
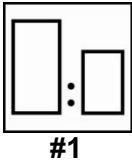


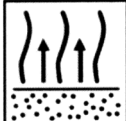


	North America	Technical Data Sheet
	Autoclear EnergySelect LV™	
	Clearcoat 06/01/2016	
FOR PROFESSIONAL USE ONLY		

Description

The Autoclear EnergySelect LV is an acrylic urethane clearcoat for use over Autowave and Autobase Plus and is intended for ambient/forced dry conditions. This clear offers excellent resistance to surface contamination with a **built in flexibility package**, excellent gloss, making it an ideal choice for air dry environments. It also meets the regulatory requirements offered at 250 gm/liter VOC.

	Safety Considerations Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.	
	Mixing 2 1	Autoclear EnergySelect LV Fast or Autoclear EnergySelect LV Slow Autoclear EnergySelect LV Hardener
	HVLP or Compliant Spray-Gun Set-Up: 1.3-1.5 mm	Application Air Pressure: Consult spray gun manufacturers' specifications. HVLP – 10 psi at the air cap maximum.
	Application Apply 2 medium coats of clearcoat.	
	Flash Between Coats at 70°F (21°C) 0-10 minutes	Flash Before Force Drying at 70°F (21°C) 0-10 minutes
	Air Drying at 70°F (21°C) Dry to handle 2 hours	Force Drying at 120°F (49°C) Dry to Handle 30-40 minute

Read complete TDS for detailed product information.

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Suitable Substrates

- Autowave, after flash-off time of 15 - 20 minutes at 70°F(21°C)
- Sikkens Autobase Plus® Solid, Metallic and Pearl Colors: after a flash-off time of 15–20 minutes at 70°F (21°C).
- Existing finishes that have been sanded and degreased. In the case of spot repairs and blending.

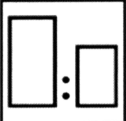
Products and Additives

Product	Autoclear EnergySelect LV Fast	Item #527668
	Autoclear EnergySelect LV Slow	Item #527670
Hardeners	Autoclear EnergySelect LV Hardener	Item #527669
	General purpose hardener for all repair sizes	
Additives	Sikkens LV250 Accelerator	Item #389353
	Autocryl Elast-O-Activ LV-For soft parts only	Item #398218
	Matte Select	Item #500324

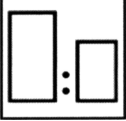
Basic Raw Materials

- Autoclear EnergySelect LV Fast and Slow – Acrylic Polyol
- Autoclear EnergySelect LV Hardener – Polyisocyanate resins
- Additives - Refer to the individual TDS for information

Mixing – General

 #1 Stick	2 1	Parts by volume Autoclear EnergySelect LV Fast or Slow Parts by volume Autoclear EnergySelect LV Hardener
		The Fast and Slow Clearcoat can be mixed to accommodate spraying conditions.

Mixing –Accelerated

 #1 Stick	2 1 0.25-0.50 oz (7-15 mL)	Parts by volume Autoclear EnergySelect LV Fast or Slow Parts by volume Autoclear EnergySelect LV Hardener Parts by volume Sikkens LV250 Accelerator per ready to spray quart



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Mixing – Flexible Parts

Autoclear EnergySelect LV does not require flex additive when being applied over plastic substrates. However, Autocryl Elast-O-Activ LV is required when soft foam parts are being painted.

	<p>100 5-8%</p>	<p>Parts by volume Autoclear EnergySelect LV Fast or Slow Parts by volume Autocryl Elast-O-Activ LV</p>
<p>#1 Stick</p>		

Stir the paint with Elast-O-Activ together THEN –

	<p>2 1</p>	<p>Parts by volume Autoclear EnergySelect LV Fast or Slow with EOA LV Parts by volume Autoclear EnergySelect LV Hardener</p>
<p>#1 Stick</p>		
<p>The Fast and Slow Clearcoat can be mixed to accommodate spraying conditions.</p>		

Viscosity When Mixed

	<p>14-16 seconds</p>	<p>Measured with a DIN #4 viscosity cup at 70°F (21°C).</p>
<p>DIN #4</p>		

Pot-Life When Mixed

Product Mix	70°F (21°C)
Autoclear EnergySelect LV Fast	1 hour
Autoclear EnergySelect LV Slow	2 hours
Autoclear EnergySelect LV Fast Accelerated	45 minutes
Autoclear EnergySelect LV Slow Accelerated	1.5 hours
Autoclear EnergySelect LV Fast/Slow Blended	1.5 hours
Autoclear EnergySelect LV Fast/Slow Blended Accelerated	1 hour

Spray Gun Set-Up

	<p>Consult spray gun manufactures instructions for specific spray gun pressure specifications.</p>		
	Spray Gun	Fluid Tip	Application Pressure
	HVLP Gravity Fed	1.3-1.5 mm	Max 15 psi at air cap
Compliant Gravity Fed	1.3-1.5 mm	Max 10 psi at air cap	



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Application



Apply 2 single flowing coats. If heavy sanding and polishing is required, a third coat may be applied after stated flash off time.

Allow a flash off time between coats of 0-10 minutes. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.

Film Thickness – Using Suitable Application

1 Coat will achieve a thickness of 1.2-1.5 mils (30-37.5 µm).


Drying / Curing Time

Below is a table showing the drying times of Autoclear EnergySelect LV with Autoclear EnergySelect LV Hardener. The air-dry times stated may increase with insufficient airflow.

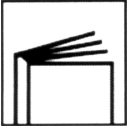
Metal Temp.	Drying	EnergySelect LV (Fast)	EnergySelect LV (Slow)	EnergySelect LV (75% Fast/25%Slow)	EnergySelect LV (50% Fast/50%Slow)	EnergySelect LV (25% Fast/75%Slow)
70°F (21°C)	Dust Free	15 - 20 min.	15 - 20 min.	15 - 20 min.	15 - 20 min.	15 - 20 min.
	Dry	60 – 80 min.	80 – 110 min.	70 – 90 min	75 – 95 min	60 – 90 min
120°F (49°C)	Dust Free	5 - 10 min	5 - 10 min	5 - 10 min	5 - 10 min	5 - 10 min
	Dry	20 - 30 min	30 - 40 min	25 - 35 min	25 - 35 min	30 - 40 min

Below is a table showing the drying times of Autoclear EnergySelect LV with Autoclear EnergySelect LV Hardener (**Accelerated System (Fast/Slow) and Accelerated - Blended System**). The air-dry times stated may increase with insufficient airflow.

Metal Temp.	Drying	EnergySelect LV (Fast) Accelerated	EnergySelect LV (Slow) Accelerated	EnergySelect LV (75% Fast/25%Slow) Accelerated	EnergySelect LV (50% Fast/50%Slow) Accelerated	EnergySelect LV (25% Fast/75%Slow) Accelerated
70°F (21°C)	Dust Free	15 min	15 min	15 min	15 min	15 min
	Dry	40 – 60 min	60 – 80 min	45 – 55 min	45 – 55 min	50 – 60 min
120°F (49°C)	Dust Free	5 min	5 min	5 min	5 min	5 min
	Dry	10 - 15 min	15 - 20 min	10 - 15 min	10 - 15 min	10 - 15 min

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Recoating

	<p>Autoclear EnergySelect LV can be re-coated with itself at any stage. Sanding will become necessary after 24 hours.</p>
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Polishing

	<p>Dust and minor damage can be polished out after 2 – 4 hours at 70°F (21°C). Carefully sand out dust particles with #10 micron (#1500) grit paper wet, and then polish the area manually or mechanically.</p> <p>Note: When heavy color sanding and rubbing are required, it may be necessary to apply one extra coat of Autoclear EnergySelect LV.</p>
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Decals and Lettering

	<p>Decals can be applied after 48 hours at 70°F (21°C)</p> <p>Hand striping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a gray scuffing pad.</p>
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Cleaning of Equipment


	<p>Clean equipment following local and federal regulations. In compliant localities, use Sikkens LV Cleaning Solvent or high quality solvent borne gun cleaner. For national rule regions, use Sikkens Cleaning Solvent or high quality lacquer thinner.</p>
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Theoretical Coverage

	<p>Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others.</p> <ul style="list-style-type: none"> · Approximately 650 - 700 sq. ft./gallon or 16-17 m2/liter of RTS paint at 1 mil with 100% TE.
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VOC / Regulatory Information

	<p>Ready to Spray VOC (2:1)</p> <p>Autoclear EnergySelect LV yields a VOC content of: 2.0 lb/gal 237 g/liter</p> <p>Notice: Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.</p>
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Product Storage

	Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).	
	Autoclear EnergySelect LV Clearcoats	1 year
	Autoclear EnergySelect LV Hardener	6 months

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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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