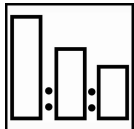


# Autoclear® Xcel

FOR PROFESSIONAL USE ONLY

## Description

Sikkens Autoclear® Xcel is a two component clearcoat system which provides excellent flow, gloss and a smooth finish. It is easy to apply and suitable for all types of repairs, in most application conditions.



100 Autoclear® Xcel  
50 P Hardeners  
10 Plus Reducers



Use Sikkens measuring stick  
No. 3 Purple

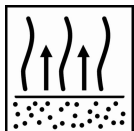


Spray gun set-up:  
1.2-1.5 mm

Application pressure:  
2-4 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap

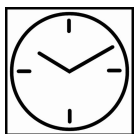


2 x 1 coat  
First apply a medium closed coat, next apply a full coat after indicated flash off time



Between coats  
5-10 minutes at 20°C  
Reducer selection according temperature

Before curing  
10-15 minutes at 20°C  
Flash-off time depending on oven type



Product selection	20°C	60°C
P25 Hardener	4.5 hours	30 minutes
P35 Hardener	7 hours	35 minutes



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

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## Description

Sikkens Autoclear® Xcel is a two component clearcoat system which provides excellent flow, gloss and a smooth finish. It is easy to apply and suitable for all types of repairs, in most application conditions.

## Product and additives

**Clearcoat** Autoclear® Xcel

**Hardener** P25 Hardener; spot and panel repairs at 20°C-30°C  
P35 Hardener; larger areas and overall refinishing at 20°C-40°C

**Reducer** Plus Reducer Fast; spot and panel repairs, temperature range: 15°C-25°C.  
Plus Reducer Medium; spot and panel repairs and large areas, temperature range: 20°C-30°C.  
Plus Reducer Slow; larger areas and complete paint jobs, temperature range: 25°C-35°C.  
Plus Reducer Extra Slow; to use in extremely hot temperatures, temperature range: above 35°C.

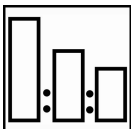
## Basic raw materials

Autoclear® Xcel: Acrylic and polyester resins  
P Hardener: Poly-isocyanate resins

## Suitable substrates

Autobase Plus; after a minimum flash off time of 15 minutes at 20°C

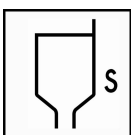
## Mixing



**100** Autoclear® Xcel  
**50** P Hardeners  
**5-10** Plus Reducers

Use measuring stick No. 3 Purple

## Viscosity



15-17 seconds – DIN Cup 4 at 20°C.

## Spray gun set-up / application pressure



**Spray gun**  
Gravity feed

**Fluid tip – set-up**  
1.2-1.5 mm

**Application pressure**  
2-4 bar at the spray gun air inlet  
HVLP max 0.7 bar at the air cap

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## Application process & blending



Apply a medium closed coat, allowing for a 5-10 minutes flash-off time at 20°C.

Next, apply a full coat, allowing for a 5-10 minutes flash-off time at 20°C before baking.

- 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
- *When sanding and heavy polishing is required, a third coat may be applied after the stated flash-off times at 20°C.*

## Mixing ratios related to mixing with Autoclear Mat (Gloss level indication)

Mixture		Part A	Part B	Part C	Gloss
Autoclear Xcel	Autoclear mat	Mixture (vol)	P Hardener	Plus Reducers	60° angle
60	40	100	50	30	84 - 85
80	20	100	50	30	94-95

## Pot-life

P25 Hardener  
P35 Hardener

3 hours at 20°C  
>3 hours at 20°C

## Film thickness

By using the recommended application: 45-50 µm (2 coats)  
Minimum film thickness for longevity of clearcoat 50 µm

## Drying times

Allow for a minimum of 5 minutes flash-off time at 20°C before moving the car into a pre-heated drying oven (booth) at 60°C. All drying times relate to standard application and object temperature.  
*Consider the time required for the spraybooth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object.*



		P25 Hardener	P35 Hardener
20°C	Dust dry	20 minutes	40 minutes
	Dry to handle*	4.5 hours	7 hours
60°C	Dust dry	5 minutes	8 minutes
	Dry to handle*	30 minutes	35 minutes

# Autoclear® Xcel

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Dry to handle after approximately 10 minutes.  
Allow 5 minutes flash off prior to infra red curing  
The panel must not reach a temperature above 100°C while curing.

**Polishability**

Dust and minor imperfections can be polished out after the stated air-dry times have been reached, or after a full bake at 60°C object temperature, followed by a cool down of the object to ambient temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

*Ready to polish approximately 1 hour after cool down to ambient temperature. 3M: standard Sikkens polishing procedure*

**Material Usage**

By using the recommended application, the theoretical material usage is  $\pm 5.27$  m<sup>2</sup>/liter RTS mixture.

*The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.*

**Cleaning of equipment**

Sikkens Solvents or solvent borne guncleaners

**VOC**

The VOC content of this product in ready to use form is 559 g/liter RTS mixture.

**Product storage**

Product shelf-life is determined when products are stored unopened at 20°C.

Autoclear ® Xcel	3 years
P hardeners	1 year
Plus reducers	4 years

*Avoid extreme temperature fluctuation.*

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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

# Autoclear<sup>®</sup> Xcel

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