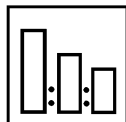


LV650 Clear

FOR PROFESSIONAL USE ONLY

Description

Autocoat[®] BT LV650 Clear is a two component VOC compliant clear coat for original equipment and repairs for commercial vehicles. LV650 Clear provides easy application, excellent flow with superior gloss and durability. The ready to spray VOC is <3.5 lbs/gal when reduced with the LV650 Reducers or <2.1 lbs/gal when reduced with the LV650 Exempt Reducer.



5	LV650 Clear
2	LV650 Hardener
2	LV650 Reducer Medium, Slow, Extra Slow or Exempt

Use Measuring Stick



42

Spray gun setup:

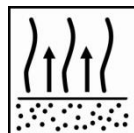
Check gun manufacturer specification



HVLP – Pressure Feed	1.0 – 1.2mm	Max 10psi	10 – 14 oz/min
HVLP – Gravity Feed	1.2 – 1.4mm	Max 10psi	



Apply two (2) single flowing coats. Apply second coat after indicated flash off time



Between coats
5 - 10 min at 70°F (21°C)

Before curing
5 - 10 minutes at 70°F (21°C)



Dry to handle

70°F (21°C)
5 hrs

140°F (60°C)
45 min



Use suitable respiratory protection
Akzo Nobel recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

LV650 Clear

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Description

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Suitable Surfaces

LV650 Basecoat
LV650 Topcoat

Autobase Plus RV – with BT300 Hardener

Existing finishes, degreased and sanded with #P320 to #P400 grit paper dry.
Properly degrease substrate prior to sanding with M600, Ultra Prep surface cleaner or equivalent

Product and Additives

Product LV650 Clear

Hardener LV650 Hardener

Reducers	LV650 Reducer Medium	All applications	70°F-80°F (21°C-27°C)
	LV650 Reducer Slow	All applications	80°F-90°F (27°C-33°C)
	LV650 Reducer Extra Slow	All applications	>90°F (33°C)
	LV650 Reducer Exempt	All applications (2.1 VOC)	
	LV650 Reducer SRA	Spot repair	

Additives LV650 Basecoat Accelerator Air dry

Basic Raw Material

LV650 Clear	Polyol resins
LV650 Hardener	Polyisocyanate resins
LV650 Reducers	Solvents

Product Characteristics

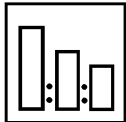
WPG	9.0 +/- 0.2 lbs/gal	Gloss	High
Volume Solids (RTS)	44% +/- 2%	Color	Clear
Theoretical Coverage	705 ft ² /gal @ 1mil – 100% TE	Pot Life (5:2:2)	1.5 hrs @ 70°F (21°C)
		Pot Life (5:2:2+4oz	1 hrs @ 70°F (21°C)
		LV650BC Accelerator)	



LV650 Clear

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Mixing

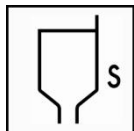


- 5 LV650 Clear
- 2 LV650 Hardener
- 2 LV650 Reducer

For accurate mixing, use measuring stick #42. Mix thoroughly.

Add a maximum of 4oz of LV650 Basecoat Accelerator per mixed RTS gallon for air dry cure LV Elast-O-Actif can be added at 10% (by vol) of the a-component to improve melt-in at high temperatures. LV Elast-O-Actif is not necessary when applying LV650 Clear over flexible parts

Viscosity



LV650 Clear 16 – 20 sec EZ ZAHN #2 at 70°F (21°C)

Viscosity is reported as ready to spray

Spray gun set-up / application pressure



HVLP – Pressure Feed	1.0 – 1.2mm	Max 10psi	10 – 14 oz/min
HVLP – Gravity Feed	1.2 – 1.4mm	Max 10psi	
HVLP – Siphon Feed	1.8 – 2.2mm	Max 10psi	
Pressure Feed	1.0 – 1.2mm	50 – 60psi	12 – 16 oz/min
Siphon Feed	1.6 – 1.8mm	50 – 60psi	
RP Gravity Feed	1.2 – 1.4mm	30 – 35psi	
Electrostatic	1.2 – 1.7mm	35 – 65psi	12 – 14 oz/min

Check gun manufacturer specification

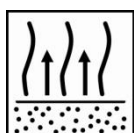
Application



Spray two (2) single flowing coats. After the stated flash-off time, apply the second coat.

Do not use LV650 Clear under 60°F (16°C)

Flash off



5 - 10 minutes at 70°F (21°C) between coats

5 - 10 minutes at 70°F (21°C) final flash before bake

LV650 Clear

FOR PROFESSIONAL USE ONLY

Dry times

Object Temp	Drying	Reducer Medium	Reducer Slow	Reducer Xtr Slow	Reducer Exempt	4oz BC Accel
		70°F (21°C)	Dust Free Dry to handle	85 min 5 hrs	105 min 5 hrs	115 min 5 hrs
100°F (38°C)	Dust Free Dry to handle	55 min 65 min	55 min 65 min	60 min 75 min	50 min 65 min	
140°F (60°C)	Dust Free Dry to handle	25 min 45 min	25 min 45 min	25 min 45 min	25 min 45 min	



Dry Film Thickness

1.8 – 2.2 mils

Recoatability

LV650 Clear is recoatable with itself. Sanding becomes necessary after 24 hours.

Polishability



Dust and minor damage can be polished out after a full bake at 140°F (60°C) object temperature, followed by a cool down of the object to ambient temperature.

- Carefully de-nib out dust particles with #1500 then #2000 grit paper. Clean and dry the surface to be polished
- Mechanically polish area using quality rubbing compounds followed by polishing glaze

Cleaning of equipment

Clean equipment with Sikkens Cleaning Solvent

VOC

LV650 Clear	LV650 Reducer Med, Slow, Xtra Slow	< 3.5 lb/gal	< 420 g/l
LV650 Clear	LV650 Reducer Exempt	< 2.1 lb/gal	< 250 g/l

VOC is ready to spray at a mix ratio of 5:2:2

LV650 Clear

FOR PROFESSIONAL USE ONLY

Product Storage and Shelf Life

Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.

LV650 Clear	2 years
LV650 Hardener	1 year
LV650 Reducer Medium, Slow, Xtr Slow, Exempt	2 years

Available Pack Size and Item Numbers

480989	LV650 Clear	1 GL	509952	LV650 Hardener	1 QT
			397309	LV650 Hardener	1 GL
			391625	LV650 Basecoat Accelerator	1 PT
			398218	LV Elast-O-Actif	1 QT

FOR PROFESSIONAL USE ONLY

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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