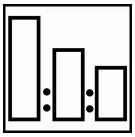
Autosurfacer HB

FOR PROFESSIONAL USE ONLY

Description

Autosurfacer HB is a fast drying two-pack high build primer-surfacer for car refinishing systems. Developed for panel and spot repairs where extreme high film build is required. Autosurfacer HB is only available as a sanding surfacer.

Sanding application



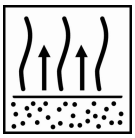
5 Autosurfacer HB
1 Hardener P25 / P35
1 Plus Reducers

Use Sikkens measuring stick
23 Violet

Spray gun set-up:
1.8-2.0 mm

Application pressure:
1.7-2.2 bar at the air inlet.

1-3 x 1 coat



Between coats:
5-10 minutes at 20°C

Before curing:
5-10 minutes at 20°C

3 hours at 20°C

30 minutes at 60°C

Final sanding step: P500
See TDS S8.06.02

Recoatable with all Sikkens topcoats

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

Existing finishes	Glass Reinforced Polyester laminates
Steel	Polyester bodyfillers
OEM electrocoat	Sikkens Polysurfacer
Sikkens Washprimers	Primer Surfacer EP II

Autosurfacer HB will provide adequate adhesion if applied directly to steel. However, it is advise for systems which should meet the highest standards to apply Autosurfacer HB over Sikkens Washprimer.
Allow for a minimum of 15 minutes flash-off time at 20°C after Washprimer application.

Autosurfacer HB can be applied on plastics parts which have been preceded by;
1K All Plastic Primer or 2K Plastic Primer.

Product and additives

Autosurfacer HB

Hardeners	Hardener P25:	Spot or panel repairs at 20°C-25°C
	Hardener P35:	Larger panels at 20°C-40°C
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	Temperature range: above 35°C.
Additives	Autocryl Structure Paste (Fine);	See TDS 6.27,
	Elast-O-Actif;	See S8.06.03c.

Basic raw materials

Autosurfacer HB: Acrylic resins
P Hardeners: Polyisocyanate resin

Surface preparation

Remove contamination using an appropriate cleaner.

Sanding; final dry sanding steps; P180 - P320

For detailed surface preparation see TDS S8.06.02

Remove contamination using an appropriate cleaner.

Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

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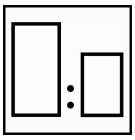
Stir before use

Autosurfacer HB must be stirred thoroughly before use.

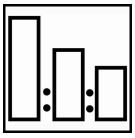
Tinting



If necessary, Autosurfacer HB can be tinted with up to 10 parts by volume with;
Autocryl Plus LV MM toners.

After tinting Autosurfacer HB must be stirred thoroughly before adding either Hardener P25 or Hardener P35.

Mixing



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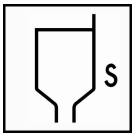
1	Hardener P25 / P35
1	Plus Reducers

Flexible parts

Once elasticized to the required level, Autosurfacer HB can be applied on plastic parts. All virgin plastic parts should be pre-coated with a suitable plastic primer
See TDS.S8.06.3c.

Viscosity



30-40 seconds DIN cup 4 at 20°C

Spray gun set-up / application pressure

Spray gun	**Fluid tip – set-up**	**Application pressure**
Gravity feed	1.8-2.0 mm	1.7-2.2 bar at the spray gun air inlet

For maximum build use large fluid tip and lower the application pressure.

Pot-life

Hardener P25;	1 hour at 20°C.
Hardener P35;	2 hours at 20°C.

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Application

Spot application:
Apply one coat over the total sanded area. Flash off until completely matt and apply the 2nd and 3rd coat within each preceding coat. Flash off until completely matt after each coat

Panel application:
Apply 2-3 coats and flash off until completely matt after each coat

Film thickness

By using the recommended application: 3 coats;240-300 µm.

Drying time sanding

3 hours at 20°C. 2 hours at 40°C. 30 minutes at 60°C.

Indicated drying times relate to the use of P25 Hardener

Allow 5 minutes flash off prior to infra red curing
The panel temperature should not exceed 100°C.
For additional information; see TDS S9.01.01

Final sanding

Final sanding step P500

For detailed surface preparation see TDS S8.06.02

Final sanding step P1000

For detailed surface preparation see TDS S8.06.02

Remove contamination using an appropriate cleaner.

Recoatable with

All Sikkens topcoats

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Theoretical Coverage

By using the recommended application, the theoretical material usage is 4 m²/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

2004/42/IIb(c)(540)520
The EU limit value for this product (product category: IIB. c) in ready to use form is max. 540 g/liter of VOC.
The VOC content of this product in ready to use form is max. 520 g/liter.

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*

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