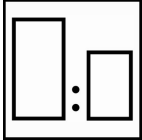


# Autoclear<sup>®</sup> HS+LV 2 Pack

FOR PROFESSIONAL USE ONLY

## Description

A 2 Pack version of Autoclear HS+ LV designed for use over Autowave. Consisting of two clearcoats and one dedicated hardener. Autoclear HS+ LV 2 Pack covers all sizes of repairs, under all application conditions, combined with high gloss level on Autowave.



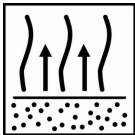
2:1  
Autoclear HS+ LV 2 Pack (Fast/Slow)  
Autoclear HS+ LV Hardener



Use Sikkens Measuring Stick #1



2x1  
HVLP-Siphon 1.8–2.2 mm  
HVLP-Gravity 1.3–1.5 mm  
Max 10 psi (air cap)



6-10 minutes at 70°F (20°C)



Autoclear HS+ LV 2 pack with  
HS+LV 2 Pack Hardener  
10 hours at 70°F (20°C)  
30 minutes at 140°F (60°C)



### Use suitable respiratory protection

Contains acrylic resins and other ingredients. When mixed, also contains isocyanates.

Read complete TDS for detailed product information

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A 2 Pack version of Autoclear HS+ LV designed for use over Autowave. Consisting of two clearcoats and one dedicated hardener. Autoclear HS+ LV 2 Pack covers all sizes of repairs, under all application conditions, combined with high gloss level on Autowave.

## Product and additives

**Product:** Autoclear HS+ LV 2 Pack Fast and Slow  
**Hardener:** Autoclear HS+ LV 2 Pack Hardener

## Basic raw materials

-Autoclear HS+ LV 2 Pack: hydroxyl acrylic resins  
-Autoclear HS+ LV 2 Pack Hardener: polyisocyanate resins

## Suitable surfaces

-Autowave basecoat after a flash-off time of 15–20 minutes at 70°F (20°C).

## Mixing ratios

Mix: 2 parts by volume of Autoclear HS+ LV 2 Pack (Fast or Slow)  
1 part by volume of Autoclear HS+ LV 2 Pack Hardener

**Note:** When mixing Autoclear HS + LV 2 Pack for flexible plastic parts, mix with 10% LV Elast-O-Actif (Mixing Stick #14 Blue). Then mix 2:1 with Autoclear HS+ LV 2 Pack Hardener.

**NOTE:** When using the MPU and LV EOA is needed, post-add 10% LV EOA to the mixed clear and stir thoroughly before applying.

## Spraying viscosity

13-15 seconds. DIN Cup #4, 70°F (20°C)

## Pot life

2 hours at 70°F (20°C)

## Spray gun and pressure

	Fluid Tip	Spraying Pressure	Fluid Pressure
High Transfer Gravity	1.3-1.5 mm	35 psi	
High Transfer Pressure Feed	1.0-1.2 mm	35 psi	10-15 psi
HVLP Pressure Feed	0.8-1.0 mm	max 10 psi (air cap)	10-15 psi
HVLP Siphon	1.8-2.2 mm	max 10 psi (air cap)	
HVLP Gravity	1.3-1.5 mm	max 10 psi (air cap)	

## Application method

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

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## Flash times

6–10 Minutes at 70°F (20°C) with Autoclear HS+ LV 2 Pack Slow  
No flash at 70°F (20°C) with Autoclear HS+ LV 2 Pack Fast

## Drying times

Below is a table showing the drying times of Autoclear HS+ LV. The air-dry times stated may vary with insufficient airflow.

Metal Temp.	Drying	HS+LV 2 Pack Slow	HS+ LV 2 Pack Fast
70°F (20°C)	Dust Free	1 hr	30 min
	Dry	10 hr	7 hr
140°F (60°C)	Dust Free	20 min	7 min
	Dry	30 min	20 min

**Note:** No flash time is required prior to force dry. After the last coat of clear is applied, immediately bake at 140°F (60°C).

## Recoatibility

Autoclear HS+ LV can be re-coated with itself at any stage. Sanding will become necessary after 12 hours.

## Film thickness

Approximately 1.2–1.4 mils per single coat.

## Cover rate

Approximately 110 sq. ft./liter of unmixed paint at a film thickness of 2.5 mils.

## Polishing

Dust and minor damage can be polished out after the "Dry to Polish" times listed previously in this TDS have been reached.

Process: Carefully color sand, removing dust particles with #1500 grit paper wet. Final sand (in a right-angled direction to the #1500 grit) with #2000 grit paper wet. Or finish with the 3 M Trizact P3000 systems. Make sure water is fresh and clean and no contaminants enter during this process, as this will scratch the surface. Clean and dry the surface to be polished.

Suggested compounds: 3M products

Step one: Use Perfect-It 3000 Rubbing Compound, Part No. 06062. Compound should be applied with a white wool pad, Part No. 05711.

Step two: Use Perfect-It 3000 Swirl Mark Remover, Part No. 06064. Use a Perfect-It Foam Polishing Pad, Part No. 05725.

Step three: Apply Perfect-It 3000 Final Glaze, Part No. 06066. With a Perfect-It II Foam Glazing Pad, Part No. 05739.

**Note:** When heavy color sanding and rubbing is required, it may be necessary to apply one extra coat of Autoclear HS+LV 2 Pack clear.

## Decals



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Decals can be applied after 48 hours at 70°F (20°C).

## Lettering

Hand stripping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a grey scuffing pad.

## Cleaning of equipment

Clean equipment with Sikkens Gun Cleaning Solvent LV.

## Stock keeping

**Color:** Clear

**Shelf life:**

-Autoclear HS+LV: 2 Pack	One year if stored unopened at room temperature
-Autoclear HS+LV 2 Pack Hard	-Six months if stored unopened at room temperature

## Safety aspects

### Ready to spray VOC:

(2:1) When mixed ready to spray,

Autoclear HS+ LV 2 Pack yields a VOC content of: 1.84 lb/gal 221 g/liter

**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 protective equipment when mixing and spraying this material. Protect skin with gloves and spray suit, wear safety glasses or goggles when mixing, and wear a full hood fresh air-fed respirator while spraying.

## Akzo Nobel Car Refinishes Inc. North America

**Address:** 5555 Spalding Drive, Norcross. GA 30092 USA

**Tel:** 770-662-8464

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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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### Head Office

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