



AUTOCLEAR® II LV

DESCRIPTION: Autoclear II LV is a high-solid urethane clearcoat designed for fast dry, high productivity and exceptional gloss, regardless of repair size. For application over all Autobase colors and especially over Autobase Plus solid, metallic and three step pearl colors. With a ready to spray VOC of 1.9 lb/gal, Autoclear II LV enables Sikkens customers to meet the most stringent VOC laws in the Car Refinish Market.


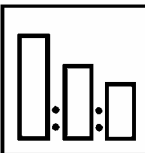


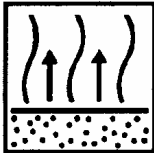
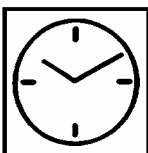
PRODUCT & ADDITIVES:

- PRODUCT:** Autoclear II LV
- HARDENERS:** —Autoclear II LV Hardener; a special hardener made for Autoclear II LV.
—Autoclear II LV Hardener Rapid; a fast curing hardener to speed the curing for medium to small repairs.
- REDUCERS:** —Autoclear II LV Reducer; a special reducer made for Autoclear II LV.
—Autoclear II LV Reducer Rapid; a fast dry reducer used to speed the dry times for spot repairs.
- ADDITIVES:** —Autocoat LV Flex; an additive designed to increase clearcoat flexibility for use on flexible plastic parts.
—Autoclear Mat; a special clearcoat with a matt finish. The gloss level of Autoclear II LV can be reduced with the blending of Autoclear Mat. The main application is on plastic parts. See Technical Data Sheet, "Autoclear Mat". The ratios will remain the same as Autoclear for the desired gloss levels in Autoclear II LV.

BASIC RAW MATERIALS:

Autoclear II LV: polyester resin
Autoclear II LV Hardener: polyisocyanate resins
Autoclear II LV Reducer: special blended chlorinated solvents

APPLICATION:

-  Contains acrylic resin, butyl acetate, methyl amyl ketone and other ingredients. When mixed, Autoclear II LV contains isocyanates. Wear protective clothing and utilize full fresh air fed hood.
-  100:50:30
Autoclear II LV
Autoclear II LV Hardener
Autoclear II LV Reducer
-  Use the Sikkens Measuring Stick #1 (Black).
-  2x1
HVLP Siphon
0.071"–0.087" (1.8–2.2 mm)
HVLP Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (max 0.8 bar)
-  5–10 minutes at 70°F (20°C)
-  Autoclear II LV Hardener
10 hours at 70°F (20°C)
30 minutes at 140°F (60°C)
Autoclear II LV Hardener Rapid
6 hours at 70°F (20°C)
20 minutes at 140°F (60°C)



AUTOCLEAR® II LV

SUITABLE SURFACES:

- Autobase® Solid, Metallic and Pearl Colors: after a flash-off time of 15–20 minutes at 70°F (20°C).
- Autobase® Plus Solid, Metallic and Pearl Colors: after a flash-off time of 15-20 minutes at 70° F (20°C).
- Autocoat LV Solid Colors: after a flash of 15 minutes.
- Existing finish, in the case of spot repairs and blending.

MIXING RATIOS:

- 100 parts by volume of Autoclear II LV
 - 50 parts by volume of Autoclear II LV Hardener
 - 30 parts by volume of any Autoclear II LV Reducer
- For easy and accurate mixing, use the Sikkens Measuring Stick #1 (Black).

NOTE:

When mixing Autoclear II LV for flexible plastic parts, mix Autoclear II LV with 33 parts Autocoat LV Flex (Measuring Stick #4 Green). This mixture must then be further mixed 100:50:30 with the appropriate Autoclear II LV Hardener and Reducer.

SPRAYING VISCOSITY:

13–14 sec. ZAHN cup #2 (12–13 sec. DIN cup #4) at 70°F (20°C).

POT LIFE:

Two hours at 70°F (20°C)

SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure	Fluid Pressure
HVLP Pressure Feed	0.039"–0.047" (1.0–1.2 mm)	max 10 psi (max 0.8 bar)	8–10 psi (0.6–0.8 bar)
HVLP Siphon Feed	0.071"–0.087" (1.8–2.2 mm)	max 10 psi (max 0.8 bar)	
HVLP Gravity Feed	0.051"–0.059" (1.3–1.5 mm)	max 10 psi (max 0.8 bar)	

APPLICATION METHOD:

Apply two single flowing coats. The first coat should be applied with sufficient flow, but should not be applied too heavily. After the stated flash-off time, apply the second coat.

FLASH TIMES:

5–10 minutes at 70°F (20°C). This product does not rely solely on solvent evaporation for its initial drying; therefore, the product will feel wet to the touch after the stated flash time. You may proceed with the application of a second coat without fear of inducing solvent popping.



AUTOCLEAR® II LV

DRYING TIMES: Below is a table showing the drying times of Autoclear II LV.

Metal Temp.	Drying	Autoclear II LV Hardener	Autoclear II LV Hardener Rapid	Hardener Rapid Reducer Rapid
70°F (20°C)	Dust Free	40 min	30 min	25 min
	Dry to Handle	10 hr	6 hr	5 hr
100°F (38°C)	Dust Free	20 min	15 min	15 min
	Dry to Handle	4 hr	3.5 hr	3 hr
140°F (60°C)	Dust Free	5 min	5 min	5 min
	Dry to Handle	30 min	20 min	15 min

NOTE: No flash time is required prior to force dry. After the last coat of clear is applied, immediately bake at 140°F (60°C).

RECOATABILITY: Autoclear II LV can be recoated with itself at any stage. Sanding will become necessary after 12 hours.

FILM THICKNESS: Approximately 1.2–1.4 mils per single coat.

COVER RATE: Approximately 110 sq. ft./liter of unmixed paint at a film thickness of 2.8 mils. It is a requirement that Autoclear II LV be applied at a film thickness of approximately 2.4–2.8 mils. This should be done by applying 2 coats.

POLISHING: Dust and minor surface defects can be polished out after a dry time of 12 hours at 70°F (20°C) or after a 45 minute bake at 140°F (60°C) metal temperature, followed by additional 1-1/2 hour cool down at 70°F (20°C). Carefully sand out dust particles with #10 micron (#P1500) grit paper wet, then polish the area manually or mechanically.

NOTE: When heavy color sanding and rubbing is required, it may be necessary to apply one extra coat of Autoclear II LV.

DECALS: Decals can be applied after 48 hours at 70°F (20°C).

LETTERING: Painted striping or lettering on Autoclear II LV must be applied within 48 hours for good adhesion. After 48 hours, scuff with a grey scuffing pad. Thorough degreasing is recommended prior to any striping or lettering.

CLEANING OF EQUIPMENT: Clean equipment with Sikkens Cleaning Solvent 790.



AUTOCLEAR® II LV

STOCK KEEPING:

COLOR: Clear

**CONTAINER
SIZE:**

Autoclear II LV: 1 gallon (3.785 lt)
Autoclear II LV Hardeners: 1/2 gallon (1.89 lt)
Autoclear II LV Reducers: 1 gallon (3.785 lt)

SHELF LIFE:

Autoclear II LV: Six months if stored unopened at 70°F (20°C).
Autoclear II LV Hardeners: Six months if stored unopened at 70°F (20°C).
Autoclear II LV Reducers: Six months if stored unopened at 70°F (20°C).

SAFETY ASPECTS:

**READY TO
SPRAY VOC:**

(100:50:30)
Autoclear II LV
Autoclear II LV Hardener
Autoclear II LV Reducer: 1.9 lb/gal 230 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 protective equipment when mixing and spraying this material. Protect skin with gloves and spray suit, wear safety glasses or goggles when mixing, and wear a full hood fresh air fed respirator while spraying.