

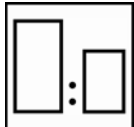
Autobase[®] Classic

FOR PROFESSIONAL USE ONLY

Description

Autobase Classic provides excellent coverage, metallic control and sprayability when used to duplicate OEM solid, metallic and pearl colour effects. Autobase Classic must be used in conjunction with a Sikkens clearcoat in order to provide protection from the environment. Autobase Classic is the superior choice to achieve optimal colour match.

This product is not for sale to Vehicle Refinishers in the EU, who need to comply to the Directive 2004/42/EC



100 Autobase Classic

50 Plus Reducer



Use Sikkens measuring stick

No. 1 Black



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

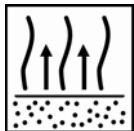


Application metallic colours:

Full coat – intermediate coat – drop coat

Application solid colours:

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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Suitable substrates

All Existing OEM finishes.
 All current Sikkens preparatory products, with the exception of direct application onto acid containing Washprimers

Products and additives

Autobase Classic MM (MM) colours

Plus Reducers

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

Autobase Classic: 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 Classic using an appropriate surface cleaner.



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Mixing



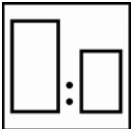
Mixing Machine

Stir MM colours on mixing machine every 4 hours for 15 minutes.



Stir after mixing

Stir the Autobase Classic MM colours thoroughly directly after mixing the colour formula.

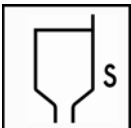


100 Autobase Classic
50 Plus Reducer

Some metallic colours show a higher sensitivity for cloudiness/mottling. Alternate Autobase Classic application in combination with adding additional 30 parts Plus Reducer will give a more optimum metallic orientation, sprayability and flow.

Elast-O-Actif should **not** be added into the Autobase Classic colour.

Viscosity



14-16 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

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.



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Application process

Solid colours

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 colours

Apply 1 full wet coat allowing for a 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 colours apply a drop coat (metallic orientation coat) when needed by increasing the spray gun distance.

In the case of high hiding colours, the colour transparency can be increased by adding MM Z070 RTS to the mixed colour.

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

Film thickness

By using the recommended application;	
Autobase Classic Solid Colours	20-30 microns
Autobase Classic Metallic and Pearl Colours	15-25 microns

Masking

Autobase Classic solid, metallic and pearl colours can be taped after ±20 minutes flash-off at 20°C.

Temperature increase will increase the ability for masking. Let the object cool down to ambient temperature before masking after which a second colour of Autobase Classic can then be applied

Denibbing

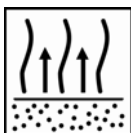
Allow Autobase Classic to flash-off sufficiently, at least 20 minutes at 20°C. Then lightly sand the damaged area with P500 free-cut dry or P1000 grit wet sanding paper. Thoroughly remove sanding residue before continuing Autobase Classic application.



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FOR PROFESSIONAL USE ONLY**Recoatable with**

All current Sikkens clearcoats
With the exception of Autoclear LV Superior.

Recoat time

Autobase Classic Solid: 5 hours

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

To extend the re-coat time of **solid** colours up to 48 hours (2 days), mix Autobase Classic as follows: Stir the Autobase Classic colour thoroughly before adding maximum 10% P25 Hardener. Stir this mixture thoroughly before adding Plus Reducer, then stir again thoroughly.

The Autobase Classic colour 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 ± 10 m²/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.

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.

AkzoNobel Car Refinish bv.**Address: Rijksweg 31, PO Box 3, 2170 BA Sassenheim****Tel: +31(0)71308-6944****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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