

AUTOCLEAR VISION II HS

DESCRIPTION:

Autoclear Vision II HS is a user friendly, easy to apply ultra high-solids clearcoat designed to increase bodyshop profitability through savings of energy and materials while also increasing productivity. Autoclear Vision II HS offers low material usage, extremely fast curing times and ultra high gloss.

PRODUCT & ADDITIVES:

Autoclear Vision II HS

HARDENER:

Autoclear Vision II HS Hardener

REDUCERS:

Autoclear Vision II HS Activator

ADDITIVES:

— Autocryl Elast-O-Actif: for National Rule areas. Additive to increase flexibility of Autoclear Vision II HS for use on flexible parts.

—LV Elast-O-Actif: for rule 1151 and other VOC restricted areas. Additive to increase flexibility of Autoclear Vision II HS for use on flexible parts.

BASIC RAW MATERIALS:

— Autoclear Vision II HS: ultra high solids patented resins

— Autoclear Vision II HS Hardener: polyisocyanate resins

— Autoclear Vision II HS Activator: solvents containing a catalyst

APPLICATION:



1.

Contains polyester resins and other ingredients. When mixed, Autoclear Vision II HS also contains isocyanates.



4.

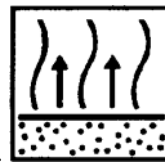
1x1 (see application method)
High Transfer Gravity
(1.1–1.3mm)
HVLP Gravity (1.1–1.3mm)
Max 10 psi (at air cap)



2.

36.7 grams Autoclear Vision II HS
114.4 grams Autoclear Vision II HS Hardener
1.1 grams Autoclear Vision II HS Activator

(See insert for amounts to mix. **Scale mix only**).



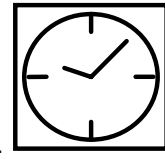
5.

1-2 minutes at 70°F (20°C)



3.

Stir Thoroughly



6.

8 hours at 70°F (20°C)
(air dry time depends on
temperature and humidity)
5 minutes at 140°F (60°C)
Metal temperature

AUTOCLEAR VISION II HS

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”.

Note:

As Autoclear Vision II HS is an extremely fast curing product it is understandable that the paint system, Autobase Plus, and if necessary any Sikkens non-sanding sealer, be applied as thin as possible and flashed thoroughly per TDS. All recommended drying times between products should be strictly adhered to for maximum performance and appearance.

MIXING RATIO:

- 36.7 grams by weight of Autoclear Vision II HS
- 114.4 grams by weight of Autoclear Vision II HS Hardener
- 1.1 grams by weight of Autoclear Vision II HS Activator

Below is a table to help mix the proper amount of material for the job size. These quantities are based on the average mid-sized automobile.

Note: Attached on this TDS, is a wall chart that may be used for easy reference.

By weight



	Autoclear Vision II HS	Autoclear Vision II HS Hardener	Autoclear Vision II HS Activator	Total
1 panel	36.7 grams	114.4 grams	1.1 grams	152.2 grams
2 panels	73.4 grams	228.8 grams	2.2 grams	304.4 grams
3 panels	110.1 grams	343.2 grams	3.3 grams	456.6 grams
Half a car	183.5 grams	572 grams	5.5 grams	761 grams
Complete	367 grams	1144 grams	11 grams	1522 grams

NOTE: Always zero the scale prior to adding each component.

SPRAYING VISCOSITY:

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

POTLIFE:

In a closed container, 4 hours at 70°F (20°C), 2 hours at 90°F (32°C)

Note:

If there is mixed product remaining after use, it may be temporarily stored in a closed container and can be rejuvenated by adding freshly mixed product before the pot life expires. A good balance would be no more than 50% of the original mixed product to which new material is added.

SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
Gravity Feed	1.1–1.3 mm	40–50 psi
HVLP Gravity	1.1–1.3 mm	max. 10 psi (air cap)
High Transfer Gravity	1.2mm	35 psi



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APPLICATION METHOD:

Apply one double coat. Applying first a single thin open coat, followed immediately with a single medium wet coat. A flash off time of up to 5 minutes may be allowed between coats.

NOTE: Due to the immediate application of the second coat do not over apply the first coat.

FLASH TIME:

1-2 minutes with no regard to spray temperature.

NOTE: For larger areas such as a hood. When the first coat is finished, immediately continue with the last coat.

DRYING TIMES:

5 minutes at a metal temperature of 140°F (60°C)

NOTE: Immediately after the last coat of Autoclear Vision II HS, it may be baked. In all cases minimize flash off times before bake.

Consideration of temperature and/or color:

Most spray booths today are direct fired and ramp up to full baking temperature quite fast. During very warm/summer spray temperatures, i.e. above 95° F (35° C) and high humidity, the metal reaches the set bake temperature very quickly, especially with black and dark colors. In this case, it is advisable to set the bake (metal) temperature at 120° F (50° C). Do not adjust the bake time. This will avoid the possibility of over baking.

RECOATABILITY:

Autoclear Vision II HS can be re-coated with itself at any stage. Sanding will become necessary after the stated dry times, plus 8 hours at room temperature.

FILM THICKNESS:

1.8–2.2 mils per application

POLISHING:

Dust and minor damage can be polished out after the stated dry time has been reached, or after a full bake at 140°F (60°C) metal temperature followed by a cool down of panel 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.

PLASTIC PARTS:

For use over flexible parts the addition of Autocryl Elast-O-Actif or LV Elast-O-Actif is necessary. The table shows the proper amount and how to mix the materials.

	Autoclear Vision II HS	Elast-O-Actif	Autoclear Vision II HS Hardener	Autoclear Vision II HS Activator	Total
1 panel	36.7 grams	5.5 grams	131.7 grams	1.2 gram	175.1 grams
2 panels	73.4 grams	11 grams	263.4 grams	2.4 grams	350.2 grams

NOTE: Always zero the scale prior to adding each component.

DECALS:

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

LETTERING:

Hand striping or lettering must be applied within 8 hours for good adhesion. After 8 hours, scuff with a gray scuffing pad.

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BLENDING OF CLEARCOAT:

Akzo Nobel Coatings/Sikkens strongly recommends the application of clear coat over the whole panel that is thoroughly prepared. Clear coating of entire panel is required for lifetime warranty.

There are, however, instances where this is not practical. Such as repairs on older vehicles where economics would dictate that a warranty is not required. In these instances, it may be acceptable to blend the clearcoat into a small area such as a rocker panel or sail panel, vertical areas only. This procedure is not warranted or OE approved.

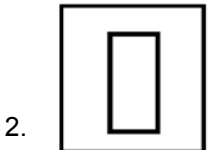


If blending of the clearcoat is inevitable (sail panels), apply Sikkens Blend-Prep on a damp sponge, and scuff until gloss is removed or alternately prepare (sail panels) by lightly scuffing with a 3M Clear Blend Prep Pad #07745 (gold). Thoroughly clean areas with a compliant Sikkens Surface Cleaner.



1x1
H. T. Gravity (1.1–1.3 mm)
HVLP Gravity (1.1–1.3 mm)
Max 10 psi (max 0.8 bar)

Hard line the last coat of clear into the prepared area (sail panel), keeping a sharp blend line. Do not fade out.



Reducer SRA 7.0
Ready to spray

Use pure Reducer SRA 7.0 to dissolve overspray edge. Refer to your local VOC regulations for “Specialty Coating” compliance.



2x1
H.T. Gravity 20–30 psi
HVLP 8 psi (air cap)

Spray 1 thin coat.
Flash for 15 seconds.
Apply a final thin coat.

AFTER TREATMENT:

After the repair area is completely dry, the fade out area may be polished with an ultra-fine polishing compound and waxed. (3M Perfect It 3000 Foam Polishing Pad Glaze). (Please see dry to polish time of the products used.)

NOTE:

Please refer to the following Technical Data Sheets for more information.

- Autobase Plus Solid, Metallic and Pearl Colors
- Autobase Plus Blending Additive
- Sikkens Reducer SRA 7.0

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**CLEANING OF
EQUIPMENT:**

Clean equipment with Sikkens Cleaning Solvent 790 or Sikkens Low VOC Cleaning Solvent

STOCK KEEPING:

COLOR: Clear

**CONTAINER
SIZE:**

Autoclear Vision II HS: 1 quart (0.95 lt)
Autoclear Vision II HS Hardener: 1 gallon (3.785 lt)
Autoclear Vision II HS Activator: 3.2 oz (100 ml)

SHELF LIFE:

— Autoclear Vision II HS:
Six months if stored unopened at room temperature.
— Autoclear Vision II HS Hardener:
Six months if stored unopened at room temperature.
— Autoclear Vision II HS Activator:
Six months if stored unopened at room temperature.

SAFETY ASPECTS:**READY TO
SPRAY VOC:**

— Autoclear Vision II HS, 1.9 lb/gal 228 g/liter
— Autoclear Vision II HS with Autocryl Elast-O-Actif, 1.97 lb/gal 236 g/liter.
— Autoclear Vision II HS with LV Elast-O-Actif, 1.86 lb/gal 223 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.

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Mixing Wall Chart

MIXING RATIO:

By weight



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NOTES: -Always zero the scale prior to adding each component.
-Approximate quantities for a compact car.

PLASTIC
PARTS:

	Autoclear Vision II HS	Elast-O-Actif or LV Elast-O-Actif	Autoclear Vision II HS Hardener	Autoclear Vision II HS Activator	Total
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