

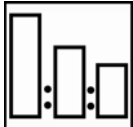


Sikkens Autoclear[®] Superior 250

FOR PROFESSIONAL USE ONLY

Description

A two component VOC compliant clearcoat, designed for use over Autowave. Consisting of one clearcoat, one dedicated hardener and three reducers, designed for optimum application properties. Autoclear Superior 250 covers all sizes of repairs, under all application conditions, combined with high gloss level on Autowave.



- 3 Autoclear Superior 250
- 2 Autoclear Superior 250 Hardener
- 1 Autoclear Superior 250 Reducer Fast, Medium or Slow



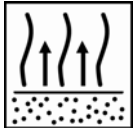
Use Sikkens measuring stick
250 (Green)



Spray gun set-up:	Application pressure:
1.3-1.4 mm	29 psi (spray gun air inlet)
HVLP max. 10 psi at air cap	o Check gun manufacturer specification



2 x 1 coat
First apply a medium closed coat, next apply a full coat after indicated flash off time



Between coats	Before curing
3-5 minutes at 70°F (20°C)	0-5 minutes at 70°F (20°C)



Reducer selection	70°F (20°C)	140°F (60°C)
Autoclear Superior 250 Reducer Fast	4 hours	15 minutes
Autoclear Superior 250 Reducer Medium	5 hours	25 minutes
Autoclear Superior 250 Reducer Slow	6 hours	30 minutes



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

Sikkens Autoclear[®] Superior 250

FOR PROFESSIONAL USE ONLY

Description

A two component VOC compliant clearcoat, designed for use over Autowave. Consisting of one clearcoat, one dedicated hardener and three reducers, designed for optimum application properties. Autoclear Superior 250 covers all sizes of repairs, under all application conditions, combined with high gloss level on Autowave.

Product and additives

Product	Autoclear Superior 250.
Hardener	Autoclear Superior 250 Hardener; a general purpose hardener for all repair sizes.
Reducers	Autoclear Superior 250 Reducer Fast; spot and panel repairs at or below 70°F (20°C) Autoclear Superior 250 Reducer Medium; larger areas and overall refinishing at 77°F-95°F (25°C-35°C) Autoclear Superior 250 Reducer Slow; larger areas and overall refinishing at 95°F (35°C) and above
Additives	LV Elast-O-Actif; additive to increase flexibility of Autoclear Superior 250, for use on flexible parts.

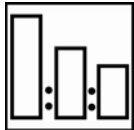
Basic raw materials

Autoclear Superior 250;	Polyol resins
Autoclear Superior 250 Hardener;	Poly-isocyanate resins
Autoclear Superior 250 Reducers;	special solvent blends

Suitable substrates

- Autowave; after a minimum flash off time of 15 minutes at 77°F (25°C).
- Existing finish that is thoroughly prepared, in the case of spot repairs and blending.

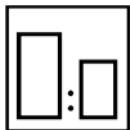
Mixing Ratio



- 3 parts by volume of Autoclear Superior 250.
- 2 parts by volume Autoclear Superior 250 Hardener.
- 1 part by volume Autoclear Superior 250 Reducer Fast, Medium or Slow.

○ For easy and accurate mixing, use the Sikkens measuring stick No. 250 (Green)

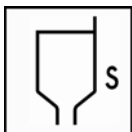
Flexible car parts



- To increase flexibility of Autoclear Superior 250 for use on flexible parts.
- Before adding hardener and reducer prepare the Autoclear Superior 250 as follows:
- 100 parts by volume Autoclear Superior 250.
- 10 parts by volume LV Elast-O-Actif

○ For easy and accurate mixing, use the Sikkens measuring stick No 14 (Blue)

Viscosity



- 14-16 seconds – DIN Cup #4 at 70°F (20°C)
- 30-35 psi at the spray gun air inlet

Sikkens Autoclear[®] Superior 250

FOR PROFESSIONAL USE ONLY

Spray gun set-up / application pressure



Spray gun

HVLP gravity	1.3-1.4 mm
High Transfer gravity	1.3-1.4 mm
High Transfer Pressure Feed	1.0-1.2 mm
HVLP Pressure Feed	0.8-1.0 mm

Fluid tip – set-up

Application pressure

HVLP max 10 psi at the air cap
 ○ Check gun manufacturer specification.

Application process



Apply a medium closed coat, allowing for a 3-5 minutes flash off time.
 Next, apply a full coat, allowing for a 0-5 minutes flash-off time before baking.
 ○ Flash off between coats; in case of application to larger areas a minimal flash off time between coats is required

Pot-life

(The ready to spray mixture 3:2:1)

Autoclear Superior 250 Reducer Medium or Slow:	45 minutes	At 70°F (20°C)
Autoclear Superior 250 Reducer Fast:	20 minutes	At 70°F (20°C)

Film thickness

Per coat: 1.0-1.2 mils. (20-30 µm)
 The total dry layer thickness: 1.7-2.4 mils. (45-60 µm)

Drying times

Allow a 5 minute flash-off time before moving the car into a pre-heated drying oven (booth).
 All drying times relate to standard application and object temperature.



		Autoclear Superior 250 Reducer Fast	Autoclear Superior 250 Reducer Medium	Autoclear Superior 250 Reducer Slow
70°F (20°C)	Dust dry	1 hour	1 ½ hours	2 hours
	Dry to handle	4 hours	5 hours	6 hours
122°F (50°C)	Dust dry	10 minutes	20 minutes	25 minutes
	Dry to handle	30 minutes	45 minutes	60 minutes
140°F (60°C)	Dust dry	10 minutes	10 minutes	15 minutes
	Dry to handle	15 minutes	25 minutes	30 minutes

sikkens Autoclear[®] Superior 250

FOR PROFESSIONAL USE ONLY



Allow 5 minutes flash off prior to infra red curing
3 minutes at half power
8 minutes at full power

Distance between short wave IR and object;
20 – 27inch (50 – 70 cm)
The panel must not exceed temperatures above 212°F
(100°C)

Through-hardening:

Following the drying cycle at 140°F (60°C) object temperature, allow the Autoclear Superior 250 to cool fully to ambient temperature to complete the through-hardening process.

Recoatibility & blending

- Recoatable with itself after full drying cycle, sanding becomes necessary if there are defects or after 24 hours
- *For blending (spot repair and panel blends), Please see TDS Spot Repairs with Autowave*

Polishability



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) object temperature, followed by a cool down of the object to ambient temperature. Carefully sand out dust particles and restore the surface according to the polishing recommendations.

- *Ready to polish approximately 1 hour after cool down 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 mechanically with 3M Perfect-It 3000 Rubbing Compound System.

Material usage

With recommended application, the theoretical material usage is ± 66.7 sq.ft./liter (6.2 m²/liter) RTS mixture.

- *The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure, method and application circumstances.*

Cleaning of equipment

Clean equipment with Sikkens Gun Cleaning Solvent LV.
or solvent borne gun cleaners

VOC

(3:2:1 Ready to spray mixture) Autoclear Superior 250: 2.1 lb/gal 250 g/liter

Product storage

Store products unopened, and used products with closed lids preferably between 70°F-95°F (10°C-35°C)
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

- *Product shelf life data see TDS S9.02.01 1 year*



sikkens Autoclear[®] Superior 250

FOR PROFESSIONAL USE ONLY

FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

Coating brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

Head Office

Akzo Nobel Car Refinishes Inc. 5555 Spalding Drive Norcross, GA 30092, USA. 770-662-8464 www.sikkenscr.com