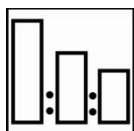


Autocryl® Plus LV

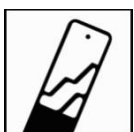
FOR PROFESSIONAL USE ONLY

Description

Two component, high Solid mixing machine based, polyester/acrylic topcoat specifically designed for the refinishing of passenger cars. The system has a VOC content of 420 g/liter and is supported by a full range of ancillary.



100 Autocryl Plus LV
50 Autocryl Plus LV Hardener/HT
10-15 Autocryl Plus LV Thinners/Accelerator



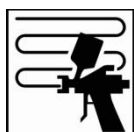
Use Sikkens measuring stick

3 Purple

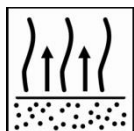


Spray gun set-up:
1.2-1.4 mm

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

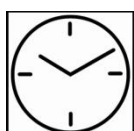


2 x 1 coat



Between coats:
1-3 minutes at 20°C

Before curing:
5-7 minutes at 20°C



Product:
Autocryl Plus LV Accelerator
Autocryl Plus LV Thinners

20°C
3 ½ hour
5 hours

60°C
20 minutes
30 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

Autocryl® Plus LV

FOR PROFESSIONAL USE ONLY

Description

Two component, high Solid mixing machine based, polyester/acrylic topcoat specifically designed for the refinishing of passenger cars. The system has a VOC content of 420 g/liter and is supported by a full range of ancillary.

Suitable substrates

Existing finishes
Polyester laminates
All Sikkens preparatory products with the exception of Autosurfacers WB

Product and additives

Autocryl Plus LV

Hardener Autocryl Plus LV Hardener

Thinners Autocryl Plus LV Thinner / Autocryl Plus LV Thinner HT

Additives Autocryl Plus LV Accelerator; spot and panel repairs at 15°C-25°C.
Autocryl Plus LV Blender R065; for blending purposes.
Autocryl Structure Paste: additive to create different surface textures.
Matting Paste 444: See TDS S1.08.01
No plasticiser (Elast-O-Activ) required.

Basic raw materials

Autocryl Plus LV: polyester and acrylic resin combination
Hardeners: poly isocyanate resins

Surface preparation



Remove any surface contamination prior to sanding using an appropriate surface cleaner.
Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.



Final sanding step P500
Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
Respect a maximum 100 grit sanding step difference or less throughout the sanding steps.
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 grit sanding step difference or less throughout the sanding steps.
For detailed surface preparation see TDS S8.06.02

Autocryl® Plus LV

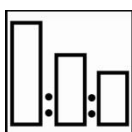
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Surface preparation continued



Remove any surface contamination prior to the application of topcoat using an appropriate surface cleaner.
Where polyester bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

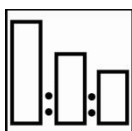
Mixing



Standard system

100 Autocryl Plus LV
50 Autocryl Plus LV Hardener
10-15 Autocryl Plus LV Thinner / Autocryl Plus LV Thinner HT

Stir the mixed MM colors thoroughly before mixing



Accelerated system

100 Autocryl Plus LV
50 Autocryl Plus LV Hardener
10-15 Autocryl Plus LV Accelerator

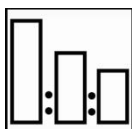
Stir the mixed MM colors thoroughly before mixing



Use Sikkens measuring stick

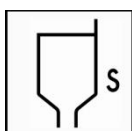
3 Purple

Blender Mixing



100 Autocryl Plus LV Blender R065
50 Autocryl Plus LV Hardener
10-15 Autocryl Plus LV Thinner / Autocryl Plus LV Thinner HT/ Autocryl Plus LV Accelerator

Viscosity



17-21 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

Autocryl® Plus LV

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Application process & blending

Apply a medium closed coat, allowing for a 1-3 minutes flash off time at 20°C.
Next, apply a full coat, allowing for a 5-7 minutes flash-off time at 20°C before baking.

In case of application to larger areas a minimal flash off time between coats is required
Recoat with itself after full drying cycle, sanding becomes necessary after 24 hours at 20°C.



Panel blending with Autocryl LV Plus R065.

Apply the color until achieving opacity, extend the 2nd coat slightly beyond the 1st coat covering all sanding scratches. Next apply a thin coat of the R065 Blender RTS mixture over the fade-out area of the previous applied color. This will dissolve the color and create a better transition from the color into the blender.

Allow for a one minute flash off before applying one full coat of the R065 Blender over the total panel.

- Use similar Hardener / Reducer and Accelerator as in the previous applied color.
- For blending (spot repair and panel blends), see TDS S8.01.01

*Note: The combination of Autocryl Plus LV Thinner HT and SRA agent can result in cratering.
This combination should not be used!*

Pot-life

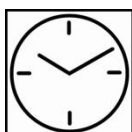
Autocryl Plus LV Hardener -Autocryl Plus LV Thinner	2 hours at 20°C
Autocryl Plus LV Hardener -Autocryl Plus LV Thinner HT	2 hours at 20°C
Autocryl Plus LV Hardener- Autocryl Plus LV Accelerator	1 hour at 20°C

Film thickness

By using the recommended application; 45-65 µm

Drying times

Allow a 5 minute 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 air temperature and object to reach 60°C.



	20°C		60°C	
	Dust dry	Dry to handle	Dust dry	Dry to handle
Plus LV Accelerator	75 minutes	3.5 hours	10 minutes	20 minutes
Plus LV Thinner	1.5 hours	5 hours	15 minutes	30 minutes
Plus LV Thinner HT	6 hours	16 hours	25 minutes	40 minutes



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 S9.01.01

Autocryl® Plus LV

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Polishability



Dust and minor damage 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 1 hour after cool down to ambient temperature.

Theoretical coverage

By using the recommended application the theoretical material usage is $\pm 6 \text{ m}^2/\text{liter}$ 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 Solvents or solvent borne Guncleaners

VOC

2004/42/IIB(d)(420)420

The EU limit value for this product (product category: IIB. d) in ready to use form is max. 420 g/liter of VOC. The VOC content of this product in ready to use form is max. 420 /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

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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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