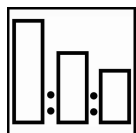


# Autoclear WB 2.0

## FOR PROFESSIONAL USE ONLY

### Description

Two-pack state of the art waterborne clearcoat with very large application window that combines a high performance with environmental compliance.



100 Autoclear WB 2.0  
50 Autoclear WB 2.0 Hardener  
30 Autoclear WB Reducer  
30-40 Activator WB



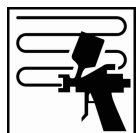
Use Sikkens measuring stick

**10** Green

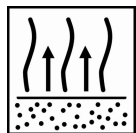


Spray gun set-up:  
1.2-1.4 mm

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

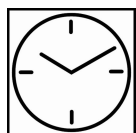


2 x 1 coat  
First apply a medium closed coat, next apply a full coat



Between coats  
3-10 minutes at 20°C

Before curing  
0-5 minutes at 20°C



|  | 20°C     | 60°C       |
|--|----------|------------|
|  | 5½ 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

# Autoclear WB 2.0

FOR PROFESSIONAL USE ONLY

## Description

Two-pack state of the art waterborne clearcoat with very large application window that combines a high performance with environmental compliance.

## Product and additives

Autoclear WB 2.0

**Hardener** Autoclear WB 2.0 Hardener

**Reducers** Autoclear WB Reducer

**Additives** Activator WB

*No plasticizer (Elast-O-Activ) required for application on plastic car parts.*

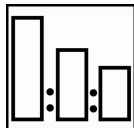
## Basic raw materials

Autoclear WB 2.0: Polyacrylate resins  
Autoclear WB 2.0 Hardener: Poly-isocyanate resins

## Suitable substrates

Autowave 2.0  
Sanded original finishes

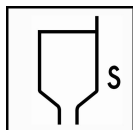
## Mixing



**100** Autoclear WB 2.0  
**50** Autoclear WB 2.0 Hardener  
**30** Autoclear WB Reducer  
**30-40** Activator WB

*Use measuring stick No. 10 Green.  
Mix the components in a plastic can, mix thoroughly after adding each of the components.*

## Viscosity



15-17 seconds – DIN Cup 4 at 20°C.

## Spray gun set-up / application pressure



**Spray gun**  
Gravity feed

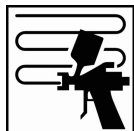
**Fluid tip – set-up**  
1.2-1.4 mm

**Application pressure**  
1.7-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

# Autoclear WB 2.0

FOR PROFESSIONAL USE ONLY

## Application process & blending



Apply a medium closed coat, allowing for a 3-10 minutes flash-off and apply a full coat  
Flash off 3-10 minutes at 20°C before baking.

Recoat with itself within 24 hours  
For blending, see TDS S8.01.01.

## Pot-life

1 hour at 20°C

## Film thickness

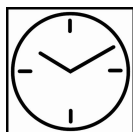
By using the recommended application: 50-60 µm

## 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.*

*\*Do not use any type of air acceleration or drying equipment during the drying cycle of the Autoclear WB 2.0*



### Autoclear WB 2.0

|      |                |                   |
|------|----------------|-------------------|
| 20°C | Dust dry       | 1 hour 40 minutes |
|      | Dry to handle* | 5½ hours          |
| 50°C | Dust dry       | 30 minutes        |
|      | Dry to handle* | 1 hour            |
| 60°C | Dust dry       | 20 minutes        |
|      | Dry to handle* | 35 minutes        |

### \*Dry to handle

Following the drying cycle at 60°C object temperature, allow the Autoclear WB 2.0 to cool down fully to ambient temperature 20°C inside the spraybooth before placing the object in an area with a minimum temperature of 15°C for optimum the through hardening.

*In case of lower area temperatures, i.e. winter times, extend the drying time by 15-20 minutes at 60°C*



Allow 5 minutes flash off prior to infra red curing

The panel must not reach a temperature above 100°C while curing.

For additional infra red drying information; see TDS S9.01.01

# Autoclear WB 2.0

**FOR PROFESSIONAL USE ONLY**

## Polishability



Ready to be polished after stated air-drying times have been reached, or after a full bake at 60°C object temperature.

## Theoretical coverage

Ready for use mixture at 1 µm dry film thickness

**m<sup>2</sup>/liter**  
± 307

*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 EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/liter VOC.  
The VOC content of this product in ready to use form is max. 420 g/liter.

## Product storage

Product shelf-life is determined when products are stored unopened at 20°C.  
Avoid extreme temperature fluctuation.  
o Product shelf life data see TDS S9.01.02

## Akzo Nobel Coatings LTD

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## FOR PROFESSIONAL USE ONLY

**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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### Head Office

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