






AUTOCLEAR HS+ LV (LOW VOC)

DESCRIPTION: Autoclear HS+ LV is a high-solids acrylic urethane clearcoat for use with Autobase Plus. Autoclear HS+ LV offers both a high gloss clearcoat and a productive clearcoat with the use of different hardener and activator combinations. Autoclear HS+ LV enables Sikkens customers to meet the most stringent VOC laws in the Car Refinish Market.

PRODUCT & ADDITIVES:

- PRODUCT:** Autoclear HS+ LV
- HARDENER:** — Autoclear HS+ LV Hardener: a general purpose hardener for all repair sizes
- REDUCERS:** — Standard Activator LV: a general-purpose activated standard reducer for larger areas and overall refinishing. Temperatures of 60°F-105°F (16°-38°C).
— Production Activator LV: an activated production reducer for medium sized areas and spot and panel repairs Temperatures of 60°F-90°F (16°-32°C).
— Rapid Activator LV: an accelerated activated reducer for spot and panel repairs at 55°F-85°F (15°C-28°C)
- ADDITIVES** — LV Elast-O-Actif; an additive designed to increase clearcoat flexibility for use on flexible plastic parts with a 10% addition. See "LV Elast-O-Actif" TDS.
— Autoclear Mat: a special clearcoat with a mat finish.
- BASIC RAW MATERIALS:** — Autoclear HS+ LV: hydroxyl acrylic resins
— Autoclear HS+ LV Hardener: polyisocyanate resins
— Standard Activator LV: special activated solvent blends
— Production Activator LV and Rapid Activator LV: activated reducers containing special solvent blends and catalyst.

APPLICATION:

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|----|---|---|----|--|---|
| 1. |  | Contains acrylic resins and other ingredients. When mixed, also contains isocyanates. | 3. |  | Use the Sikkens measuring Stick # 9 (Gray) |
| 2. |  | 3:1:1
Autoclear HS+ LV
Autoclear HS+ LV Hardener
Standard Activator LV | 4. |  | 2 x 1
HVLP Siphon
1.8–2.2 mm
HVLP Gravity
1.4–1.5 mm
Max 10 psi (max 0.8 bar) |
| 5. |  | 6-10 minutes at 70°F (20°C) | 6. |  | Autoclear HS+ LV with
Standard Activator LV
15 hours at 70°F (20°C)
30 minutes at 140°F (60°C) |

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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”.

MIXING RATIO:

- Mix: 3 parts by volume of Autoclear HS+ LV
1 part by volume of Autoclear HS+ LV Hardener
1 part by volume of Standard Activator LV, Production Activator LV or Rapid Activator LV

SPRAYING VISCOSITY:

13-15 seconds. DIN cup #4, 70°F (20°C)

POTLIFE:

2 hours at 70°F (20°C) with all activators

SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
Siphon Feed	1.4–1.7 mm	40–50 psi
Gravity Feed	1.3–1.5 mm	40–50 psi
HVLP Siphon	1.8–2.2 mm	max. 10 psi
HVLP Gravity	1.4–1.5 mm	max. 10 psi

APPLICATION METHOD:

Apply 2 single wet coats. If heavy sanding and polishing is required, a third coat may be applied after the stated flash off time.

FLASH TIME:

6–10 minutes at 70°F (20°C) with Standard Activator LV
4–6 minutes at 70°F (20°C) with Production Activator LV
No flash at 70°F (20°C) with Rapid Activator LV

DRYING TIMES:

Below is a table showing the drying times of Autoclear HS+ LV. The air-dry times stated may vary with insufficient airflow.

Metal Temp.	Drying	Standard Activator LV	Production Activator LV	Rapid Activator LV
70°F (20°C)	Dust Free 1	hr	35 min	30 min
	Dry	10 hr	7 hr	4 hr
140°F (60°C)	Dust Free2	0 min	15 min	7 min
	Dry	30 min	20 min	10 min



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RECOATABILITY: Autoclear HS+ LV can be re-coated with itself at any stage. Sanding will become necessary after 12 hours.

FILM THICKNESS: 1.2–2.0 mils per single coat

COVERAGE RATE: Approximately 100 sq. ft./liter of unmixed paint at a film thickness of 2.5 mils

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

LETTERING: Hand striping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a gray scuffing pad.

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

STOCK KEEPING:

COLOR: Clear

CONTAINER SIZE:

- Autoclear HS+ LV: 1 gallon (3.785 lt)
- Autoclear HS+ LV Hardener: 1 gallon (3.785 lt) or 1 quart (0.8 lt)
- Standard Activator LV, Production Activator LV and Rapid Activator LV: 1 gallon (3.785 lt)

SHELF LIFE:

- Autoclear HS+ LV: One year if stored unopened at room temperature.
- Autoclear HS+ LV Hardener: Six months if stored unopened at room temperature.
- Standard Activator LV, Production Activator LV and Rapid Activator LV: Six months if stored unopened at room temperature.

SAFETY ASPECTS:

READY TO SPRAY VOC: (3:1:1)
When mixed ready to spray,
Autoclear HS+ LV yields a VOC content of: 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 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.