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## AUTOCOAT® LV CLEAR HIGH SOLIDS

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**DESCRIPTION:** Autocoat LV Clear High Solids is a high solid two-component polyurethane enamel clear. Autocoat LV Clear High Solids provides full gloss retention and durability over Autobase Basecoat in a two-coat application. When applied, the Ready to Spray VOC is 3.65 lbs. per gallon.

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### PRODUCTS & ADDITIVES:

**PRODUCT:** Autocoat LV Clear High Solids

**HARDENERS:**

- Autocoat LV Hardener Fast; a faster hardener for spot and panel repair. Temperature Range 60°F–85°F (16°C–29°C).
- Autocoat LV Hardener Standard; for spot and panel repair in high temperatures or complete resprays in cooler temperatures 60°F–85°F (16°C–29°C).
- Autocoat LV Hardener Slow; a slower hardener for all applications in higher temperatures 85°F (29°C) and above.

**REDUCERS:**

- Autocoat LV Reducer; a special reducer made for Autocoat LV Clear High Solids and Autocoat LV Solid Color. As Autocoat LV Clear High Solids has no flash-off time—per se—as conventional topcoat systems, this one reducer is suitable for spot and panel repairs as well as complete resprays at temperatures up to 85°F (30°C).
- Autocoat LV Retarder; a specially developed retarder which can be used in place of the Autocoat LV Reducer in extremely hot ambient temperatures (above 100°F (38°C)). Autocoat LV Retarder can be combined with Autocoat LV Reducer at temperatures below 100°F (38°C).
- Blending Agent 790; a special solvent to be used instead of Autocoat LV Reducer for spot repairs and also to dissolve fade out areas of spot repairs. See "Spot Repairs with Autobase®" Technical Data Sheet for VOC restricted areas.
- Autocoat LV Retarder; a special retarder for use in Autocoat LV Clear HS for use on large jobs in temperatures above 95°F.

**ADDITIVES:**



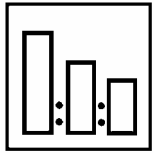
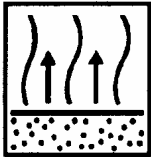
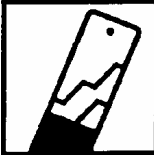

- Autocoat LV Flex; additive to increase flexibility of Autocoat LV Clear High Solids, for use on flexible parts.
- Autocoat LV Accelerator; a specially designed accelerator to improve the curing speed of Autocoat LV Clear High Solids.

**BASIC RAW MATERIALS:**

Autocoat LV Clear High Solids: acrylic and polyester resins  
Autocoat LV Hardeners: polyisocyanate resins

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### APPLICATION:

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|----|---|--|----|--|--|
| 1. |  | Contains acrylic resins, methyl amyl ketone, xylene and other ingredients. When mixed, Autocoat LV Clear High Solids contains polyisocyanates. | 4. |  | 2x1<br>HVLP-Siphon<br>0.071"–0.087" (1.8–2.2 mm)<br>HVLP – Gravity<br>0.051"–0.059" (1.3–1.5 mm)<br>Max 10 psi (max 0.8 bar) |
| 2. |  | 100:50:25<br>Autocoat LV Clear High Solids<br>Autocoat LV Hardener Fast,<br>Standard or Slow<br>Autocoat LV Reducer                            | 5. |  | 10 minutes at 70°F (20°C)  |
| 3. |  | Use the Sikkens Measuring Stick #11 (Blue).  | 6. |  | 14 hours at 70°F (20°C)<br>45 minutes at 140°F (60°C)<br>(Fast Hardener)   |

### SUITABLE SURFACES:

- Autobase Solid; metallic and pearl colors, after a flash time of 15–20 minutes at 70°F (20°C).
- Existing finish; in the case of spot repair and blending, please see further information later in this Technical Data Sheet.
- Autocoat LV Solid Color; after a flash-off time of 5 minutes in the case of spot repairs with Autocoat LV Solid Color or 10 minutes over Autocoat LV Solid Colors in complete resprays. Please see Technical Data Sheet, "Spot Repairs with Autocoat LV Solid Color".

### MIXING RATIO:

- Mix 100 parts by volume of Autocoat LV Clear High Solids, with  
50 parts by volume of Autocoat LV Hardener Fast, Standard or Slow  
25 parts by volume of Autocoat LV Reducer.  
For easy and accurate mixing, use the Sikkens Measuring Stick #11 (Blue).

### SPRAYING VISCOSITY:

- 23–26 sec. ZAHN cup #2 (21–24 sec. DIN cup #4) at 70°F (20°C).

### POT LIFE:

- 2 hours at 70°F (20°C) with Autocoat LV Reducer  
30 minutes at 70°F (20°C) with Autocoat LV Accelerator



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### SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
Siphon Feed	0.063"–0.071" (1.6–1.8 mm)	50–60 psi (3.5–4.5 bar)
Gravity Feed	0.055"–0.059" (1.4–1.5 mm)	50–60 psi (3.5–4.5 bar)
Pressure Feed	0.037"–0.047" (1.0–1.2 mm)	50–60 psi (3.5–4.5 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 of Autocoat LV Clear High Solids should be applied with sufficient flow but should not be applied too heavy. After the stated flash-off time, apply the second coat.

### FLASH TIME:

10 minutes at 70°F (20°C). Compared to conventional products, Autocoat LV Clear High Solids does not rely on solvent evaporation for its initial drying; therefore, the product is still wet to the touch after this flash time. You may proceed with the second coat application without fear of solvent pops.

### DRYING TIMES:

Below is a table showing the drying times of Autocoat LV Clear High solids:

Metal Temp.	Drying	Fast	Standard	Slow	* Fast Hardener w/Accelerator
70°F (20°C)	Dust Free	35 min	40 min	50 min	30 min
	Dry	14 h	16 h	20 h	10 h
	Dry to polish	24 h	32 h	48 h	16 h
100°F (38°C)	Dust Free	20 min	25 min	30 min	15 min
	Dry	2 h	2-1/2 h	3 h	1-1/2 h
	Dry to polish	4 h	5 h	6 h	3 h
140°F (60°C)	Dust Free	10 min	10 min	10 min	5 min
	Dry	45 min	50 min	1 h	30 min
	Dry to polish	1-1/2 h	1-1/2 min	2 h	45 min

\* Dry times are determined when Autocoat LV Accelerator is used in combination with Fast Hardener.

### NOTE:

After the last coat of Autocoat LV Clear High Solids and following a flash-off time of 10 minutes, Autocoat LV Clear High Solids can be baked at 140°F (60°C).



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**RECOATABILITY:** Autocoat LV Clear High Solids can be recoated with itself at any stage. Sanding will become necessary after 24 hours.

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

**COVER RATE:** Approximately 95 sq. ft./liter of unmixed paint at a film thickness of 2.8 mils. As it is a requirement that Autocoat LV Clear High Solids be applied at a film thickness of approximately 2.8 mils, this should be done by applying 2 single coats.

**POLISHING:** 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) metal temperature followed by a 1-1/2 hour cool down at 70°F (20°C). Carefully sand out dust particles with #10 micron (#1500) grit paper wet, then polish the area manually or mechanically.

**NOTE:** When heavy color sanding and rubbing are required, it may be necessary to apply one extra coat of Autocoat LV Clear HS.

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

**WHAT TO DO:** **In the case of second repair;** as second repairs normally involve fresh base coat/clear coat paint jobs, it is important to remember you will be working on a relatively sensitive substrate, especially when the clear coat has been extensively sanded or sanded through. When, for example, the clear has been broken through, exposing the base coat and other underlying layers, it is beneficial to isolate the various layers, including the base coat, to avoid the risk of lifting; therefore, the repair area should be sealed with a primer surfacer that is compliant to local regulations, allow a good flash off between coats. After drying, sand with #400 grit paper dry or #600 (3M #P600 to #P800) grit wet. Apply the spot repair with Autobase in light coats.

**NOTE:** It is recommended to allow at least the stated dry-to-polish times before commencing a second repair. If necessary, an infrared heat lamp may be used to accelerate the drying.

**WHAT TO DO:** **In the case of spot repairs and fade out;** as most often, repairs are made with a fade out of the base coat color and sometimes with a fade out of the clear coat. Please find in Technical Data Sheet, "Spot Repairs with Autocoat LV", a comprehensive spot repair process made for VOC regulated areas to include Autobase and Autocoat LV Clear High Solids.



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### STOCK KEEPING:

**COLOR:** Clear

**CONTAINER  
SIZE:**

Autocoat LV Clear High Solids: 1 gallon (3.785 lt)  
Autocoat LV Hardener Fast,  
Standard and Slow: 1 gallon (3.785 lt)  
Autocoat LV Reducer: 1 gallon (3.785 lt)

**SHELF LIFE:**

Autocoat LV Clear High Solids: One year if stored unopened at room temperature.  
Autocoat LV Hardener Fast,  
Standard and Slow: Six months if stored unopened at room temperature.  
Autocoat LV Reducer: Two years if stored unopened at room temperature.  
Autocoat LV Retarder: One year if stored unopened at room temperature.  
Autocoat LV Accelerator: One year if stored unopened at room temperature.

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### SAFETY ASPECTS:

**READY TO  
SPRAY VOC:**

100:50:25  
Autocoat LV Hardener Fast,  
Standard or Slow: 3.7 lb/gal 450 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 an air-supplied respirator when exposed to vapors or spray mist.

