



AUTOBASE® PLUS SOLID, METALLIC AND PEARL COLORS

DESCRIPTION: Autobase Plus basecoat provides excellent coverage, metallic control and sprayability when used to duplicate OEM solid, metallic and pearl color effects. Autobase Plus must be used in conjunction with a Sikkens clearcoat in order to provide protection from the environment. Autobase Plus is the superior choice to achieve optimal color match.

PRODUCTS & ADDITIVES:

PRODUCTS: —Autobase Plus Solid
—Autobase Plus Metallic and Pearl Colors

REDUCERS: —Autobase Plus Reducer Fast: for spot and panel repairs.
Temperature range: 60°F–75°F (16°C–24°C).
—Autobase Plus Reducer Medium: for spot and panel repairs and large areas.
Temperature range: 70°F–85°F (20°C–30°C).
—Autobase Plus Reducer Slow: for larger areas and complete paint jobs.
Temperature range: 80°F–95°F (27°C–35°C).
—Autobase Plus Reducer Extra Slow: a specially developed reducer, which can be used in extremely hot temperatures.
Temperature range: above 95°F (35°C).

Note: Autobase Plus Reducers should not be used in Autobase.

ADDITIVES: —Autoclear II LV Hardener: hardener that can be used to extend clearcoat time of Autobase Plus solid colors. See further information in this TDS under “Drying Times”.

Note: This hardener may also be used under extreme circumstances, while spraying soft “foam” spoilers. Then it is necessary to add 10% hardener to Autobase Plus, before continuing to add Autobase Plus Reducer.

Note: Autocoat LV Flex is not needed in Autobase Plus.


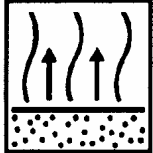
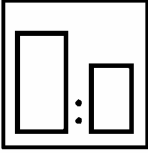

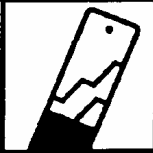
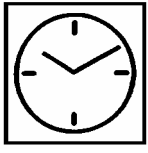


—Autobase Plus Blending Additive: A purpose made blending additive that may be used while making spot repairs and blending Autobase Plus. Please see TDS on Autobase Plus Blending Additive and TDS on Spot Repairs with Autobase Plus.

CLEARCOATS: Autoclear II LV: Please refer to the clearcoat technical data sheet.

BASIC RAW MATERIALS: Autobase Plus: physically drying binders.
Autobase Plus Reducers: special solvent blends.
Hardener: polyisocyanate resin.

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APPLICATION:

- | | | | | | |
|----|---|--|----|--|--|
| 1. |  | Contains acrylic resins and other ingredients. | 5. |  | 3–5 minutes at 70°F (20°C) |
| 2. |  | 100:50
Autobase Plus
Autobase Plus Reducer | 6. |  | (Autobase Plus Metallic)
1x1
Increase distance and apply a metallic orientation coat if necessary. |
| 3. |  | Use the Sikkens Measuring Stick #1 (Black). | 7. |  | 15–20 minutes at 70°F (20°C) |
| 4. |  | 2x1
HVLP–Gravity
1.3–1.5 mm
HVLP–Siphon
1.8–2.2 mm
Max 10 psi (0.8 bar) | 8. |  | Apply Autoclear II LV |

SUITABLE SURFACES:

- Autobase Plus can be applied directly over:
- OEM 2-step solid and metallic systems and over existing finishes; degreased and sanded with #P500 to #P600 grit paper dry or #P600 to #P800 grit wet but not over thermoplastic acrylic lacquers. In that case, the entire panel of lacquer must be sealed with a compliant Sikkens undercoat system.
 - Any Sikkens preparatory product that is compliant for local regulations.

SURFACE PREPARATION:

- All products that are to be sanded: you may have to initial sand, but final sanding with #P500 to #P600 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.



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MIXING RATIO: Autobase Plus solid, metallic and pearl colors are mixed as follows:
100 parts by volume of Autobase Plus color with
50 parts by volume of Autobase Plus Reducer
For easy and accurate mixing, use the Sikkens Measuring Stick #1 (Black).
For example: pour Autobase Plus to the #1 in the first column, then pour Autobase Plus Reducer to the #1 in the second column.

LIGHT AUTOBASE PLUS COLORS: Autobase Plus solid white or colors containing 50% or more Autobase Plus Q110 white should not be applied directly over Washprimer EM. If this product is necessary for metal treatment, apply only one coat, allow 30 minutes flash and proceed without sanding using either a sanding primer surfacer, or a pigmented wet-on-wet sealer that is compliant for your area.

SPRAYING VISCOSITY: The proper spraying viscosity is achieved by using the recommended mixing ratio. Autobase Plus Solid, Metallic and pearl colors: 16–17 sec. DIN cup #4 at 70°F (20°C).

POT LIFE: Autobase Plus Solid and Metallic colors: 6 months
Pearl colors (three stage): 24 hours.

SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
Siphon Feed	0.055"–0.067" (1.4–1.7 mm)	40–50 psi (3–4 bar)
Gravity Feed	0.047"–0.055" (1.2–1.4 mm)	40–50 psi (3–4 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 OF AUTOBASE PLUS SOLID:

Spray 2 single coats, allow approximately 3–5 minutes flash-off between each coat. Primed areas and over areas where extra coverage is required, first apply a single thin coat.



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APPLICATION OF AUTOBASE

PLUS METALLIC: Spray 2 single coats, at approximately 6 inches from the panel allowing 3–5 minutes flash off between each coat. Even out the metallic pattern with a metallic orientation coat after the second coat has flashed off completely. This is achieved by extending the distance between the gun and panel, and applying a lighter coat. Do not make this coat too wet. With HVLP equipment, it is not necessary to lower the pressure, although this may be done in order to control the color.

APPLICATION OF OF AUTOBASE PLUS THREE

STAGE COLORS: **Autobase Plus Solid Foundation Color:** Spray 2 single coats, allowing approximately 3–5 minutes flash-off between each coat. Over primed areas and areas where extra coverage is required, apply first a single thin coat. Allow the foundation coat to dry for 15–20 minutes.

Autobase Plus Metallic Foundation Color: Follow the application procedures listed above under “Application of Autobase Plus Metallic”.

Autobase Plus Pearl Mid Coat: Spray three to four thin coats, allowing 3–5 minutes flash-off between coats at 70°F (20°C). Do not lower the air pressure for pearl coats.

Autobase Plus Transparent Solid Color Mid Coat: Spray three to four even, wet coats, allowing 5-10 minutes flash-off between coats at 70°F (20°C).

DRYING TIME:

Allow Autobase Plus to dry for 15 to 20 minutes at 70°F (20°C) before applying the clearcoat. The maximum time Autobase Plus may be left before clear:

Autobase Plus Metallic Color: 48 hours

Autobase Plus Solid Color: 5 hours

To extend the re-coat time of solid colors to 48 hours, mix Autobase Plus as follows: add 10% Autoclear II LV Hardener prior to the addition of Autobase Plus Reducer.

FILM

THICKNESS:

Autobase Plus Solid, Metallic and Pearl: 0.3–0.4 mils per single coat.

COVER RATE:

Approximately 195 sq.ft./liter of unmixed paint per single coat.

CLEANING

OF EQUIPMENT:

Clean equipment with Sikkens Cleaning Solvent 790.

TWO-TONE

APPLICATION:

Autobase Plus Solid, Metallic and pearl colors can be taped off with fine line masking tape after 20 minutes flash-off at 70°F (20°C) and a second color of Autobase Plus can then be applied.



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ADDED

INFORMATION:

Hand made colors: if it is necessary to make your own color without using a color formula, it is essential that you incorporate the toner Autobase Plus Connector Q 065 into the paint mix. To do this, mix 3 parts Autobase Plus hand made color to 1 part toner Q 065. Use the Sikkens Measuring Stick #9 (Grey). Then stir thoroughly, reduce and apply as normal. Failure to do this will cause poor product performance.

SECOND REPAIR:

If, during the application of Autobase Plus Solid or Metallic color, some damage occurs such as dust impregnation or perspiration spots, allow the Autobase Plus to flash off for 20 minutes at 70°F (20°C). Lightly sand the damaged area with #P600 to #P800 grit paper wet. As there is no clearcoat to protect the base coat at this stage, care must be taken to clean up all sanding residue. Proceed by making a spot repair as described in the TDS, "Spot Repairs with Autobase Plus."

WHAT TO DO:

In the case of lifting; some substrates are not original and are unknown. Then it is reasonable to apply 1-2 coats of a sanding primer surfacer, prior to Autobase Plus, over the whole panel. A pigmented sealer may also be used as a wet-on-wet process. In blending situations, it is necessary to first apply Basefix 790

In the case of fisheyes caused by silicones, spray 2 mist coats over the contaminated area, and then proceed, allowing longer flash off times. If severe, it may be necessary to allow a dry time of 20-30 minutes, sand and continue to spray Autobase Plus. Adding anti-silicone to Autobase Plus is not recommended, as this may lead to a risk of poor adhesion of the clearcoat.

STOCK KEEPING:

AVAILABILITY:

Autobase Plus Solid, Metallic and Pearl Colors are available ready-mixed or can be mixed by means of the Sikkens Color Mixing System.

COLOR RANGE:

See the Sikkens Color Listing or the computerized MIXIT System.

SHELF LIFE:

Autobase Plus MM Toners: Four years if stored unmixed at room temperature.

SAFETY ASPECTS:

READY TO

SPRAY VOC:

Autobase Plus 100:50 with Autobase Plus Reducers: 6.5 lb/gal 780 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.

