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:

<table>
<thead>
<tr>
<th>HVLP – Pressure Feed</th>
<th>1.0 – 1.2mm</th>
<th>Max 10psi</th>
<th>10 – 14 oz/min</th>
</tr>
</thead>
<tbody>
<tr>
<td>HVLP – Gravity Feed</td>
<td>1.2 – 1.4mm</td>
<td>Max 10psi</td>
<td></td>
</tr>
</tbody>
</table>

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
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**Suitable Surfaces**

LV650 Basecoat Autobase Plus RV – with BT300 Hardener
LV650 Topcoat

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**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>WPG</td>
<td>9.0 +/- 0.2 lbs/gal</td>
</tr>
<tr>
<td>Volume Solids (RTS)</td>
<td>44% +/- 2%</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>705 ft²/gal @ 1mil – 100% TE</td>
</tr>
<tr>
<td>Gloss</td>
<td>High</td>
</tr>
<tr>
<td>Color</td>
<td>Clear</td>
</tr>
<tr>
<td>Pot Life (5:2:2)</td>
<td>1.5 hrs @ 70°F (21°C)</td>
</tr>
<tr>
<td>Pot Life (5:2:2:4oz)</td>
<td>1 hrs @ 70°F (21°C)</td>
</tr>
<tr>
<td>LV650BC Accelerator</td>
<td></td>
</tr>
</tbody>
</table>
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

<table>
<thead>
<tr>
<th>Spray Gun Type</th>
<th>Pressure Feed</th>
<th>Siphon Feed</th>
<th>Electrostatic</th>
</tr>
</thead>
<tbody>
<tr>
<td>HVLP – Pressure Feed</td>
<td>1.0 – 1.2mm</td>
<td>Max 10psi</td>
<td>1.2 – 1.7mm</td>
</tr>
<tr>
<td>HVLP – Gravity Feed</td>
<td>1.2 – 1.4mm</td>
<td>Max 10psi</td>
<td>1.2 – 1.7mm</td>
</tr>
<tr>
<td>HVLP – Siphon Feed</td>
<td>1.8 – 2.2mm</td>
<td>Max 10psi</td>
<td>1.2 – 1.7mm</td>
</tr>
<tr>
<td>Pressure Feed</td>
<td>1.0 – 1.2mm</td>
<td>50 – 60psi</td>
<td>1.2 – 1.7mm</td>
</tr>
<tr>
<td>Siphon Feed</td>
<td>1.6 – 1.8mm</td>
<td>50 – 60psi</td>
<td>1.2 – 1.7mm</td>
</tr>
<tr>
<td>RP Gravity Feed</td>
<td>1.2 – 1.4mm</td>
<td>30 – 35psi</td>
<td>1.2 – 1.7mm</td>
</tr>
<tr>
<td>Electrostatic</td>
<td>1.2 – 1.7mm</td>
<td>35 – 65psi</td>
<td>1.2 – 1.7mm</td>
</tr>
</tbody>
</table>

Max 10psi – 10 – 14 oz/min
Max 10psi – 12 – 16 oz/min
Max 10psi – 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

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Dry times

<table>
<thead>
<tr>
<th>Object Temp</th>
<th>Drying</th>
<th>Reducer Medium</th>
<th>Reducer Slow</th>
<th>Reducer Xtr Slow</th>
<th>Reducer Exempt</th>
<th>4oz BC Accel</th>
</tr>
</thead>
<tbody>
<tr>
<td>70°F (21°C)</td>
<td>Dust Free</td>
<td>85 min</td>
<td>105 min</td>
<td>115 min</td>
<td>75 min</td>
<td>30 min</td>
</tr>
<tr>
<td></td>
<td>Dry to handle</td>
<td>5 hrs</td>
<td>5 hrs</td>
<td>5 hrs</td>
<td>4 ½ hrs</td>
<td>1 hr</td>
</tr>
<tr>
<td>100°F (38°C)</td>
<td>Dust Free</td>
<td>55 min</td>
<td>55 min</td>
<td>60 min</td>
<td>50 min</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Dry to handle</td>
<td>65 min</td>
<td>65 min</td>
<td>75 min</td>
<td>65 min</td>
<td></td>
</tr>
<tr>
<td>140°F (60°C)</td>
<td>Dust Free</td>
<td>25 min</td>
<td>25 min</td>
<td>25 min</td>
<td>25 min</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Dry to handle</td>
<td>45 min</td>
<td>45 min</td>
<td>45 min</td>
<td>45 min</td>
<td></td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>LV650 Clear</th>
<th>LV650 Reducer Med, Slow, Xtra Slow</th>
<th>&lt; 3.5 lb/gal</th>
<th>&lt; 420 g/l</th>
</tr>
</thead>
<tbody>
<tr>
<td>LV650 Clear</td>
<td>LV650 Reducer Exempt</td>
<td>&lt; 2.1 lb/gal</td>
<td>&lt; 250 g/l</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>480989</td>
<td>LV650 Clear</td>
<td>1 GL</td>
</tr>
<tr>
<td>509952</td>
<td>LV650 Hardener</td>
<td>1 QT</td>
</tr>
<tr>
<td>397309</td>
<td>LV650 Hardener</td>
<td>1 GL</td>
</tr>
<tr>
<td>391625</td>
<td>LV650 Basecoat Accelerator</td>
<td>1 PT</td>
</tr>
<tr>
<td>398218</td>
<td>LV Elast-O-Actif</td>
<td>1 QT</td>
</tr>
</tbody>
</table>

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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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