

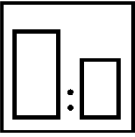



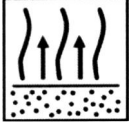
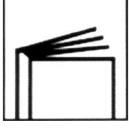

	North America	Technical Data Sheet
	Autobase Plus™	
	Basecoat 02/14/2017	
FOR PROFESSIONAL USE ONLY		

Description

Autobase Plus solvent borne basecoat provides excellent coverage, metallic control and sprayability when used to duplicate OEM solid, metallic and pearl color effects. Autobase Plus 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 shaking Autobase Plus toners prior to use.	
	100 50-80	Autobase Plus Color HP Reducer Stir color thoroughly prior to adding HP Reducer
	Use Sikkens measuring stick #1 (black)	
	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 (20°C) 3-5 minutes	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
- Airbag covers
- Thermoplastic acrylic laquers
- AutoPrep Pretreatment wipes

Products and Additives

Product Autobase Plus MM (Mixing Machine) toners

Hardeners

Autoclear PC Hardener Item #391299
Autoclear HS+ 2 Pack Hardener Item #481305

- Hardener may be added to extend clearcoat time of Autobase Plus Solid colors.
- 5% of Hardener can be added to Autobase Plus color prior to the addition of HP Reducer when spraying soft, foam spoilers.
- To meet National Rule VOC levels for 3 stage colors, 10% hardener must be added to the foundation color.

Activators

Sikkens High Performance Reducer Fast Item #391059
-Spot and panel repairs, temperature range 60°F – 75°F (16°C – 24°C)

Sikkens High Performance Reducer Medium Item #391062
-Spot and panel repairs and large areas temperature range 70°F – 85°F (20°C – 30°C)

Sikkens High Performance Reducer Slow Item #391064
-Larger areas and complete jobs temperature range 80°F – 95°F (27°C – 35°C)

Sikkens High Performance Reducer Extra Slow Item #391066
-Specially developed reducer which can be used for extremely hot temperatures above 95°F (35°C)

*Item numbers are provided for 1 gallon containers. Additional container sizes are available.

Basic Raw Materials

- Autobase Plus – Physically drying binders
- Sikkens High Performance Reducers – Special solvent blends
- Hardeners – Polyisocyanate resin

**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.

**Wet sanding**

- Initial sanding steps may be executed with a coarser sanding grit #P500
- Final sanding step #P600 to #P800

Note: Respect a maximum 200 sanding grit step difference or less throughout the sanding steps.

**Surface Cleaning**

- AutoPrep UltraPrep
- M600

Product Agitation

Autobase Plus MM toners must be stirred on a mixing machine for 15 minutes prior to use or agitated for 10 minutes a shaker.



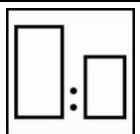
Autobase Plus MM colors must be stirred thoroughly before and after reduction.

Mixing Colors**Formulas**

- A wide range formulas are available to match the most popular colors. These are available in MixitPro.


Hand Mixing Colors

- Colors can be custom mixed.
- When making a color without using a color formula, it is essential that you incorporate the toner Autobase Plus Connector Q 065 into the paint mix. To do this, mix 3 parts Autobase Plus handmade color to 1 part toner Q 065. Use the Sikkens Measuring Stick #9 (Grey). Then stir thoroughly, reduce and apply as normal. Failure to do this will cause poor product performance.


Autobase Plus Reduction

Add HP Reducer to all Autobase Plus colors prior to application using the following guidelines.

- 50-80 parts reducer by volume

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Viscosity When Mixed

	DIN Cup #4 70°F (20°C)	100:50 ratio – 16-17 seconds 100:80 ratio – 13-14 seconds



Pot-Life When Mixed


Autobase Plus Mixed Colors	70°F (20°C)
Autobase Plus solid, metallic and pearl mixed colors	6 months
Autobase Plus 3 stage pearl colors	24 hours
Autobase Plus Mixed Colors containing Hardener	4 hours

Spray Gun Set-Up

	Consult spray gun manufactures instructions for specific spray gun pressure specifications.		
	HVLP Gravity	1.3-1.5 mm	Max 10 psi at cap
Compliant Gravity	1.2-1.4 mm	Per manufacturer	

Application Process

	Solid colors <ul style="list-style-type: none"> ○ Apply 2 single coats or until opacity is achieved. ○ Flash off 3-5 minutes between coats
	Metallic / pearl colors <ol style="list-style-type: none"> 1. Autobase Plus Solid Foundation Color: Spray 2 single coats, allowing approximately 5-7 minutes flash-off between each coat. Over primed areas and areas where extra coverage is required, apply first a single thin coat. Allow the foundation coat to dry for 15–20 minutes. 2. Autobase Plus Mid Coat: Spray three to four thin coats, allowing 3–5 minutes flash-off between coats at 70°F (20°C). Do not lower the air pressure for pearl coats. 3. Autobase Plus Transparent Solid Color Mid Coat: Spray three to four even, wet coats, allowing 5-10 minutes flash-off between coats at 70°F (20°C). <p>Note: To meet National Rule VOC levels for three-stage colors. The addition of 10% Sikkens PC Hardener or Sikkens Autoclear HS+ 2 Pack Hardener must be added to the “foundation color.” Use the # 14 (Blue) measuring stick for this, stir this mixture and continue to add High Performance Reducer at a ratio of 100:50 or 100:80.</p>
	Spot repairs <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.


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Film Thickness – Using Suitable Application

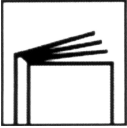
Autobase Plus solid, metallic and pearl colors: 0.3-0.4 mils

Drying / Curing

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

	<p>Allow Autobase Plus to dry for 15 to 20 minutes at 70°F (20°C) before applying the clearcoat. The maximum time Autobase Plus may be left before clear:</p> <ul style="list-style-type: none"> –Autobase Plus Metallic Color: 2 days –Autobase Plus Solid Color: 5 hours <p>The recoat time of Autobase Plus solid colors can be extended to 2 days with the addition of hardener.</p>
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Recoating

	<p>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</p>
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Two Tone Application

	<p>Autobase Plus Solid, Metallic and Pearl colors can be taped off with fine line masking tape after 20 minutes flash-off at 70°F (20°C) and a second color of Autobase Plus can then be applied.</p>
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Second Repair


	<p>If during the application of Autobase Plus Solid or Metallic color, some damage occurs such as dust impregnation or perspiration spots, allow the Autobase Plus to flash off for 20 minutes at 70°F (20°C). Lightly sand the damaged area with #P600 to #P800 grit paper wet. As there is no clearcoat to protect the base coat at this stage, care must be taken to clean up all sanding residue.</p>
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Cleaning of Equipment

	<p>Clean and rinse the spray gun thoroughly after use.</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"> • 143 m2/liter ready to spray at 1 mil dry Filmbuild and 100% transfer efficiency
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VOC / Regulatory Information

	<p>Ready to spray VOC: Autobase Plus 100:50 with High Performance Reducers: 6.28 lb/gal. 754 g/liter Autobase Plus 100:80 with High Performance Reducers: 6.44 lb/gal. 773 g/liter</p> <p>Autobase Plus with 10% hardener, then 100:50 with High Performance Reducers: 5.89 lb/gal. 707 g/liter 100:80 with High Performance Reducers: 6.12 lb/gal. 735 g/liter</p> <p>Notice: Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.</p>
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Product Storage

	<p>Product shelf-life is determined when products are stored unopened at 70°F (20° C). Please reference the Sikkens Shelf Life TDS for the shelf life limits for each Autobase Plus component</p>
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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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