







	North America	Technical Data Sheet
	Autoclear Superior 250 2 Pack™	
	Clearcoat 06.01.2016	
FOR PROFESSIONAL USE ONLY		

Description

Autoclear Superior 250 2 Pack is a two component version of Autoclear Superior 250 designed for use over Autowave or Autobase Plus basecoats. The system consists of two clearcoats and one dedicated hardener suitable for all sizes of repair and under all application conditions.

	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.	
 #1	2 1	Autoclear Superior 250 2 Pack (Fast or Slow) Autoclear Superior 250 2 Pack Hardener
	HVLP or Compliant Spray-Gun Set-Up: 1.3 – 1.4 mm	Application Air Pressure: Consult spray gun manufacturers' specifications. HVLP – 10 psi at the air cap maximum.
	Application Apply a medium, closed coat allowing for a 3-5 minute flash off time at 70°F (21°C). Followed by a full coat, allowing for 0-5 minutes flash off time before baking.	
	Flash Between Coats at 70°F (21°C) 3-5 minutes	Flash Before Force Drying at 70°F (21°C) 0-5 minutes
	Air Drying at 70°F (21°C) Dust Free 1 hour – Fast Clearcoat mixture 2 hours – Slow Clearcoat mixture	Dry to Handle 4 hours – Fast Clearcoat mixture 6 hours – Slow Clearcoat mixture
	Force Drying at 140°F (60°C) Dry to Handle 15 minutes – Fast Clearcoat mixture 30 minutes – Slow Clearcoat mixture	Infra-Red Flash 5 minutes Low Power 3 minutes Full Power 8 minutes

Read complete TDS for detailed product information.

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Suitable Substrates

- Existing finishes that are properly prepared
- Autowave
- Autobase Plus

Products and Additives

Product	Autoclear Superior 250 2 Pack Fast	Item #480807
	Autoclear Superior 250 2 Pack Slow	Item #480806
Hardeners	Autoclear Superior 250 2 Pack Hardener	Item #480808
	· General purpose hardener for all repair sizes	
Additives	Reducer SRA 4.5	Item #397904
	· A specialty solvent designed for dissolving the overspray and fade out edge created during spot repair and blending	
	LV250 Accelerator	Item #398353
	· LV250 Accelerator is added ½ ounce per ready to spray quart for decreased drytime	
LV Elast-O-Actif		Item #398218
	· Required when spraying plastic parts	

Basic Raw Materials

- Autoclear Superior 250 2 Pack clearcoats – Polyol resins
- Autoclear Superior 250 2 Pack hardener – Polyisocyanate resins
- Additives- Refer to the individual TDS for information.



North America

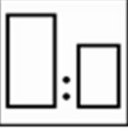
Technical Data Sheet

Autoclear Superior 250 2 Pack™

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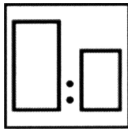
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Mixing


	2 1	Autoclear Superior 250 2 Pack (Fast or Slow) Autoclear Superior 250 2 Pack Hardener
#1		

Mixing – Flexible Parts

If the part to be painted can be deformed by hand, increase the flexibility of PRODUCT as follows.

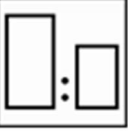
	100 10	Parts by volume Autoclear Superior 250 2 Pack (Fast or Slow) Parts by volume LV Elast-O-Actif
#14		

Stir the paint with LV Elast-O-Actif together THEN –

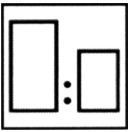
	2 1	Autoclear Superior 250 2 Pack Flexed mixture from above Autoclear Superior 250 2 Pack Hardener
#1		

Mixing on MPU– Flexible Parts

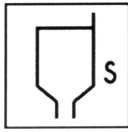
If the part to be painted can be deformed by hand, increase the flexibility of PRODUCT as follows.


	2 1	Autoclear Superior 250 2 Pack Flexed mixture from above Autoclear Superior 250 2 Pack Hardener
#1		

Stir the paint and add LV Elast-O-Actif

	100 5	Parts by volume Autoclear Superior 250 2 Pack ready to spray Parts by volume LV Elast-O-Actif
#14		

Viscosity When Mixed


	14-16 seconds	Measured with a DIN #4 viscosity cup at 70°F (21°C).
DIN #4		

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Pot-Life When Mixed

Product Mix	70°F (21°C)
Autoclear Superior 250 2 Pack Slow	45 minutes
Autoclear Superior 250 2 Pack Fast	20 minutes

Spray Gun Set-Up

	Consult spray gun manufactures instructions for specific spray gun pressure specifications.		
	Spray Gun	Fluid Tip	Application Pressure
	HVLP Gravity Fed	1.3-1.4	<10 psi at cap
	Compliant Gravity Fed	1.3-1.4	<10 psi at cap

Application

	<p>Apply a medium closed coat, allowing for a 3-5 minutes flash-off time at 70°F (20°C). Next, apply a full coat, allowing for a 0-5 minutes flash-off time at 70°F (20°C) before baking.</p> <ul style="list-style-type: none"> Flash-off between coats; in case of application to larger areas, flash off between coats is minimal. Recoatable with itself after full drying cycle, sanding becomes necessary after 24 hours <p>When sanding and heavy polishing is required, a third coat may be applied after the stated flash-off times at 70°F (20°C).</p>
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Film Thickness – Using Suitable Application

2 Coats will achieve a thickness of 1.7-2.2 mils (45 -60µm).


Drying / Curing Time

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




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2 Pack™**

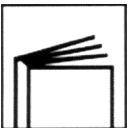
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		Autoclear Superior 250 2 Pack Fast	Autoclear Superior 250 2 Pack Slow
70°F (21°C)	Dust dry	1 hour	2 hours
	Dry to handle	4 hours	6 hours
122°F (50°C)	Dust dry	10 minutes	25 minutes
	Dry to handle	30 minutes	60 minutes
140°F (60°C)	Dust dry	10 minutes	15 minutes
	Dry to handle	15 minutes	30 minutes

Following the drying cycle at 140°F (60°C) object temperature, allow the Autoclear Superior 250 2 Pack to cool fully to ambient temperature to complete the through-hardening process.

	<p>Drying / Curing with short wave light IR equipment and a surface distance of 20 – 27 inches (50 – 70cm). The object temperature must not reach a temperature above 212°F (100°C).</p> <ul style="list-style-type: none"> • Allow 5 minute flash off before infra-red curing. • Cure 3 minutes on low power followed directly by a 8 minute full power cure.
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Recoating


	<p>Recoatable with itself after full drying cycle, sanding becomes necessary if there are defects or after 24 hours.</p>
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Decals

	<p>Decals can be applied after 48 hours.</p>
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Cleaning of Equipment


	<p>Clean equipment following local and federal regulations. In compliant localities, use Sikkens LV Cleaning Solvent or high quality solvent borne gun cleaner.</p>
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Theoretical Coverage

	<p>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.</p> <ul style="list-style-type: none"> • 806 sq ft / gallon or 19.81 m2/liter calculated at 100% TE per 1 mil of dry film thickness.
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Polishability

	<p>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.</p>
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VOC / Regulatory Information

	Autoclear Superior 250 2 Pack ready to spray: 2.1 lbs/gal (250 g/L)
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Product Storage

	Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).	
	Autoclear Superior 250 2 Pack Clearcoat	1 year
	Autoclear Superior 250 2 Pack Hardener	6 months

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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.

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