





AUTOCLEAR[®] VISION HS

DESCRIPTION: Autoclear Vision HS is an easy to apply ultra high-solids clearcoat designed for increased bodyshop productivity. When used over Autobase Plus[®], Autoclear Vision HS offers low material usage, an extremely fast curing time and high gloss for baking conditions.



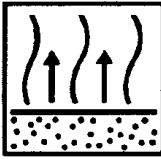
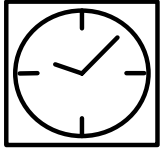
PRODUCT & ADDITIVES:

- PRODUCTS:** Autoclear Vision HS
- HARDENER:** Autoclear Vision HS Hardener
- REDUCERS:** Autoclear Vision HS Activator
- ADDITIVES:** Autocryl Elast-O-Actif: additive to increase flexibility of Autoclear Vision HS for use on flexible parts.
- BASIC RAW MATERIALS:**
- Autoclear Vision HS: ultra high solids resins (patented)
 - Autoclear Vision HS Hardener: polyisocyanate resins
 - Autoclear Vision HS Activator: solvents containing a catalyst

APPLICATION:

-  Contains polyester resins and other ingredients. When mixed, Autoclear Vision HS also contains isocyanates.
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36.7 grams Autoclear Vision HS
114.4 grams Autoclear Vision HS Hardener
1.1 grams Autoclear Vision HS Activator

(See insert for amounts to mix. **Scale mix only**).
-  Stir Thoroughly
-  1x1 (see application method)
Gravity
0.043"-0.051 (1.1-1.3mm)
HVLP Gravity
0.043"-0.051 (1.1-1.3mm)
Max 10 psi (max 0.8 bar)
-  1-2 minutes at 70°F (20°C)
-  8 hours at 70°F (20°C)
(air dry time depends on the temperature and humidity)
5 minutes at 140°F (60°C)
Metal temperature



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SUITABLE SURFACES:

- Sikkens Autobase Plus Solid, Metallic and Pearl Colors: after a flash-off time of 15–20 minutes at 70°F (20°C).
- Existing finishes that have been sanded and degreased. In the case of spot repairs and blending, see TDS “Spot Repairs with Autobase Plus”.

Note:

As Autoclear Vision HS is an extremely fast curing product it is understandable that the paint system, Autobase Plus, and if necessary any Sikkens non-sanding sealer, be applied as thin as possible and flashed thoroughly per TDS. All recommended drying times between products should be strictly adhered to for maximum performance and appearance.

MIXING RATIO:

- 36.7 grams by weight of Autoclear Vision HS
- 114.4 grams by weight of Autoclear Vision HS Hardener
- 1.1 grams by weight of Autoclear Vision HS Activator

Below is a table to help mix the proper amount of material for the job size. These quantities are based on the average mid-sized automobile.

By weight



	Autoclear Vision HS	Autoclear Vision HS Hardener	Autoclear Vision HS Activator	Total
1 panel	36.7 grams	114.4 grams	1.1 grams	152.2 grams
2 panels	73.4 grams	228.8 grams	2.2 grams	304.4 grams
3 panels	110.1 grams	343.2 grams	3.3 grams	456.6 grams
Half a car	183.5 grams	572 grams	5.5 grams	761 grams
Complete	367 grams	1144 grams	11 grams	1522 grams

NOTE: Always zero the scale prior to adding each component.

SPRAYING VISCOSITY:

12-15 seconds. DIN cup #4, 70°F (20°C)

POTLIFE:

In a closed container, 4 hours at 70°F (20°C), 2 hours at 90°F (32°C)

If there is mixed product remaining after use, it may be temporarily stored in a closed container and can be rejuvenated by adding freshly mixed product before the pot life expires. A good balance would be no more than 50% of the original mixed product to which new material is added.

SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
Gravity Feed	0.043”–0.051” (1.1–1.3 mm)	40–50 psi (3–4 bar)
HVLP Gravity	0.043”–0.051” (1.1–1.3 mm)	max. 10 psi (max. 0.8 bar)
High Transfer Gravity	0.047” (1.2mm)	35 psi (2.4 bar)



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APPLICATION METHOD:

Apply one double coat. Applying first a single thin closed coat, followed immediately with a single medium wet coat. A flash off time of up to 5 minutes may be allowed between coats.

NOTE: Due to the immediate application of the second coat do not over apply the first coat.

FLASH TIME:

1-2 minutes with no regard to spray temperature.

NOTE: For larger areas such as a hood. When the first coat is finished, immediately continue with the last coat.

DRYING TIMES:

5 minutes at a metal temperature of 140°F (60°C)

NOTE: Immediately after the last coat of Autoclear Vision HS, it may be baked. In all cases minimize flash off times before bake.

RECOATABILITY:

Autoclear Vision HS can be re-coated with itself at any stage. Sanding will become necessary after the stated dry times, plus 8 hours.

FILM THICKNESS:

1.8–2.2 mils per application

POLISHING:

Dust and minor damage can be polished out after the stated dry time has been reached, or after a full bake at 140°F (60°C) metal temperature followed by a cool down of panel to ambient temperature. Carefully sand out dust particles with #1500 then #2000 grit paper wet or finish with the 3M Trizact P3000 system, and then polish the area manually or mechanically with 3M Perfect-It II Rubbing Compound.

PLASTIC PARTS:

For use over flexible parts the addition of Elast-O-Actif is necessary. The table shows the proper amount and how to mix the materials.

	Autoclear Vision HS	Elast-O-Actif	Autoclear Vision HS Hardener	Autoclear Vision HS Activator	Total
1 panel	36.7 grams	5.5 grams	131.7 grams	1.2 gram	175.1 grams
2 panels	73.4 grams	11 grams	263.4 grams	2.4 grams	350.2 grams

NOTE: Always zero the scale prior to adding each component.

DECALS:

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

LETTERING:

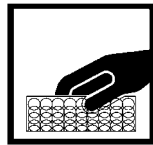
Hand striping or lettering must be applied within 8 hours for good adhesion. After 8 hours, scuff with a gray scuffing pad.

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BLENDING OF CLEARCOAT:

Akzo Nobel Coatings/Sikkens strongly recommends the application of clear coat over the whole panel that is thoroughly prepared. Clearcoating of entire panel is required for lifetime warranty.

There are, however, instances where this is not practical. Such as repairs on older vehicles where economics would dictate that a warranty is not required. In these instances, it may be acceptable to blend the clearcoat into a small area such as a rocker panel or sail panel, vertical areas only. This procedure is not warranted or OE approved.



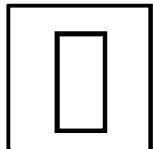
If blending of the clearcoat is inevitable (sail panels), apply Sikkens Blend-Prep on a damp sponge, and scuff until gloss is removed or alternately prepare (sail panels) by lightly scuffing with a 3M Clear Blend Prep Pad #07745 (gold). Thoroughly clean areas with a compliant Sikkens Surface Cleaner.



1.

1x1
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)

Hard line the last coat of clear into the prepared area (sail panel), keeping a sharp blend line.



2.

Reducer SRA 7.0
Ready to spray

Use pure Reducer SRA 7.0 to dissolve overspray edge. Refer to your local VOC regulations for "Specialty Coating" compliance.



3.

2x1
HVLP 10 psi (max 0.8 bar)
Conventional - 20–30 psi
(1.3–2.0 bar)

Spray 1 thin coat.
Flash for 15 seconds.
Apply a final thin coat.

AFTER TREATMENT:

After the repair area is completely dry, the fade out area (if any) may be polished with an ultra-fine polishing compound and waxed. (Please see dry to polish time of the products used.)

NOTE:

Please refer to the following Technical Data Sheets for more information.

- Autobase Plus Solid, Metallic and Pearl Colors
- Autobase Plus Blending Additive
- Sikkens Reducer SRA 7.0



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CLEANING OF EQUIPMENT:

Clean equipment with Sikkens Cleaning Solvent 790 or lacquer thinner.

STOCK KEEPING:

COLOR: Clear

CONTAINER SIZE:

Autoclear Vision HS:	1 quart (0.95 lt)
Autoclear Vision HS Hardener:	1 gallon (3.785 lt)
Autoclear Vision HS Activator:	3.2 oz (100 ml)

SHELF LIFE:

- Autoclear Vision HS:
Six months if stored unopened at room temperature.
- Autoclear Vision HS Hardener:
Six months if stored unopened at room temperature.
- Autoclear Vision HS Activator:
Six months if stored unopened at room temperature.

SAFETY ASPECTS:

READY TO SPRAY VOC:

Ready to spray, Autoclear Vision HS, yields a VOC content of:
1.9 lb/gal 228 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 the 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 suits, wear safety glasses or goggles when mixing, and wear full hood fresh air fed respirator while spraying.



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Mixing Wall Chart

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