

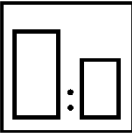



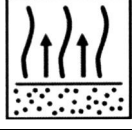
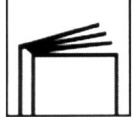

	North America	Technical Data Sheet
	Autowave™	Basecoat
		08/17/2017
FOR PROFESSIONAL USE ONLY		

Description

Autowave waterborne basecoat provides excellent coverage, metallic control and sprayability when used to duplicate OEM solid, metallic and pearl color effects. Autowave must be used in conjunction with a Sikkens clearcoat in order to provide protection from the environment.

	Safety Considerations Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.	
	Agitate by gently shaking Autowave toners prior to use.	
	100 10-50	Autowave Color Activator WB Stir color thoroughly prior to adding Activator WB
	Use Sikkens measuring stick #14 (blue)	
	HVLP or Compliant Spray-Gun Set-Up: 1.3-1.5 mm	Application Air Pressure: Consult spray gun manufacturers' specifications. HVLP – 10 psi at the air cap maximum.
	Application-Metallic Colors 3 x 1 Coats	Application – Solid Colors 2-3 x 1 coats
	Flash Between Coats at 70°F (21°C) Until completely matte	Flash Before Force Drying at 75°F (24°C) Not Recommended
	Re-Coatable With: <ul style="list-style-type: none"> • Sikkens Clearcoats 	

Read complete TDS for detailed product information.

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Suitable Substrates

SUITABLE SURFACES

- All existing OEM finishes
- Sikkens preparatory products

CANNOT BE APPLIED OVER

- Acid containing wash primers
- Sikkens Aerosol Spot Primers
- Sikkens Primer PO
- Airbag covers
- AutoPrep Pre-Treatment wipes

Products and Additives

Product Autowave MM (Mixing Machine) toners

Hardeners WB Hardener Item #553737 and Item #484386

WB Hardener is suitable for use in Autowave. The addition of 5% is sufficient to improve system robustness including stone chip resistance, adhesion and system hardness. WB Hardener is also recommended when multi-layer systems are applied and the recommended layer thickness is exceeded.

Activators Activator WB Item #391196

Activator WB, the Autowave waterborne basecoat activator is used for all repair sizes. Application conditions of 70°F (21°C) or higher with a relative humidity range between 10% to 90%.

Additives Autowave Additive LP Item #391192
 -Used to extend the pot life of Autowave metallic colors
 Autowave Underhood Additive Item #398179
 Flex additive is not needed in Autowave.

Basic Raw Materials

- Water based acrylic dispersion


Substrate Preparation





Dry sanding



- Initial sanding steps may be executed with a coarser sanding grit; for example, #P360 - #P400
- Final sanding step #P500 to #P600

Note: Respect a maximum 100 sanding grit step difference or less throughout the taken sanding steps.

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	<p>Wet sanding</p> <ul style="list-style-type: none"> ○ Initial sanding steps may be executed with a coarser sanding grit #P500 ○ Final sanding step #P600 to #P800 <p>Note: Respect a maximum 200 sanding grit step difference or less throughout the sanding steps.</p>
	<p>Surface Cleaning</p> <ul style="list-style-type: none"> · National Rule Markets use AutoPrep UltraPrep followed by M600 · Regulated Markets use AutoPrep UltraPrep only

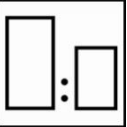
Product Agitation

	<p>Autowave MM toners must be vigorously shaken several times prior to first use for ideal consistency and pour viscosity. Either shake by hand or agitate for 45 seconds on a shaker.</p>
	<p>Autowave MM colors must be stirred thoroughly before and after reduction.</p>

Mixing Colors


	<p>Formulas</p> <ul style="list-style-type: none"> · A wide range formulas are available to match the most popular colors. These are available in MixitPro. <p>Hand Mixing Colors</p> <ul style="list-style-type: none"> · Colors can be custom mixed. · Solid colors can be made with solid MM toners and do not require additional MM666 binder. · When using pure Autowave Metallic MM888 toner, mix 4 parts MM666 with 1 part MM888 toner.
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Autowave Reduction

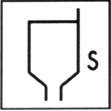
	<p>Add Activator WB to all Autowave colors prior to application using the following guidelines.</p> <ul style="list-style-type: none"> · Metallic Colors add 30-50 parts Activator WB · Pearl Colors add 20-40 parts Activator WB · Solid Colors add 10-30 parts Activator WB · Do not exceed 50 parts of Activator WB
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Points of Attention

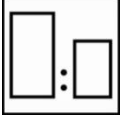
<p>Filtering: Use waterborne suitable 125 micron paint strainers</p> <p>Black Pre-Coat: When applying a black pre-coat for special effect colors, use deep black MM400 for the most vivid effects</p> <p>Solvents: Avoid contact between waterborne products and any conventional solvents.</p>

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Viscosity When Mixed

 DIN #4	20-30 seconds	Measured with a DIN #4 viscosity cup at 70°F (21°C).
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Autowave Mixing for Underhood

	Step 1: Mix Autowave color formula and stir Step 2: Add 10% Autowave Underhood Additive and mix Step 3: Add appropriate amount of Activator WB for metallic, pearl or solid colors and stir
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Pot-Life When Mixed


Autowave Mixed Colors	70°F (21°C)
Autowave solid and pearl mixed colors	3 months
Autowave metallic colors containing MM888 or MM338 toners	1 week
Autowave 888 or 338 metallic colors containing toner MM777	1 day
Autowave Mixed Colors containing WB Hardener	
70°F (21°C)	
Autowave solid and pearl mixed colors	1 ½ hours
Autowave pearl and solid colors containing 50% or more AW245	1 hour
Autowave metallic colors	30 minutes

Pot-Life Extension using Autowave LP Additive



	To obtain a 3 month pot life for all Autowave metallic colors, Autowave LP Additive can be used. Step 1: Thoroughly stir the MM toners Step 2: Add 5 percent by weight Autowave LP Additive and stir Step 3: Add Activator WB and stir Note: Do not use Autowave LP Additive in solid colors or colors containing Hardener WB or Underhood Additive.
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Spray Gun Set-Up

	Consult spray gun manufactures instructions for specific spray gun pressure specifications.		
	HVLP Gravity Compliant Gravity	1.4-1.5 mm 1.3-1.5 mm	Max 10 psi at cap Per manufacturer

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Application Process


	<p>Solid colors</p> <ul style="list-style-type: none"> ○ Apply 2 single coats or until opacity is achieved. ○ Flash off between coats by increasing airflow and or heat until the basecoat dries completely to a matt finish. If necessary allow the surface to cool. ○ Dry for a minimum of 15 minutes (max. 24 hours) at 75°F (24° C) prior to clearcoat application.
	<p>Metallic / pearl colors</p> <ul style="list-style-type: none"> ○ Apply 1 full coat, 100 % closed coat,. Next apply an intermediate coat, 80 % of the first coat ○ Flash off between coats by increasing airflow and or heat until the basecoat dries completely to a matt finish. If necessary allow the surface to cool. ○ When needed, apply an orientation coat . Increase the distance to approximately 12 to 14 inches and apply a light coat with no wet areas. ○ Dry for a minimum of 15 minutes (max. 24 hours) at 75°F (24° C) prior to clearcoat application. <ul style="list-style-type: none"> ○ Thorough drying after basecoat application is necessary.
	<p>Spot repairs</p> <ul style="list-style-type: none"> ○ When making spot repairs apply thin coats until opacity is achieved. Dry until matt between each coat before fading out beyond the coverage coats. ○ Metallic colors may need lower air pressure may be needed for color control. Extend each coat until coverage is obtained. Finally apply an orientation coats fading out beyond the coverage coats.

Film Thickness – Using Suitable Application

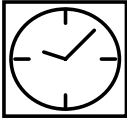
Autowave solid, metallic and pearl colors: 0.4-0.9 mils
The total dry layer thickness of Autowave should not exceed 1.2 mils


Drying / Curing

Drying times are stated a recommended application method, film thickness and object temperature.

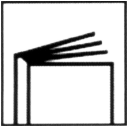
	<p>Humidity and airflow will influence the Autowave flash off and drying times. These times can be reduced to a minimum by using air accelerator systems with a distance of 3 feet from the object, thus increasing the airflow over the object.</p> <p>When heat is used for drying, allow object to cool down to application temperature before proceeding with color or clearcoat application</p>
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Recoat Time

	<p>Prior to clearcoat application:</p> <ul style="list-style-type: none"> ○ Minimum 15 minutes at 75°F (24° C). Thorough drying after basecoat application is necessary ○ Maximum 24 hours at 75°F (24° C). Should this maximum time be exceeded, abrade the surface and apply another coat.
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Recoating

	Autoclear Superior 250 2 Pack Fast and Slow Autoclear EnergySelect LV Fast and Slow Autoclear HS+ LV 2 Pack Fast and Slow Autoclear HS+ 2 Pack Fast and Slow Autoclear PC Standard and Production
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Sanding / De-Nibbing

	Allow Autowave to dry sufficiently, at least 20 minutes at 75°F (24°C). Then lightly dry sand the damaged area with #P600 to #P1000 dry sanding paper. Thoroughly remove sanding dust residue before continuing Autowave application.
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Masking

	Autowave colors can be taped (i.e. two toning) after 20 minutes flash-off at 75°F (24°C). <ul style="list-style-type: none"> ○ Increasing air movement especially with increased temperature improves the ability to apply masking on Autowave. ○ Let the object cool down to ambient temperature before masking.
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Cleaning of Equipment

	Clean and rinse the spray gun thoroughly after use with Autowave Gun Cleaner. Final rinse the spray gun with Activator WB prior to Autowave use. <ul style="list-style-type: none"> ○ Do not use any conventional thinner unless removing dried Autowave deposits. ○ Do not soak the spray gun for long periods either with Autowave Gun cleaner or Activator WB.
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Theoretical Coverage


	Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others. <ul style="list-style-type: none"> · 160 m2/liter ready to spray at 1 mil film thickness
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VOC / Regulatory Information

	The VOC content of this product in ready to use form is <3.5 lb. /gallon. (<420 gr/ltr)
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Product Storage

	Product shelf-life is determined when products are stored unopened at 70°F (21°C). Avoid too much temperature fluctuation. <ul style="list-style-type: none"> ○ For optimal performance, allow the ready to spray material to reach the application temperature before application ○ Maximum transport and storage temperatures between 36°F-95°F (2°C and 35°C). ○ Frozen Autowave toners causes gelling / lumps after which these toners can no longer be used. Please reference the Sikkens Shelf Life TDS for the shelf life limits for each Autowave component
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