the Autobase Plus SEC color within the Blending Agent area.

Film thickness

By using the recommended application;

Autobase Plus SEC Colors 15-30 µm

Masking

Autobase Plus SEC colors can be taped after 20 minutes flash-off at 20°C.

Temperature increase in combination with air movement increase the ability for masking.

Let the object cool down to ambient temperature before masking after which a second color of Autobase Plus can then be applied

Denibbing

Allow Autobase Plus SEC colors to flash off sufficiently, at least 20 minutes at 20°C.

Then lightly sand the damaged area with P500 free-cut dry or P1000 grit wet sanding paper sanding paper.

Thoroughly remove sanding residue before continuing Autobase Plus SEC colors application.

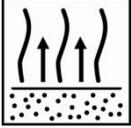
Recoatable with

All current Sikkens clearcoats

With the exception of;

Autoclear LV Superior

Autobase[®] Plus RM SEC

FOR PROFESSIONAL USE ONLY
Recoat time


Autobase Plus SEC colors must be recoated within: 24hrs

Theoretical coverage

 By using the recommended application the theoretical material usage is $\pm 14 \text{ m}^2/\text{l}$ RTS mixture.

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

Cleaning of equipment

Sikkens Solvents or solvent borne Guncleaners

VOC

The VOC content of this product in ready to use form is 800g/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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