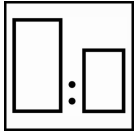


Autoclear Superior 250 2 Pack

FOR PROFESSIONAL USE ONLY

Description

A 2 Pack version of Autoclear Superior 250, designed for use over Autowave. Consisting of two clearcoats and one dedicated hardener. Autoclear Superior 250 2 Pack covers all sizes of repairs, under all application conditions, combined with high gloss level on Autowave.



- 2 Autoclear Superior 250 2PK (Fast or Slow)
- 1 Autoclear Superior 250 2PK Hardener



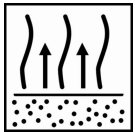
Use Sikkens measuring stick
1



<p>Spray gun set-up: 1.3-1.4 mm HVLP max. 10 psi at air cap</p>	<p>Application pressure: 28-30 psi (spray gun air inlet) o Check gun manufacturer specification</p>
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2 x 1 coat
Apply a medium closed coat, allowing for a 3-5 minutes flash-off time at 70°F (20°C).
Next, apply a full coat, allowing for a 0-5 minutes flash-off time at 70°F (20°C) before baking



<p>Between coats 3-5 minutes at 70°F (20°C)</p>	<p>Before curing 0-5 minutes at 70°F (20°C)</p>
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Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information



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Product and additives

Product	Autoclear Superior 250 2PK. Fast and Slow
Hardener	Autoclear Superior 250 2PK Hardener; a general purpose hardener for all repair sizes.
Additives	- Reducer SRA 4.5; A specialty solvent designed for dissolving the overspray and fade out edge created during spot repair or blending.

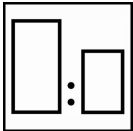
Basic raw materials

Autoclear Superior 250 2PK;	Polyol resins
Autoclear Superior 250 2PK Hardener;	Poly-isocyanate resins

Suitable substrates

- Autowave; after a minimum flash off time of 15 minutes at 77°F (25°C).
- Existing finish that is thoroughly prepared, in the case of spot repairs and blending.

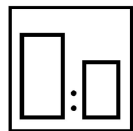
Mixing Ratio



2 parts by volume of Autoclear Superior 250 2PK.
1 parts by volume Autoclear Superior 250 2PK Hardener.

- o For easy and accurate mixing, use the Sikkens measuring stick No. 1

Flexible car parts



To increase flexibility of Autoclear Superior 250 2PK for use on flexible parts.
100 parts by volume Autoclear Superior 250.
10 parts by volume LV Elast-O-Actif

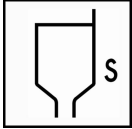
Then mix 2:1 with Autoclear Superior 250 2 Pack Hardener

- o For easy and accurate mixing, use the Sikkens measuring stick No 14 (Blue)

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Viscosity



14-16 seconds – DIN Cup #4 at 70°F (20°C)

Spray gun set-up / application pressure



Spray gun

HVLP gravity
High Transfer gravity
High Transfer Pressure Feed
HVLP Pressure Feed

Fluid tip – set-up

1.3-1.4 mm
1.3-1.4 mm
1.0-1.2 mm
0.8-1.0 mm

Application pressure

HVLP max 10 psi at the air cap
○ Check gun manufacturer specification.

Application process



Apply a medium closed coat, allowing for a 3-5 minutes flash-off time at 70°F (20°C).

Next, apply a full coat, allowing for a 0-5 minutes flash-off time at 70°F (20°C) before baking.

- Flash-off between coats; in case of application to larger areas, flash off between coats is minimal.
- Recoatable with itself after full drying cycle, sanding becomes necessary after 24 hours

When sanding and heavy polishing is required, a third coat may be applied after the stated flash-off times at 70°F (20°C).

Pot-life

(The ready to spray mixture 2:1)

Autoclear Superior 250 2PK Slow:

45 minutes At 70°F (20°C)

Autoclear Superior 250 2PK Fast:

20 minutes At 70°F (20°C)

Film thickness

Per coat: .9 – 1.1 mils. (20-30 μm)


The total dry layer thickness: 1.7-2.2 mils. (45-60 μm)

Autoclear Superior 250 2 Pack

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Drying times

Allow a 5 minute flash-off time before moving the car into a pre-heated drying oven (booth).
All drying times relate to standard application and object temperature.

		Autoclear Superior 250 2PK Fast	Autoclear Superior 250 2PK Slow
70°F (20°C)	Dust dry	1 hour	2 hours
	Dry to handle	4 hours	6 hours
122°F (50°C)	Dust dry	10 minutes	25 minutes
	Dry to handle	30 minutes	60 minutes
140°F (60°C)	Dust dry	10 minutes	15 minutes
	Dry to handle	15 minutes	30 minutes



Allow 5 minutes flash off prior to infra red curing
3 minutes at half power
8 minutes at full power

Distance between short wave IR and object;
20 – 27inch (50 – 70 cm)
The panel must not exceed temperatures above 212°F
(100°C)

Through-hardening:

Following the drying cycle at 140°F (60°C) object temperature, allow the Autoclear Superior 250 2PK to cool fully to ambient temperature to complete the through-hardening process.

Recoatability & blending

- o Recoatable with itself after full drying cycle, sanding becomes necessary if there are defects or after 24 hours
- o For blending (spot repair and panel blends), Please see TDS Spot Repairs with Autowave

Material usage

- With recommended application, the theoretical material usage is ± 66.7 sq.ft./liter (6.2 m²/liter) RTS mixture.
- o The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure, method and application circumstances.

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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 140°F (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 to the polishing recommendations.

- o Ready to polish approximately 1 hour after cool down to ambient temperature.
- o Carefully sand out dust particles with 3M™ #P1500 Trizact™ Clearcoat Sanding Disc (PN02088 or 02069) then continue with #P3000 grit Trizact™ Foam Disc (PN 02085 or 02075).
- o Compound the area mechanically with 3M Perfect-It™ Rubbing Compound (PN 06085) with Perfect-It Wool Compounding Pad (PN 05753). Buffer speed; 1200 to 1800 RPM
- o Polish with 3M Perfect-It Machine Polish (PN 06064) using a 3M Perfect-It Foam Polish Pad (PN 05707) finally applying lighter pressure to achieve the best appearance. Buffer speed; 1200 to 1800 RPM
- o For dark colored vehicles, use 3M Perfect-It Ultrafine Machine Polish (PN 06068) with the Ultrafine Foam Polishing Pad (PN 05708). Buffer speed; 1200 to 1800 RPM. Apply light medium then light pressure and do not buff dry – leave a wet film on the surface that will be removed with a blue 3M Perfect-It detail Cloth (PN06020)

Cleaning of equipment

Clean equipment with Sikkens Gun Cleaning Solvent LV.
or solvent borne gun cleaners

VOC

(2:1 Ready to spray mixture) Autoclear Superior 250 2PK: 2.1 lb/gal 250 g/liter

Product storage

Store products unopened, and used products with closed lids preferably between 50°F-95°F (10°C-35°C)
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

- o Product shelf life data see TDS S9.02.01 1 year

AkzoNobel Car Refinishes Inc. North America

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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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