

Autobase[®] Plus Special Effect Colors

FOR PROFESSIONAL USE ONLY

Description

Autobase Plus 3 step Special Effect Colors provide unique color and flip/flop effects when viewed from different angles. These colors are not available from the mixing system; therefore there are eight pre-packaged (ready mixed) colors available. Autobase Plus Special Effect Colors are designed for custom finishing and must be used in conjunction with a Sikkens clearcoat in order to provide protection from the environment.



Use suitable respiratory protection

AkzoNobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

Products & additives

Products: Autobase Plus Special Effect Colors

Color Name	Color Direction	Mid Flip Color	Full Flip Color
Red/Gold	Red	Orange	Green
Gold/Silver	Gold	Yellow	Pale Blue
Green/Purple	Teal Green	Maroon	Purple
Cyan/Purple	Blue	Violet	Purple
Blue/Red	Blue	Purple	Orange
Purple/Orange	Blue	Orange	Copper
Magenta/Gold	Purple	Orange	Yellow
Silver/Green	Pale Purple	Green	Blue

Note: The colors have been described under direct sunlight; the observer could notice a change of color under artificial light. Determine the color choice by using the color swatch, "Autobase Plus Special Effect Colors".

First layer: As this is a 3-step system, it is necessary to apply a Black foundation color. Use toner # Q140 for this. Other darker colors can be used to obtain different effects but Black will produce the most vibrant color flip/flop and the best coverage.

Reducers:

- Autobase Plus Reducer Fast: for spot and panel repairs. Temperature range: 60°F–75°F (16°C–24°C).
- Autobase Plus Reducer Medium: for spot and panel repairs and large areas. Temperature range: 70°F–85°F (20°C–30°C).
- Autobase Plus Reducer Slow: for larger areas and complete paint jobs. Temperature range: 80°F–95°F (27°C–35°C).
- Autobase Plus 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, i.e. spraying soft "foam" spoilers. Then it is necessary to add 10% hardener to Autobase Plus, before reducing.



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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 Special Effect Colors.

Basic raw materials

Autobase Plus Special Effect Colors: physically drying binders.

Autobase Plus Reducers: special solvent blends.

Hardeners: polyisocyanate resin.

Suitable surfaces

Autobase Plus 3 Step Special Effect Colors 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 Sikkens preparatory product that is compliant for local regulations.

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.

Mixing of foundation

The first layer in this 3-step system is Q140, black. It is important that Autobase Plus Connector Q065 be added to the color. To do this, mix 3 parts Autobase Plus Q140 to 1 part toner Q065. Use the #9 (Grey) measuring stick. Stir thoroughly.

To comply with National Rule VOC levels

With the above foundation color.

First mix: 100 parts by volume Autobase Plus with 10 parts by volume Sikkens Standard Hardener or Sikkens XP Hardener. For easy and accurate mixing, use the #14 stick (Blue). Stir, and to this, further mixing is necessary as described below.

Mixing ratio

Autobase Plus solid black, Q140 (first layer) and Special Effect Colors are mixed as follows:

100 parts by volume of Autobase Plus color with

50 parts by volume of Autobase Plus Reducer

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

For example: pour Autobase Plus to the #1 in the first column, and then pour Autobase Plus Reducer to the #1 in the second column.



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Application

Autobase Plus Black Foundation Color: Apply 1 to 2 single coats until covered, allowing approximately 3–5 minutes flash-off between each coat. Allow the foundation coat to dry for 15–20 minutes.

Autobase Plus Special Effect Color: Apply 3 to 4 even medium wet coats, allowing approximately 5–7 minutes flash-off between each coat. As there is some transparency with the Special Effect Color it is advised to apply as evenly as possible, trying to avoid overlapping in the same areas.

Spraying viscosity

The proper spraying viscosity is achieved by using the recommended mixing ratio.
Autobase Plus Solid and Special Effect Colors: 16–17 sec. DIN cup #4 at 70°F (20°C).

Pot life

Autobase Plus Solid colors: 6 months
Autobase Plus Special Effect Colors: 24 hours

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
HVLP Gravity	(1.3–1.5 mm)	max 10psi

Drying time

Allow Autobase Plus Special Effect Color 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: 2 days

Film thickness

Autobase Plus Solid and Special Effect Colors: 0.3–0.4 mils per single coat

Cleaning of equipment

Clean equipment with Sikkens Cleaning Solvent 790 or lacquer thinner.

Two-tone application

Autobase Plus Special Effect 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.

Second repair

If, during the application of the Autobase Plus Special Effect Color system, 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 Special Effect Colors."



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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.

Stock keeping

Availability:	Autobase Plus Special Effect Colors are available in 8 ready-mixed colors.
Container size:	1 pint
Color range:	See the Sikkens Color swatch for Autobase Plus Special Effect Colors.
Shelf life:	Autobase Plus Special Effect Colors: Four years if stored unmixed at room temperature.

Safety aspects**Ready to spray VOC:**

-Autobase Plus 100:50 with Autobase Plus Reducers: 6.5 lb/gal. 780 g/liter

-Autobase Plus with 10% hardener,

Then 100:50 with Autobase Plus Reducers: 6.3 – 6.4 lb/gal. 756 – 768 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.

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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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