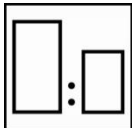


Autobase[®] Plus

FOR PROFESSIONAL USE ONLY

Description

Autobase Plus 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. Autobase Plus is the superior choice to achieve optimal color match.



100 Autobase Plus
 50 Plus Reducer



Use Sikkens measuring stick
1 Black



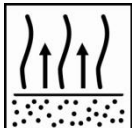
Spray gun set-up:
 1.2-1.5 mm

Application pressure:
 1.7-2.2 bar at the air inlet
 HVLP max 0.6-0.7 bar at the air cap



Application metallic colors:
 Full coat – intermediate coat – drop coat

Application solid colors:
 2 x 1 coat



Between coats
 3-5 minutes at 20°C

Before clearcoat application
 15 minutes at 20°C



Clearcoat application
 See clearcoat T.D.S.



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

Autobase Plus 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. Autobase Plus is the superior choice to achieve optimal color match.

Suitable substrates

All Existing OEM finishes, with the exception of thermoplastic acrylic finishes.
 All current Sikkens preparatory products.
With the exception of direct application on acid containing Washprimers

Products and additives

Autobase Plus MM (MM) colors

Plus Reducers

Plus Reducer Extra Fast; to use in extremely cold temperatures, temperature range: 10°C-15°C
 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.

Additives

Blending Agent: Additive specially developed for easier application of spot repairs and fade-outs
 Hardener P25: extend recoat time, improve stone chip resistance and adhesion properties

Basic raw materials

Autobase Plus: Physical drying binders
 Autobase Plus Blending Agent: Physical drying binders

Surface preparation



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Surface cleaning; remove any surface contamination prior to the application of Autobase Plus using an appropriate surface cleaner.

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Mixing



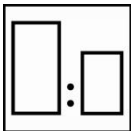
Mixing Machine

Stir MM colors on mixing machine every 4 hours for 15 minutes



Stir after mixing

Autobase Plus MM colors must be stirred thoroughly directly after mixing the color formula



Standard system

100 Autobase Plus
50 Plus Reducers

Easier blend of metallic colors

100 Autobase Plus
80 Plus Reducers

Use measuring stick No. 1 Black

For application details see TDS; S8.01.04 (Technical Bulletin)

NOTE:

Special enhancements to the Autobase Plus system.

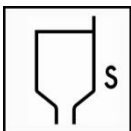
To improve: elasticity, recoat properties, stone chip resistance, adhesion properties and total system robustness it is possible to add Hardener P25 to Autobase Plus. The Hardener is added in the ratio of 10% by volume of the base (color) mix prior to adding Plus Reducers. After adding hardener mix thoroughly and mix with Reducer as mentioned above.

Color mixing by hand:

If an Autobase Plus color is made without the use of a formula it is essential to incorporate MM Q065 into the hand mixed formula; mix 3 parts of the color with 1 part of the MM Q065.

Elast-O-Actif should **not** be added into the Autobase Plus color.

Viscosity



16–17 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
1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

Pot-life

6 Months when stored in a closed can at 20°C.

4 Hours at 20°C in a closed can, when mixed with hardener.

Stir the ready to spray mixture thoroughly before use.

Autobase[®] Plus

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Application process

Solid colors

Apply 2 single coats or until opacity is achieved. *Allow for a 3-5 minutes flash-off time at 20°C between coats until the basecoat dries completely to a matt finish.

**Allow for a minimum of 15 minutes final flash-off time at 20°C before clearcoat application.*

Metallic colors

Apply 1 full wet coat allowing for an 3-5 minutes flash-off time at 20°C until the basecoat dries completely to a matt /semi gloss finish. Next apply an intermediate coat until achieving opacity and allow again a 3-5 minutes flash-off time at 20°C until the basecoat dries completely to a matt /semi gloss finish.

When needed, apply a drop coat (metallic orientation coat) by reducing the pressure to 1-1 ½ bar at the gun inlet and apply the drop coat with full trigger, increase the distance to approximately 30 cm.

**Allow for a minimum of 15 minutes final flash-off time at 20°C before clearcoat application.*

Spot repairs:

When making spot repairs, use lower application pressure and apply thin coats until reaching opacity. Allow for a 3-5 minutes flash-off time at 20°C between coats. Next, fade out, by extending beyond the edges, using similar application pressure. In case of metallic colors apply a drop coat (metallic orientation coat) when needed by increasing the spray gun distance.

In the case of high hiding colors, the color transparency can be increased by adding Blending Additive or MM070 RTS to the mixed color.

**Allow for a minimum of 15 minutes final flash-off time at 20°C before clearcoat application.*

Blending Agent:

If required, Autobase Plus Blending Agent can be used ready to spray as a pre-coat (wet-bed) to reduce the halo effect. Apply 1 full wet coat to the maximum fade-out area and allow for the pre-coat to flash off until fully dried before proceeding with the color application.

Apply the Autobase Plus color within the Blending Additive area.

Film thickness

By using the recommended application;

Autobase Plus Solid Colors 20-40 µm

Autobase Plus Metallic and Pearl Colors 15-30 µm

For proper color match and long term performance of the coating, it is imperative that the layer of Autobase Plus achieve full hiding. When 2 coats do not achieve full hiding, additional coats are necessary. To apply additional coats, allow the already applied coats to flash as usual and apply an addition coat. Repeat as necessary allowing proper flash between coats until full hiding is achieved.

Masking

Autobase Plus solid, metallic and pearl colors can be taped after 20 minutes flash-off at 20°C.

Temperature increase in combination with air movement increase the ability for masking.

Let the object cool down to ambient temperature before masking after which a second color of Autobase Plus can then be applied

Denibbing

Allow Autobase Plus to flash off sufficiently, at least 20 minutes at 20°C.

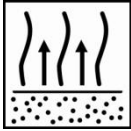
Then lightly sand the damaged area with P500 free-cut dry or P1000grit wet sanding paper sanding paper.

Thoroughly remove sanding residue before continuing Autobase Plus application.

Autobase[®] Plus

FOR PROFESSIONAL USE ONLY**Recoatable with**

All current Sikkens clearcoats
With the exception of;
○ Autoclear LV Superior

Recoat time

Autobase Plus Solid: 5 hours

Autobase Plus Metallic and Pearl: 48 hours (2 days)

To extend the re-coat time of **solid** colors up to 48 hours (2 days), mix Autobase Plus as follows:
Stir the Autobase Plus color thoroughly before adding 10% Hardener P25.

Stir this mixture thoroughly before adding Plus Reducer, then stir again thoroughly

The Autobase Plus color and the hardener must be mixed thoroughly prior to the addition of the Reducer to gain the required system property.

Material usage

By using the recommended application the theoretical material usage is $\pm 10 \text{ m}^2/\text{l}$ RTS mixture.

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure, method 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 744 g/lit RTS with 50% Plus Reducer and 803g/lit Plus Reducer mixture

When 10% hardener is added prior to the Reducer 755 - 767 g/liter RTS mixture

Product storage

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

Avoid extreme temperature fluctuation.

- *Product shelf life data see TDS S9.01.02*

Autobase[®] Plus

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Tel: 0396441711

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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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