

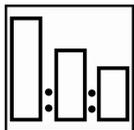
# Autosurfacers HB

FOR PROFESSIONAL USE ONLY

## Description

Autosurfacers 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. Autosurfacers HB is only available as a sanding surfacer.

## Sanding application



5 Autosurfacers HB  
1 Hardener P25 / P35  
1 Plus Reducers



Use Sikkens measuring stick  
Nr. 23 Violet  
*Beware of different ratios on measuring stick.*

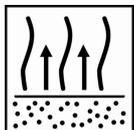


Spray gun set-up:  
1.8-2.0 mm

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



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 S8.06.01



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, we 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; Plastoflex Primer or 2K Plastic Primer.*

## Product and additives

Autosurfacer HB

**Hardeners** Hardener P25; for application at temperatures around 20°C-25°C for spot or panel repairs  
Hardener P35; to use at higher temperatures or in case of application on larger panels.

**Thinner** Plus Reducer

**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.

**Additives** Autocryl Structure Paste (Fine); additive to create different surface textures; TDS 6.27, 6.29.  
Elast-O-Actif; to elasticize Autosurfacer HB making it suitable for plastic parts. See S8.06.03c.

## Basic raw materials

Autosurfacer HB: Acrylic resins  
P Hardeners: Polyisocyanate resin

## Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using an appropriate surface cleaner.  
*Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.*



Sanding; final dry sanding steps; P180 – P280  
Rigid OEM electro coated parts; final dry sanding steps; P180 – P280  
Sikkens polyester bodyfillers and Polysurfacer; finished with; P180 - P280  
Featheredge sanding for spot repair, finish outer area with P400  
*For detailed surface preparation see TDS S8.06.02*



# Autosurfacer HB

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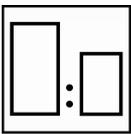
Surface cleaning; remove any surface contamination prior to Autosurfacer HB application using appropriate surface cleaner. *Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

## Stir before use



Autosurfacer HB must be stirred thoroughly before use.

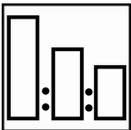
## Tinting



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

*Autosurfacer HB mixed with any of the topcoat MM colours must be stirred thoroughly before adding either Hardener P25 or Hardener P35.*

## Mixing



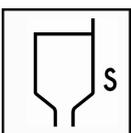
**5** Autosurfacer HB  
**1** Hardener P25 / P35  
**1** Plus Reducers

*Use Hardener P25 at application temperatures around 20°C-25°C for spot or panel repairs. At higher temperatures or in case of application on larger panels use P35 Hardener.*

## Flexible parts

Once elasticized to the required level, Autosurfacer HB can be applied on plastic parts. All flexible plastic parts should be pre-coated with a suitable plastic primer (in the case of virgin plastic), or OEM finish. See TDS.S8.06.3c.

## Viscosity



30-40 seconds DIN cup 4 at 20°C.

## Spray gun set-up / application pressure



**Spray gun**  
Gravity feed

**Fluid tip – set-up**  
1.8-2.0 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

*For maximum build use widest fluid tip and lower application pressure.*

## Pot-life

Hardener P25; 1 hour at 20°C.

Hardener P35; 2 hours at 20°C.

# Autosurfacer HB

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## Application



Apply one coat over the total sanded area. Next apply the 2<sup>nd</sup> and 3<sup>rd</sup> coat within each preceding coat. Where a full panel application is required apply 2-3 coats over the total panel dependent on the required film build.

*Allow each coat to flash-off naturally until the surface is completely matt; this also supports to achieve higher film build. Do not force-dry with air support.*

*Flash-off between the coats is dependent on ambient temperature, applied layer thickness and airflow. For maximum build use widest fluid tip and lower application pressure.*

## 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.

Drying times relate to recommended application (3 coats) and object temperature.  
*Indicated drying times relate to the use of P25 Hardener*



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*

## Final sanding



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 the topcoat using an appropriate surface cleaner.

## Recoatable with

All Sikkens topcoats



# Autosurfacer HB

**FOR PROFESSIONAL USE ONLY****Material usage**

By using the recommended application, the theoretical material usage is  $\pm 4$  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****2004/42/IIIB(c)(540)518**

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. 518 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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**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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