

# Autoclear Superior 250 2 Pack

Autoclear Superior 250 2 Pack is a two-component high solids clear coat designed for use over Autowave or Autobase Plus basecoats. The system consists of two clearcoats with one dedicated hardener and has built in flex chemistry. Autoclear Superior 250 2 Pack is suitable for all sizes of repair and under most application conditions.

**Safety Considerations**

- Use suitable personal protection.
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator.

**Suitable Surfaces**

- Sikkens Basecoat
- Existing Clearcoat
- Wait until the basecoat's indicated flash time before clear application.
- Thoroughly abraded with P1000 dry or a gray scuff pad.



STICK #1

**Mix**

2

1

**By Volume**

Parts Superior 250 2 Pack Fast or Slow Clear

Part Superior 250 2 Pack Hardener

**Spray-Gun Set-Up**

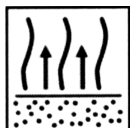
- 1.3 – 1.4mm HVLP Gravity
- 1.3 – 1.4mm Compliant

**Application Air Pressure**

- HVLP – 10 psi (<0.7 bar) at cap maximum.
- Consult manufacturer specifications.

**Application**

- Apply 2 single coats.

**Flash Between Coats at 70°F (21°C)**

- 0 – 5 minutes.

**Flash at 70°F (21°C) Before Force Drying**

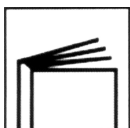
- 0 – 5 minutes.

**Drying Superior 250 2 Pack Fast**

- Dust free in 1 hour at 70°F (21°C).
- Dry to handle in 4 hours at 70°F (21°C).
- Dry to handle in 15 minutes 140°F (60°C).

**Drying Superior 250 2 Pack Slow**

- Dust free in 2 hours at 70°F (21°C).
- Dry to handle in 6 hours at 70°F (21°C).
- Dry to handle in 30 minutes 140°F (60°C).

**Recoat Information**

- May be recoated with Sikkens Autoclear Superior 250 2 Pack at any stage for up to 24 hours without sanding.

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information.

## Description

Autoclear Superior 250 2 Pack is a two-component high solids clear coat designed for use over Autowave or Autobase Plus basecoats. The system consists of two clearcoats with one dedicated hardener and has built in flex chemistry. Autoclear Superior 250 2 Pack is suitable for all sizes of repair and under most application conditions.

## Suitable Substrates



- Existing finishes that have been thoroughly sanded and degreased.
- Sikkens Autowave after a 15-minute flash at 70°F (21°C).
- Sikkens Autobase Plus after a 15-minute flash at 70°F (21°C).
- Sikkens Autoclear Superior 250 2 Pack.

## 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

### Additives

- Sikkens LV250 Accelerator – Item # 389353
- Sikkens High Temperature Additive – Item # 589142
- Sikkens SRA 4.5 Reducer – Item # 397904
- Sikkens SRA LV Aerosol – Item # 562816
- Sikkens SRA Aerosol – Item # 390990 (National rule areas only)
- Sikkens SRA 7.0 Reducer – Item # 385063 (National rule areas only)
- Sikkens LV Elast-O-Actif – Item # 398218

○ SDS and TDS for products available online at – <http://my.anaac.net/>

## Basic Raw Materials



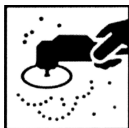
- Autoclear Superior 250 2 Pack Clear – Polyol resins
- Autoclear Superior 250 2 Pack Hardener – Polyisocyanate resins
- Additives – Refer to specific additive product TDS.

## Existing Finish Substrate Preparation



### Pre-Cleaning

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with M600 Surface Cleaner, AutoPrep Ultra-Prep (VOC compliant) or Anti-Static surface cleaners.



### Sanding Preparation

- Abrade existing clearcoat with #P1000 dry and a 3M Interface pad or use a 3M Gray Scotch-Brite with Sikkens BlendPrep and water.



### Surface Cleaning – Prior to Paint Application

- Clean with M600 Surface Cleaner, Autoprep UltraPrep (VOC compliant) or Antistatic surface cleaners.

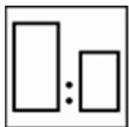
## Mixing Formulas and Products



### Formulas

- Easy mixing products, including hardening, reduction and the addition of additives can be done through Color Manager or MIXIT.

## Mixing – By Volume

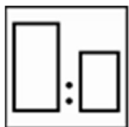


BY VOLUME  
STICK # 1

Mix  
100  
50

### Standard Mix

Parts Superior 250 2 Pack Fast or Slow  
Parts Superior 250 2 Pack Hardener



BY VOLUME  
STICK # 1

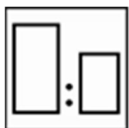
Mix  
100  
50

+ 10%  
(maximum)

### High Temp / High Humidity Mix

Parts Superior 250 2 Pack Slow  
Parts Superior 250 2 Pack Hardener  
High Temperature Additive

- High Temp/High Humidity mix is not recommended for use at temperatures below 85°F (≈29°C).



STICK #9

Mix  
100  
5-10

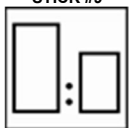
### Flexed for Soft Parts

Parts Superior 250 2 Pack Fast or Slow  
Parts LV Elast-O-Actif

### STIR, THEN MIX

Parts Superior 250 2 Pack + LV Elast-O-Actif  
Parts Superior 250 2 Pack Hardener

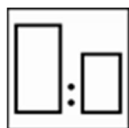
- Superior 250 2-Pack has chemistry that does not require flex additive for flexible parts. For severe service applications or soft foam parts, flexing is advised.



STICK #1

100  
50

## Mixing – By Manual Proportioning Unit (MPU Machine)

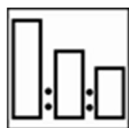


BY MPU

**Mix**  
2  
1

### Standard Mix

Parts Superior 250 2 Pack Fast or Slow Clear  
Part Superior 250 2 Pack Hardener



STICK #9

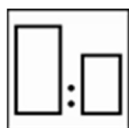
**Mix**  
2  
1  
+ 5%

### For Soft Parts

Parts Superior 250 2 Pack Fast or Slow Clear  
Part Superior 250 2 Pack Hardener  
LV Elast-O-Activ

- Superior 250 2-Pack has chemistry that does not require flex additive for flexible parts. For severe service applications or soft foam parts, flexing is advised.

## Mixing - Accelerated



**Mix**  
100  
50  
+ 15ml  
(maximum)

Parts Superior 250 2 Pack Fast or Slow Clear  
Part Superior 250 2 Pack Hardener  
LV250 Accelerator per ready to spray quart

## Viscosity – Ready to Spray



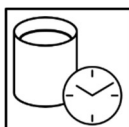
DIN #4

- Superior 250 2 Pack Fast or Slow Clear

**At 70°F (21°C)**

– 14 – 16 sec.

## Pot-Life When Mixed



### Product Mix

- Superior 250 2 Pack Fast Clear
- Superior 250 2 Pack Slow Clear

**At 70°F (21°C)**

– 20 minutes

– 45 minutes

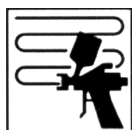
## Spray Gun Set-Up



Consult spray gun manufactures instructions for specific spray gun pressure specifications.

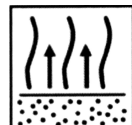
Spray Gun	Fluid Tip	Application Pressure
HVLP Gravity Fed	1.3 – 1.4mm	<10 psi (<0.7 bar) at cap
Compliant Gravity Fed	1.3 – 1.4mm	psi per spray gun manufacturer

## Application



- Option #1 – Apply 2 flowing coats with a flash of 5 minutes between coats.
- Option #2 – Apply a thin closed coat followed back-to-back with a full flowing coat.
  - When excessive sanding and polishing will be required, apply a third coat after flashing off.

## Flash Drying



### Flash Between Coats at 70°F (21°C)

- 0-5 minutes.

### Flash at 70°F (21°C) Before Force Drying

- 0-5 minutes.

- Flash time will be dependent on ambient temperature, applied paint wetness/thickness, and available air-flow.

## Drying / Curing Time



Product/Mix	2 Pack Fast		2 Pack Slow		High Temp Mix	
	Dust Free	Dry	Dust Free	Dry	Dust Free	Dry
<b>70°F (21°C) Metal Temp</b>	1 hour	4 hours	2 hours	6 hours	3 hours	8 hours
<b>122°F (50°C) Metal Temp</b>	10 minutes	30 minutes	25 minutes	1 hour	35 minutes	1 hour
<b>140°F (60°C) Metal Temp</b>	10 minutes	15 minutes	15 minutes	30 minutes	25 minutes	40 minutes



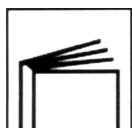
- Drying times are with recommended application method, film thickness and object temperature.
- Cure can be shortened with mixes that include up to 15ml LV250 Accelerator per ready to spray quart.
- Decals can be applied 48 hours (70°F (21°C)) after full cure.
- Hand painted striping or lettering must be applied within 48 hours for good adhesion. After 48 hours, scuff with a grey scuffing pad before application.

## Drying / Curing – Infrared



- Flash dry the clear for 5 minutes before infrared curing.
- Position the IR lamp approximately 20-27 inches (50-70cm) from the surface.
- Cure at ½ power 3 minutes followed by curing at full power for 8 minutes.

## Recoat Information



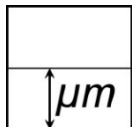
- May be recoated with Sikkens Autoclear Superior 250 2 Pack at any stage for up to 24 hours without sanding.

## Cleaning of Equipment



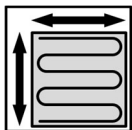
- Clean equipment and dispose of waste following local and federal regulations. Use Sikkens Cleaning Solvent to clean equipment. In compliant localities, use Sikkens LV Cleaning Solvent.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

## Film Thickness – Using Suitable Application



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

## Theoretical Coverage



- With the recommended application, the theoretical material usage is ±806 feet<sup>2</sup>/gallon (±19.8m<sup>2</sup>/liter) at a 1 mil thickness (24.5μm).
- Actual coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique, and other application variables.

## Polishing



- 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.

## VOC / Regulatory Information



### Product

- Autoclear Superior 250 2-Pack (Ready to Spray)

### VOC Pounds per Gallon

≤2.10

### VOC Grams per Liter

≤250

- Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on 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.

## Product Storage



- Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures. Optimum storage temperature is approximately 70°F (21°C). Avoid too much temperature fluctuation. The maximum temperature range for storage is 40°F - 95°F (5°C – 35°C).
- Autoclear Superior 250 2-Pack Clear – 2 Years
- Autoclear Superior 250 2-Pack Hardener – 1 Year



North America

## Autoclear Superior 250 2 Pack

Technical Data Sheet

Clearcoat

06/02/2021

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FOR PROFESSIONAL USE WITH SUITABLE HSE EQUIPMENT

**AkzoNobel Inc., North America**

**Address: 1845 Maxwell Street – Troy, MI USA**

**Telephone: 800.618.1010**

### FOR PROFESSIONAL USE WITH SUITABLE HSE EQUIPMENT

**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 Safety 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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