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## AUTOCOAT® LV (3.5 VOC)

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**DESCRIPTION:** Autocoat LV is a high solid two-component polyurethane enamel top coat, suitable for automotive refinishing, trucks and equipment. Autocoat LV provides easy application, excellent flow with superior gloss and durability in a two-coat application. When applied, the ready to spray VOC is 3.5 lbs. per gallon.

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### PRODUCT & ADDITIVES:

**PRODUCT:** Autocoat LV

**HARDENERS:** —Autocoat LV Hardener Standard: A medium speed range hardener for spot and panel repairs or complete resprays in cooler temperatures 60°F–80°F (16°C–27°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 color. As Autocoat LV has no flash-off time—per se—as conventional topcoat systems, this reducer is suitable for spot and panel repairs as well as complete resprays, in 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 Technical Data Sheet, “Spot Repairs with Autocoat LV”.



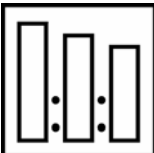
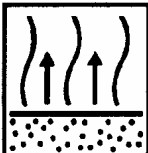
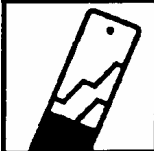

**ADDITIVES:** —Autocoat LV Flex; additive to increase flexibility of Autocoat LV for use on flexible parts.  
—Autocoat LV Accelerator; a special accelerator used in place of reducer to help speed the curing of Autocoat LV.  
—Autocoat LV 444; a specialized matting agent used to reduce the gloss of Autocoat LV. For further information in the use of Autocoat LV 444, please see the product Technical Data Sheet.

### BASIC RAW MATERIALS:

Autocoat LV: acrylic and polyester resins  
Autocoat LV Hardener Standard and Slow: 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 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<br>Autocoat LV Hardener<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. |  | 16 hours at 70°F (20°C)<br>45 minutes at 140°F (60°C)<br>(Autocoat LV Hardener Standard)                                      |

### SUITABLE SURFACES:

Autocoat LV can be applied directly over:  
—All existing finishes, degreased and sanded with #P360 to #P500 grit paper dry or #P600 to #P800 grit wet.  
—Fiberglass gelcoat, degreased and sanded with #P360 to #P400 grit dry or #P600 to #P800 grit wet.  
—All Sikkens preparatory products.

### SURFACE PREPARATION:

—All products that are to be sanded, you may have to initially sand, but final sanding with #P400 to #P500 grit paper dry or #P600 to #P800 grit wet is recommended.  
—Wet-on-wet products, please follow recommendation for product in use by consulting the relevant Technical Data Sheet.

### MIXING RATIO:

Mix 100 parts by volume of Autocoat LV, with  
50 parts by volume of Autocoat LV Hardener 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:

The proper spraying viscosity is achieved by using the recommended mixing ratios. 23–25 sec. ZAHN cup #2 (21–23 sec. DIN cup #4) at 70°F (20°C).

### POT LIFE:

1 hour 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	Fluid Pressure
Siphon Feed	0.063"–0.071" (1.6–1.8 mm)	50–60 psi (3.5–4.5 bar)	
Pressure Feed	0.039"–0.047" (1.0–1.2 mm)	50–60 psi (3.5–4.5 bar)	10–14 psi (0.8–1.0 bar)
HVLP Pressure Feed	0.031"–0.039" (0.8–1.0 mm)	max 10 psi (max 0.8 bar)	5–7 psi (0.3–0.6 bar)
HVLP Siphon	0.071"–0.087" (1.8–2.2 mm)	max 10 psi (max 0.8 bar)	
HVLP Gravity	0.051"–0.059" (1.3–1.5 mm)	max 10 psi (max 0.8 bar)	

### APPLICATION METHOD:

Apply 2 single, flowing coats. The first coat of Autocoat LV should be applied with sufficient flow but should not be applied too heavy. After the stated flash-off time, apply the second coat.

### FLASH TIMES:

10 minutes at 70°F (20°C). Compared to conventional products, Autocoat LV 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:

Metal Temperature	Drying	Autocoat LV Hardener		
		Standard	with Autocoat LV Accelerator	Slow
70°F (20°C)	Dust Free	40 minutes	30 minutes	50 minutes
	Dry	16 hours	6 hours	20 hours
	Dry to polish	32 hours	12 hours	48 hours
100°F (38°C)	Dust Free	25 minutes	15 minutes	30 minutes
	Dry	2-1/2 hours	2 hours	3 hours
	Dry to polish	5 hours	4 hours	6 hours
140°F (60°C)	Dust Free	10 minutes	5 minutes	10 minutes
	Dry	45 minutes	30 minutes	1 hour
	Dry to polish	1-1/2 hours	45 minutes	2 hours

### NOTE:

After the last coat of Autocoat LV and following a flash-off time of 5 minutes, Autocoat LV can be baked at 140°F (60°C) metal temperature.



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**RECOATABILITY:** Autocoat LV can be recoated with itself or with Autoclear LV Clear HS and Autoclear II LV at any stage. Sanding will become necessary after 24 hours.

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

**COVER RATE:** Approximately 84 sq. ft./liter of unmixed paint at a film thickness of 2.5 mils. As it is a requirement that Autocoat LV be applied at a film thickness of approximately 2.5 mils, this is achieved by applying 2 single coats.

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

**POLISHING:** Dust and minor damage can be polished out after the "Dry to Polish" times listed previously in this TDS have been reached.

Process: Carefully color sand, removing dust particles with #1500 grit paper wet. Final sand (in a right-angled direction to the #1500 grit) with #2000 grit paper wet. Make sure water is fresh and clean and no contaminants enter during this process as this will scratch the surface. Clean and dry the surface to be polished.

Suggested compounds: 3M products

Step one: Use Perfect-It Rubbing Compound, Part No. 05984 or Perfect-It Rubbing Compound, Part No. 05981. Either compound should be applied with a white wool pad, Part No. 05711.

Step two: Use Perfect-It Foam Polishing Pad Glaze, Part No. 05995 or Perfect-It Foam Polishing Pad Glaze, Part No. 05996. Either polishing glaze should be applied with a yellow wool pad, Part No. 05713, or a Perfect-It Foam Polishing Pad, Part No. 05725.

**NOTE:** For extensive color sanding and buffing, it is necessary to apply 1–2 coats of Autoclear LV Clear HS or Autoclear II LV. Allow 15 minutes flash off before applying 1–2 coats of clear.

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### STOCK KEEPING:

**AVAILABILITY:** Autocoat LV is available ready mixed or can be mixed by means of the Sikkens mixing machine.

**SHELF LIFE:**

Autocoat LV:	Two years if stored unopened at room temperature.
Autocoat LV Hardener	
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.

**COLOR RANGE:** See the Sikkens Color Listing or the computerized Mixit System.



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### SAFETY ASPECTS:

#### READY TO SPRAY VOC:

Autocoat LV (100:50:25):	3.5 lbs/gal	420 g/liter
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#### 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.

