

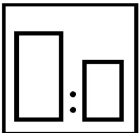
Autobase[®] Plus

Solid, Metallic & Pearl Colors (HP Reducers)

FOR PROFESSIONAL USE ONLY

Description

Autobase Plus basecoat provides excellent coverage, metallic control and sprayability when used to duplicate OEM solid, metallic and pearl color effects. Autobase Plus must be used in conjunction with a Sikkens clearcoat in order to provide protection from the environment. Autobase Plus is the superior choice to achieve optimal color match.



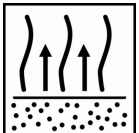
100:50 to 80
–Autobase Plus
–Sikkens High Performance Reducer



Use Sikkens measuring stick #1 (Black)



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



3–5 minutes at 70°F (20°C)



(Autobase Plus Metallic)
1x1
Increase distance and apply a metallic orientation coat if necessary.



15–20 minutes at 70°F (20°C)



Apply Clearcoat



Use suitable respiratory protection
Contains acrylic resins and other ingredients.

Read complete TDS for detailed product information



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Product and additives

Products:	-Autobase Plus Solid -Autobase Plus Metallic and Pearl Colors
Reducers:	-Sikkens High Performance Reducer Fast: for spot and panel repairs. Temperature range: 60°F–75°F (16°C–24°C). -Sikkens High Performance Reducer Medium: for spot and panel repairs and large areas. Temperature range: 70°F–85°F (20°C–30°C). -Sikkens High Performance Reducer Slow: for larger areas and complete paint jobs. Temperature range: 80°F–95°F (27°C–35°C). -Sikkens High Performance Reducer Extra Slow: a specially developed reducer, which can be used in extremely hot temperatures. Temperature range: above 95°F (35°C).
Additives:	-Sikkens Standard Hardener or Sikkens XP Hardener: hardeners that can be used to extend clearcoat time of Autobase Plus solid colors. See further information in this TDS under “Drying Times”. Note: One of these hardeners may also be used under extreme circumstances, while spraying soft “foam” spoilers. Then it is necessary to add 5% of XP Hardener or Sikkens Standard Hardener to Autobase Plus, before continuing to add one of the High Performance Reducers. Note: To meet National Rule VOC levels for three-stage colors. The addition of 10% Sikkens Standard Hardener or Sikkens XP Hardener must be added to the “foundation color.” Note: Autocryl Elast-O-Actif is not needed in Autobase Plus. -Autobase Plus Blending Additive: A purpose made blending additive that may be used while making spot repairs and blending Autobase Plus. Please see TDS on Autobase Plus Blending Additive and TDS on Spot Repairs with Autobase Plus.
Clearcoats:	Clearcoats for application over Autobase Plus are: Autoclear III, Autoclear HS + and Autoclear Vision HS. The selection is based on product performance. Please refer to the clearcoat technical data sheet.

Basic raw materials

Autobase Plus: physically drying binders.
Sikkens High Performance Reducers: special solvent blends.
Hardeners: polyisocyanate resin.

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Suitable surfaces

Autobase Plus can be applied directly over:

- OEM 2-step solid and metallic systems and over existing finishes; degreased and sanded with #P500 to #P600 grit paper dry or #P600 to #P800 grit wet but not over thermoplastic acrylic lacquers. In that case, the entire panel of lacquer must be sealed with a compliant Sikkens undercoat system.
- Any current Sikkens preparatory product that is compliant for local regulations except direct application to Washprimers.

Surface preparation

- All products that are to be sanded: you may have to initial sand, but final sanding with #P500 to #P600 grit paper dry or #P600 to #P800 grit wet is recommended.
- Wet-on-wet products: please follow recommendation for product in use by consulting the relevant Technical Data Sheet.

Material preparation and mixing

Autobase Plus solid, metallic and pearl colors are mixed as follows:

- 100 parts by volume of Autobase Plus color with
- 50 to 80 parts by volume of Sikkens High Performance Reducer

For easy and accurate mixing, use the Sikkens Measuring Stick #1 (Black).

For example: for the 100:50 ratio, pour Autobase Plus to the #1 in the first column, then pour High Performance Reducer to the #1 in the second column.

For the 100:80 ratio, pour Autobase Plus to the #1 in the first column, then pour High Performance Reducer to the #1 in the third column.

Light Autobase colors

Autobase Plus solid white or colors containing 50% or more Autobase Plus Q110 or Q120 white should not be applied directly over Washprimer EM. If this product is necessary for metal treatment, apply only one coat, allow 30 minutes flash and proceed without sanding using either a sanding primer surfacer, or a pigmented wet-on-wet sealer that is compliant for your area.

Spray viscosity

The proper spraying viscosity is achieved by using the recommended mixing ratio.
For the 100:50 ratio; 16–17 sec. For the 100:80 ratio; 13–14 sec. DIN cup #4 at 70°F (20°C).

Pot-life

Autobase Plus solid, metallic and pearl colors: 6 months
Pearl colors (three stage): 24 hours.
When 5 to 10% hardener is added; 4 hours at 70°F (20°C)

Spray gun & pressure

	Fluid Tip	Spraying Pressure
Siphon Feed	(1. 4–1. 7 mm)	40–50 psi
Gravity Feed	(1. 2–1. 4 mm)	40–50 psi
HVLP Siphon	(1. 8–2. 2 mm)	max 10 psi (air cap)
HVLP Gravity	(1. 3–1. 5mm)	max 10 psi (air cap)

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Application of Autobase Plus solid

Spray 2 single coats; allow approximately 3–5 minutes flash-off between each coat. Primed areas and over areas where extra coverage is required, first apply a single thin coat.

Application of Autobase Plus metallic

Spray 2 single coats, at approximately 6 inches from the panel allowing 3–5 minutes flash off between each coat. Even out the metallic pattern with a metallic orientation coat after the second coat has flashed off completely. This is achieved by extending the distance between the gun and panel, and applying a lighter coat. Do not make this coat too wet. With HVLP equipment, it is not necessary to lower the pressure, although this may be done in order to control the color.

Application of Autobase Plus three stage colors

Autobase Plus Solid Foundation Color: Spray 2 single coats, allowing approximately 5-7 minutes flash-off between each coat. Over primed areas and areas where extra coverage is required, apply first a single thin coat. Allow the foundation coat to dry for 15–20 minutes.

Autobase Plus Metallic Foundation Color: Follow the application procedures listed above under "Application of Autobase Plus Metallic".

Autobase Plus Pearl Mid Coat: Spray three to four thin coats, allowing 3–5 minutes flash-off between coats at 70°F (20°C). Do not lower the air pressure for pearl coats.

Autobase Plus Transparent Solid Color Mid Coat: Spray three to four even, wet coats, allowing 5 10 minutes flash-off between coats at 70°F (20°C).

Note: To meet National Rule VOC levels for three-stage colors. The addition of 10% Sikkens Standard Hardener or Sikkens XP Hardener must be added to the "foundation color."

Use the # 14 (Blue) measuring stick for this, stir this mixture and continue to add High Performance Reducer at a ratio of 100:50 or 100:80, as described earlier in this TDS.

Drying time

Allow Autobase Plus to dry for 15 to 20 minutes at 70°F (20°C) before applying the clearcoat. The maximum time Autobase Plus may be left before clear:

–Autobase Plus Metallic Color: 2 days

–Autobase Plus Solid Color: 5 hours

To extend the re-coat time of solid colors to 2 days, mix Autobase Plus as follows: add 5% Sikkens XP Hardener or Sikkens Standard Hardener prior to the addition of Sikkens High Performance Reducer.

Film thickness

Autobase Plus Solid, Metallic and Pearl: 0.3–0.4 mils per single coat.

Cover rate

Approximately 195 sq.ft. /liter of unmixed paint per single coat.

Cleaning of equipment

Clean equipment with Sikkens Cleaning Solvent 790, Sikkens Cleaning Solvent LV or lacquer thinner.



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Two-tone application

Autobase Plus Solid, Metallic and Pearl colors can be taped off with fine line masking tape after 20 minutes flash-off at 70°F (20°C) and a second color of Autobase Plus can then be applied.

Added information

Hand made colors: if it is necessary to make your own color without using a color formula, it is essential that you incorporate the toner Autobase Plus Connector Q 065 into the paint mix. To do this, mix 3 parts Autobase Plus hand made color to 1 part toner Q 065. Use the Sikkens Measuring Stick #9 (Grey). Then stir thoroughly, reduce and apply as normal. Failure to do this will cause poor product performance.

Second repair

If, during the application of Autobase Plus Solid or Metallic color, some damage occurs such as dust impregnation or perspiration spots, allow the Autobase Plus to flash off for 20 minutes at 70°F (20°C). Lightly sand the damaged area with #P600 to #P800 grit paper wet. As there is no clearcoat to protect the base coat at this stage, care must be taken to clean up all sanding residue. Proceed by making a spot repair as described in the TDS, "Spot Repairs with Autobase Plus."

What to do

In the case of lifting; some substrates are not original and are unknown. Then it is reasonable to apply 1-2 coats of a sanding primer surfacer, prior to Autobase Plus, over the whole panel. A pigmented sealer may also be used as a wet-on-wet process. In blending situations, it is necessary to first apply Basefix 790

In the case of fisheyes caused by silicones, spray 2 mist coats over the contaminated area, and then proceed, allowing longer flash off times. If severe, it may be necessary to allow a dry time of 20-30 minutes, sand and continue to spray Autobase Plus. Adding anti-silicone to Autobase Plus is not recommended, as this may lead to a risk of poor adhesion of the clearcoat.

VOC

Availability: Autobase Plus Solid, Metallic and Pearl Colors are available ready-mixed or can be mixed by means of the Sikkens Color Mixing System.

Color range: See the Sikkens Color Listing or the computerized MIXIT System.

Shelf life: Autobase Plus MM Toners: Four years if stored unmixed at room temperature.

Storage

Ready to spray VOC:

Autobase Plus 100:50 with High Performance Reducers: 6.28 lb/gal. 754 g/liter

Autobase Plus 100:80 with High Performance Reducers: 6.44 lb/gal. 773 g/liter

Autobase Plus with 10% hardener, then

100:50 with High Performance Reducers: 5.89 lb/gal. 707 g/liter

100:80 with High Performance Reducers: 6.12 lb/gal. 735 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 an air-supplied respirator when exposed to vapors or spray mist.



North America

Technical Data Sheet 5.2.65

Topcoat
07.01.2010

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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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