Autowave 2.0

Product Data

Application

Flash process

Cleaning equipment

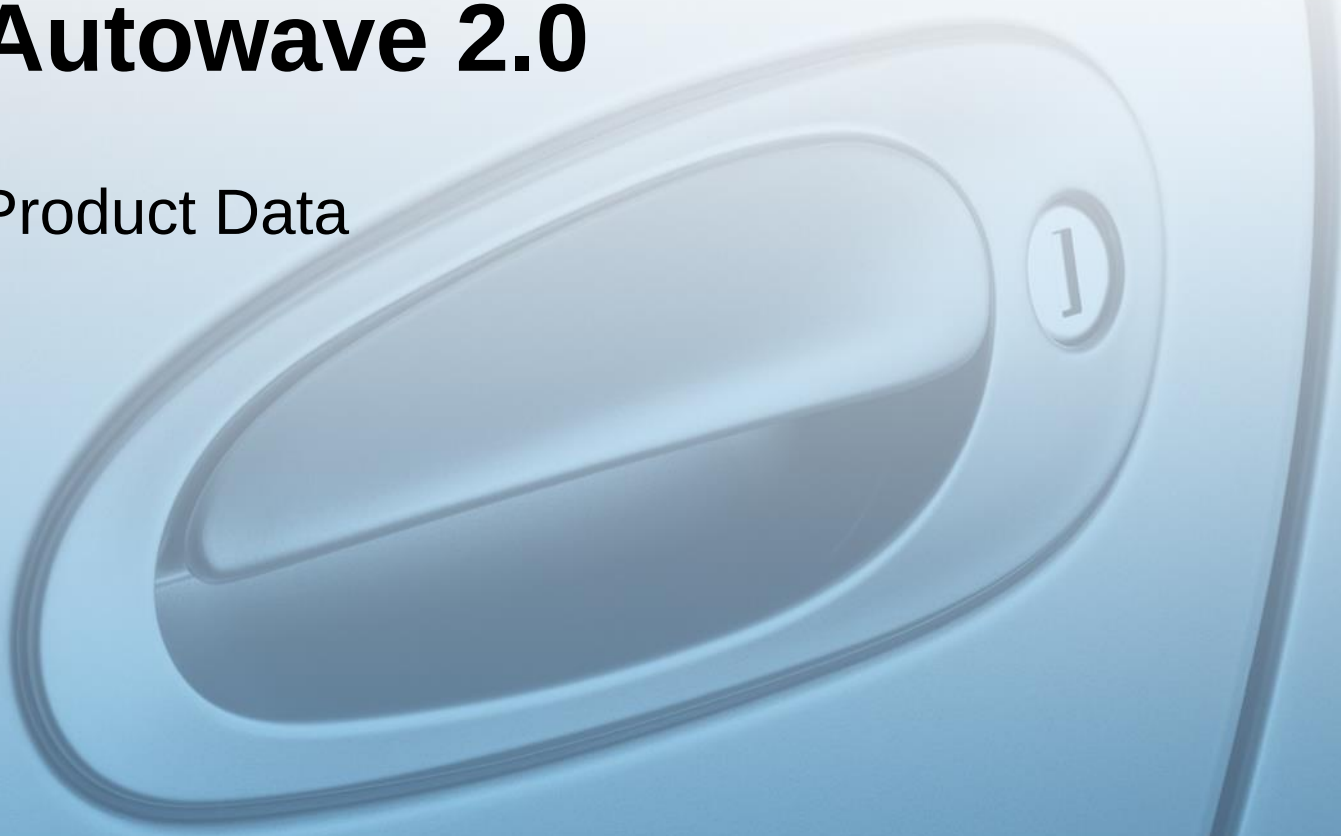
Final Preparation

2 Coat System

3 Coat System

Autowave 2.0

Product Data



Suitable substrates

Autowave can be applied on:

- All existing OEM finishes
- All current Sikkens preparatory products.
  - With the exception of direct application on acid containing washprimers.

Autowave MM toners

Autowave MM toners

- Solids
- Non stirring metallic toners
- Xirralic MM toners
- Pearls
- SEC colors

Binder - MM600

Flip tone controllers

MM700-MM101

Point of attention - mixing

Gently shake the can before mixing

Easier to pour

Stir thoroughly

Directly after mixing

Use preferably plastic cans

Point of attention - mixing

Metallic MM800 toners

- Stir thoroughly before first use

Once installed

- Handle like any other MM toner

Activator WB

Activator WB

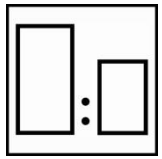
- For optimum application viscosity

Mixing ratio is mainly determined by:

- Relative humidity
- Temperature

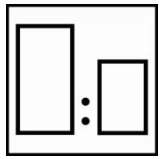
Variable mixing ratios

Solid color



100:10

- Standard mixing ratio
- Temp. 20°C-25°C

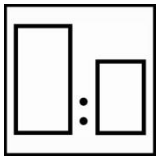


100:20

- Easier color blend
- RH around 20% or < 20%
- Temp. >25°C

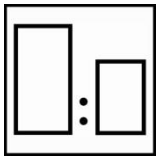
Variable mixing ratios

Metallic color



100 : 10-20

- Standard mixing ratio
- Temp. 20°C-25°C



100 : 30

- Optimum metallic control
- Easier colour blending
- Temp. 20°C-25°C

Variable mixing ratio

Metallic color; Change of ambient conditions

100 : 40

Temperatures >35°C

Relative humidity ± 20%

100 : 50

Temperatures >40°C

Relative humidity <10%

Waterborne paint strainers

Suitable waterborne paint strainers

- Minimum strainer size 125µm

Autowave Guncleaner

Waterbased cleaning agent

- For cleaning the Autowave spray-gun

- Consists of water and co-solvents (alcohol)
- Can be re-used after coagulation process

Autowave Separator

Coagulation process, add 1-1½% to contaminated

- Autowave Guncleaner
- Water

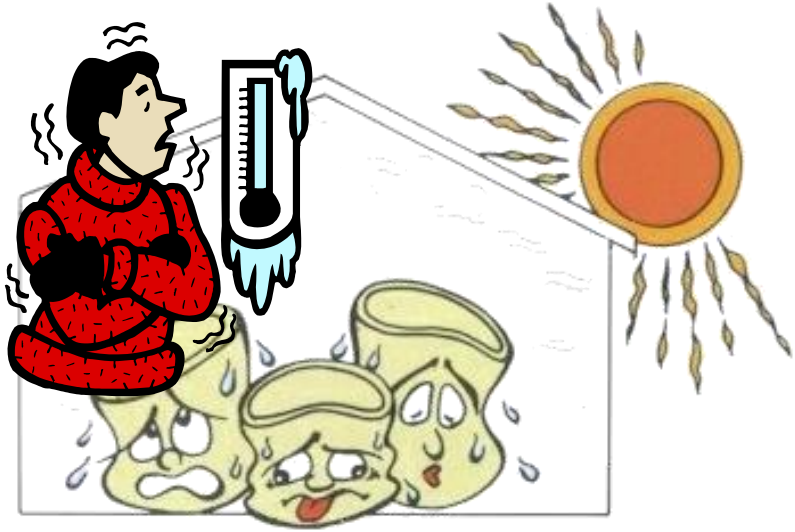
Separates contaminated Autowave Guncleaner or water from the Autowave paint residue

When pouring Autowave Guncleaner

Storage and shelf-life

Store at application temperature

- Storage temperature 3°C-35°C
- Avoid extreme temperature fluctuation
- Products shelf-life TDS S9.02.01



Autowave 2.0

Application

Preparation

P500 dry sanding

Abrade the rest and adjoining panels with P1000 (3M 260L)

- Removing all surface texture of the panel's

Abrade the edges by using a copper scuffing pad

Clean thoroughly

- Combined waterborne/solvent borne surface cleaners

Application conditions

Thorough surface cleaning

- Waterborne paint is more sensitive for surface contamination

Clean application equipment

- Flush thoroughly prior to use with Guncleaner/Activator WB

Recommended application temperature 20°C-25ºC

- For optimum application conditions
- Slight decrease humidity, improves water evaporation

Spray gun

Spray gun set up:

- 1.2 - 1.5

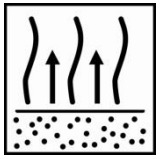
Application pressure:

- 1.7-2.2 bar at the spray-gun air inlet
- HVLP max. 0.7-1 bar

Autowave 2.0 solid application

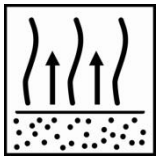
Apply two full coats

- Until hiding is achieved



Between coats

- Until the surface is completely matt

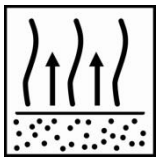


Minimum 15 minutes at 25ºC

- Before clearcoat application
- Recoat within maximum 24 hours at 25ºC

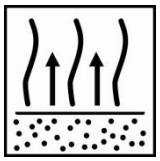
Autowave 2.0 metallic application

Apply one full coat



Until the surface is completely matt

Apply a intermediate coat; until hiding is achieved

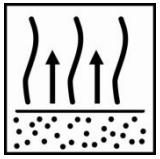


Until the surface is completely matt

Autowave 2.0 metallic application

Apply a drop coat

- For an even metallic orientation/appearance



Minimum 15 minutes at 25°C

- Before clearcoat application
- Recoat within maximum 24 hours at 25°C

Colour fade-out

Pre-coat application AW 666

Easier colour blend

Less risk for halo

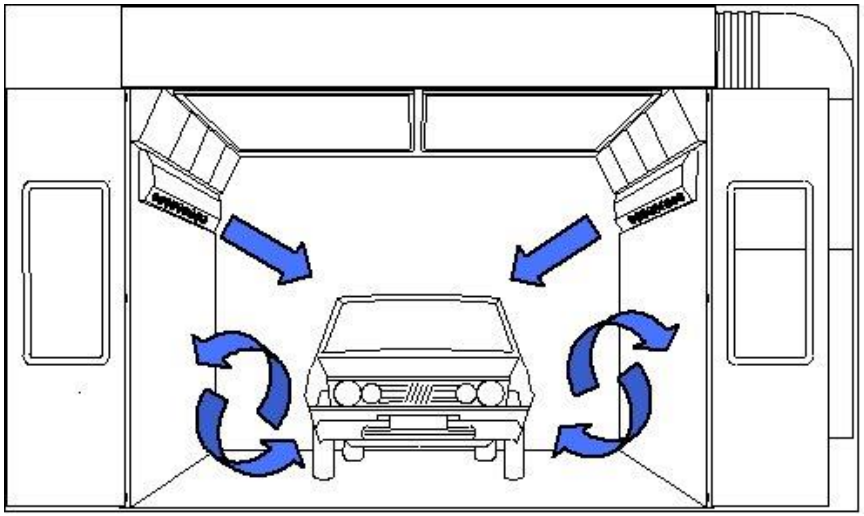
Autowave 2.0

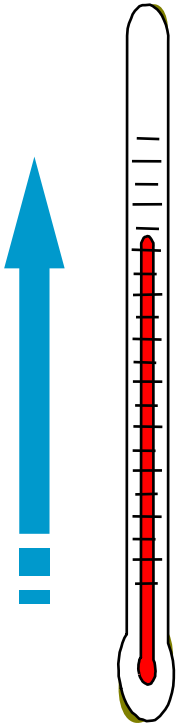
Flash-off process

Autowave® flash-off process

Flash-off times are reduced by

- Temperature increase
- Air turbulence inside the spraybooth





Temperature increase

Heat up for approximately 10 minutes at 60°C

- Object temperature will rise

Cool down to ambient temperature

- Approximately 5 minutes

Continue Autowave® application after cool down

Air movement

WindJet

Air Jets

- Hand held or on stand

AirWave system

Open fans system

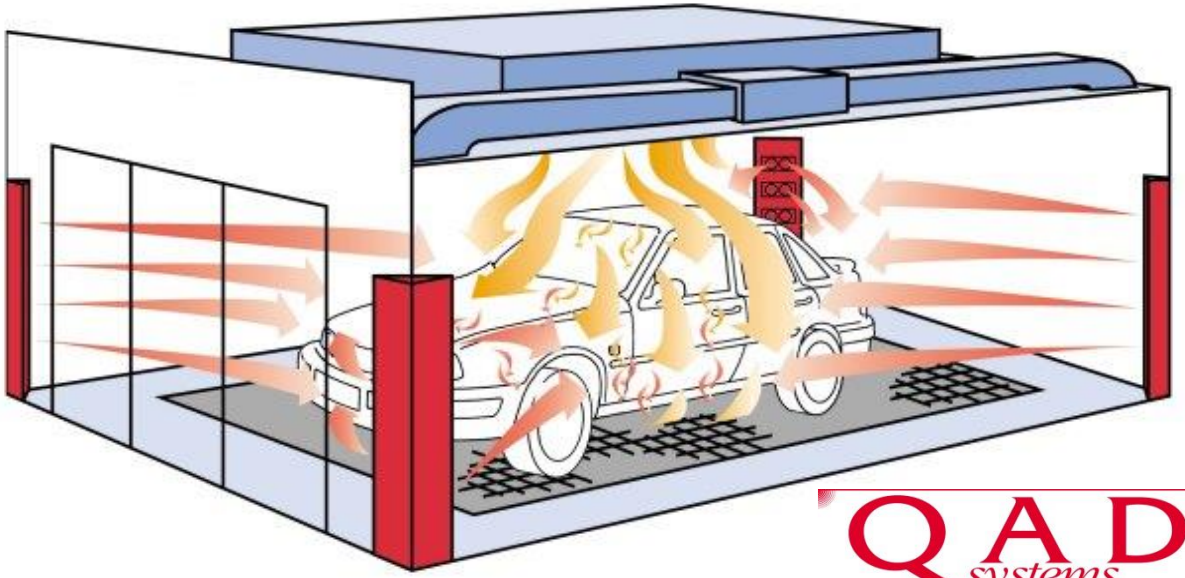
Fitted on ceiling, walls, or on rail system

- Automatic air temperature raise up till ± 40°C

Qad system

Integrated at spraybooth corners

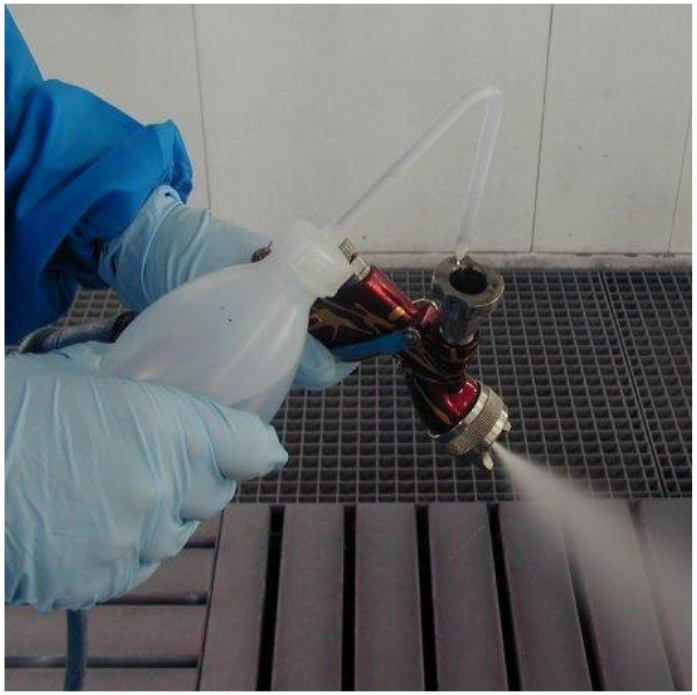
- Automatic air temperature raise up till ± 40°C



Autowave 2.0

Cleaning Equipment

RPS / PPS use



Spray gun cleaning

Solvent borne

Water borne

Spray gun cleaning

Filled with Autowave® Guncleaner

- Autowave® Guncleaner contains co-solvents
- Dissolves waterborne paint residue

Uses Autowave Separator for standard coagulation process

After filtering; re-use Autowave® Guncleaner

Spray gun cleaning with water

Connected to regular tap water supply
- Can be connected to boiler system
- Warm water for optimum cleaning!

Uses Autowave Separator for standard coagulation process

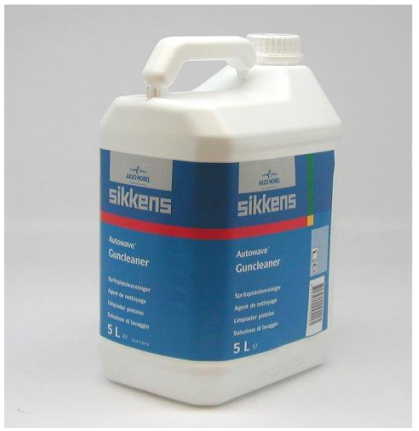
Once coagulated the water can be drained

<u>Check with local legislation!</u>

Guncleaner and Separator

Autowave® Guncleaner

- Contains co-solvents
- Can be regenerated / re-used



Autowave® Separator

- Separates paint from Guncleaner
- Add 1-1½% into dirty Guncleaner

Wear respirator

Coagulation process (Guncleaner)

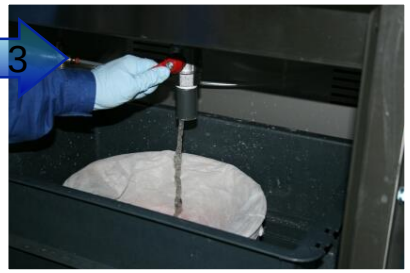
Step 1

Add Autowave Separator to contaminated Guncleaner

Step 2

Stir Autowave Separator & contaminated Guncleaner

Step 3



Drain the coagulated Guncleaner through the filter

Step 4

Re-use the cleaned Autowave Guncleaner

Step 5

Solid waste in to chemical bin

Step 6

Replace the filter

Coagulation process (water)

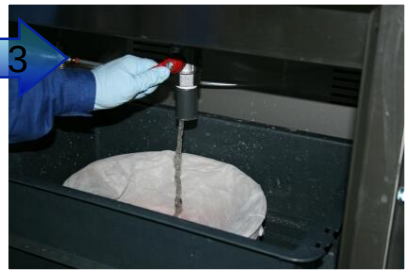
Step 1

Add Autowave Separator

Step 2

Stir Autowave Separator & contaminated water

Step 3



Run the coagulated water through the filter

Step 4

Release the water from the container

Step 5

Solid waste in to chemical bin

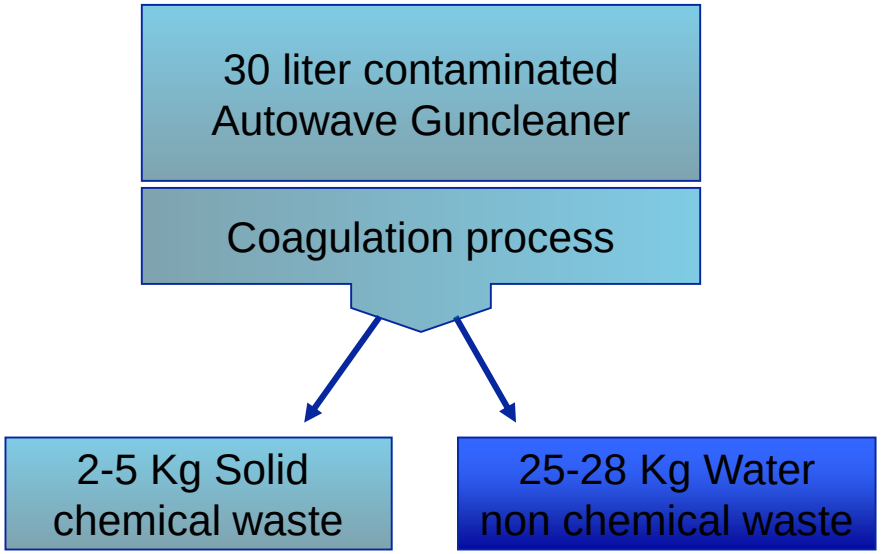
Step 6

Replace the filter

Waterborne coagulation

Up to 90% waste reduction

- After coagulation process
- 10% solid paint residue
- 90% water or regenerated Autowave Guncleaner



Autowave 2.0

Final preparation

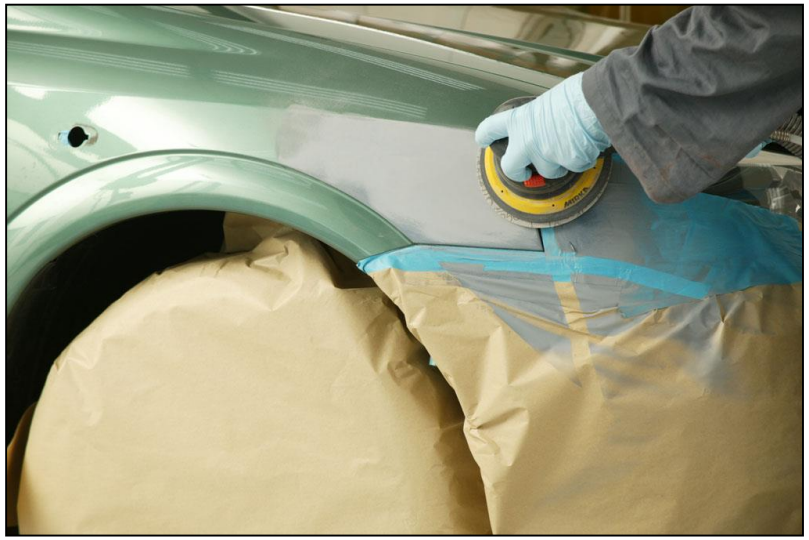
Final sanding

Advised dry sanding steps

- P400
- P500

Advised wet sanding steps

- P800
- P1000



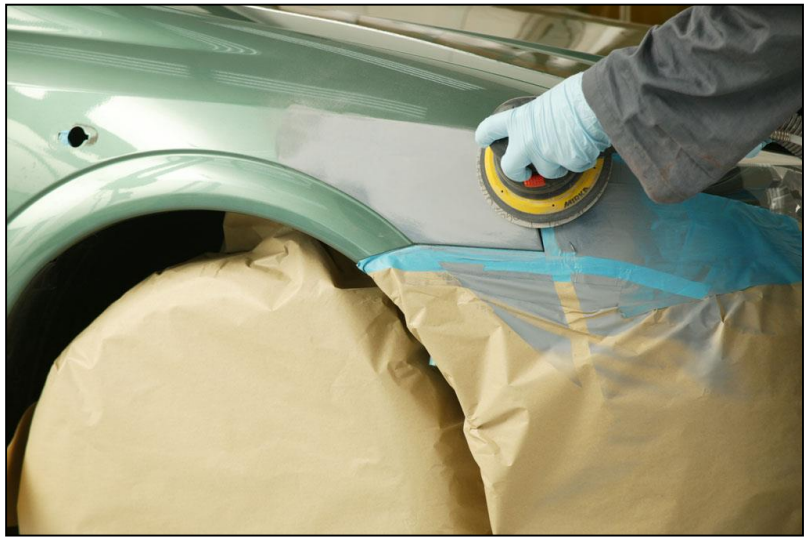
Panel preparation

Panel sanding, i.e. P1000 260L

- Removing surface texture
- Using a soft back pad

Scuffing pad, i.e. Scotch Brite

- Water
- Blend Prep



Masking

Mask tide to the object

- Loosely paper or plastic can generate dust

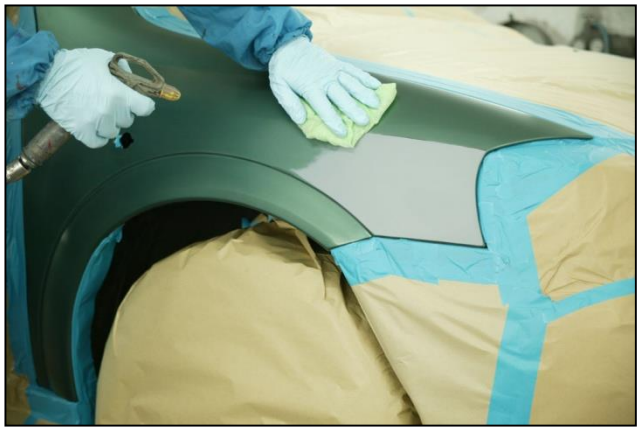
Final surface cleaning

Use high quality absorbent cloths

- One wet cloth
- Wipe with one dry cloth

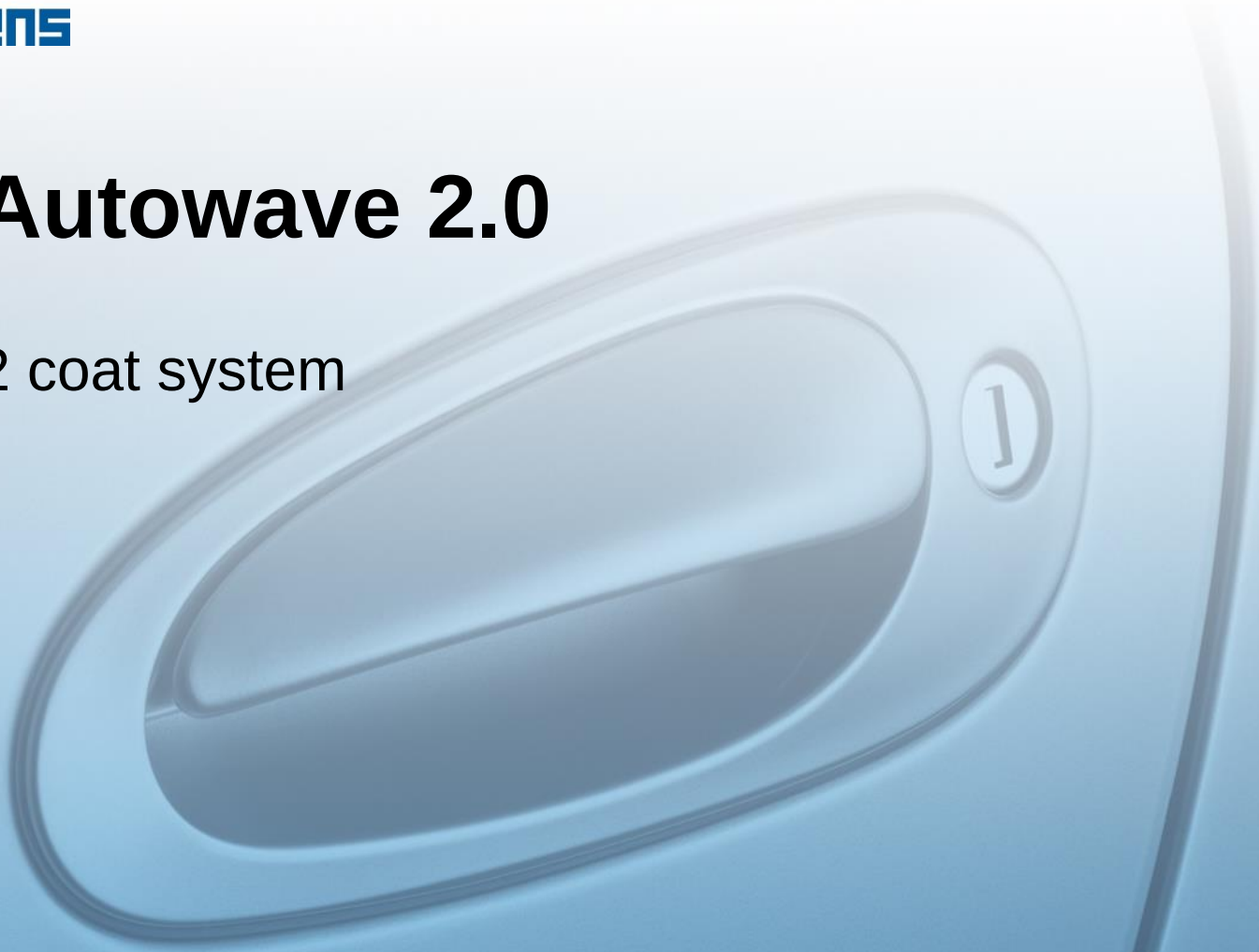
Wipe dry before evaporation

Dust prevention

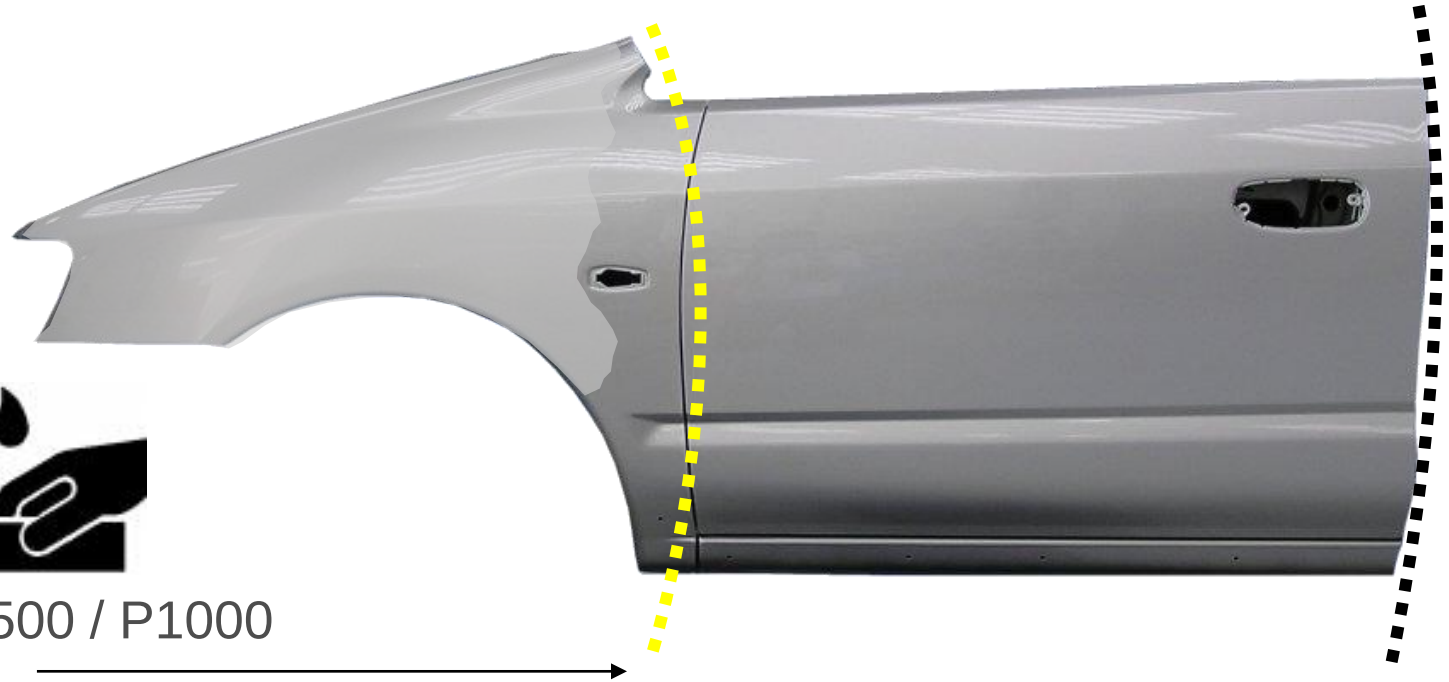


Autowave 2.0

2 coat system



Panel-repair



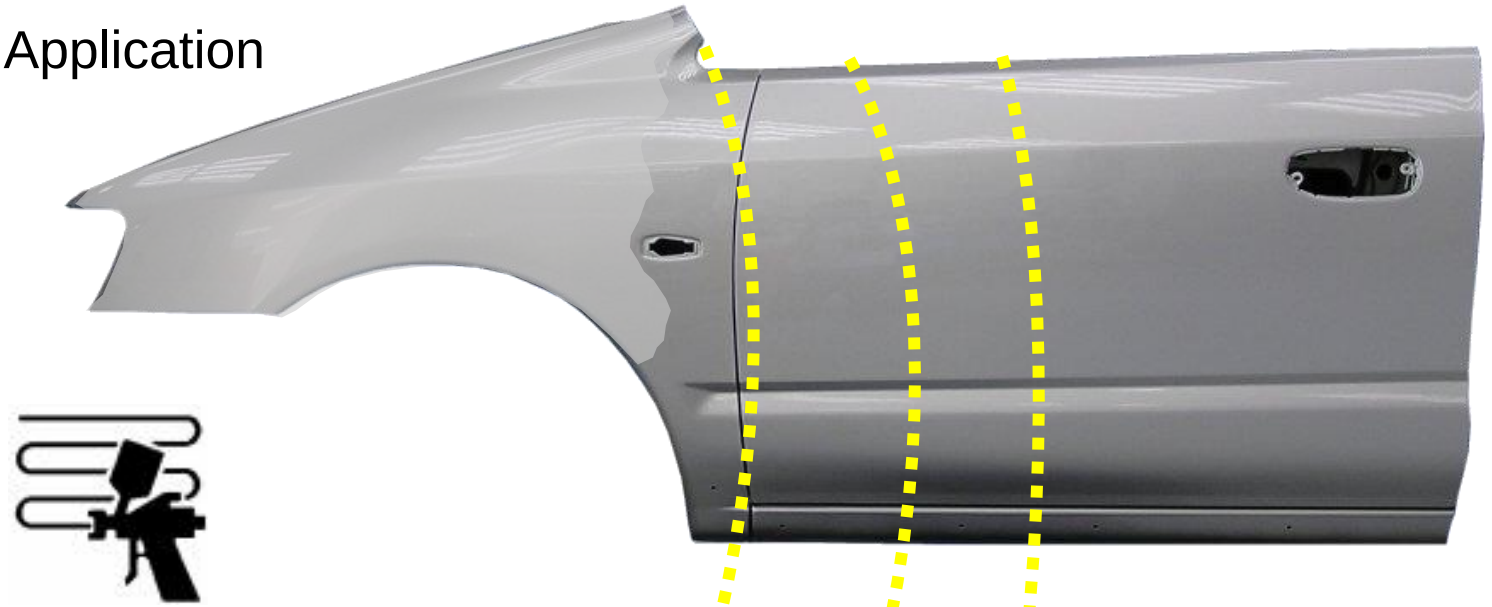
P500 / P1000

Scotch Brite

Degreaser

Panel-repair

Application



First coat

Second coat

Mist-coat

Panel-repair

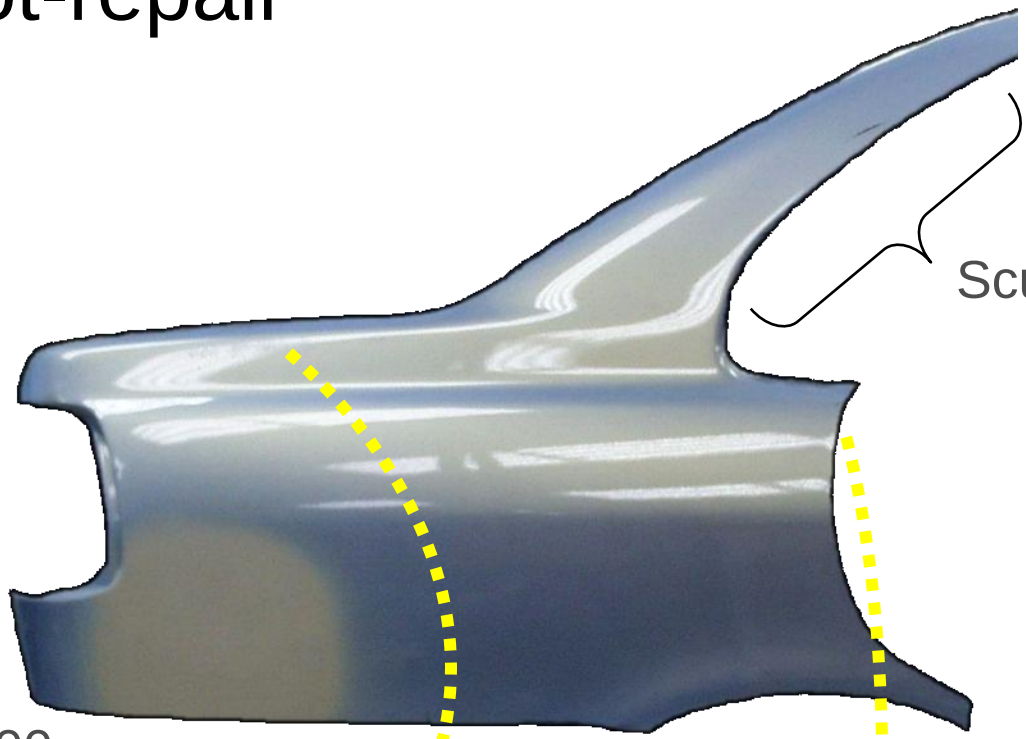
Clearcoat

First coat

Second coat

2-C Spot-repair

Preparation



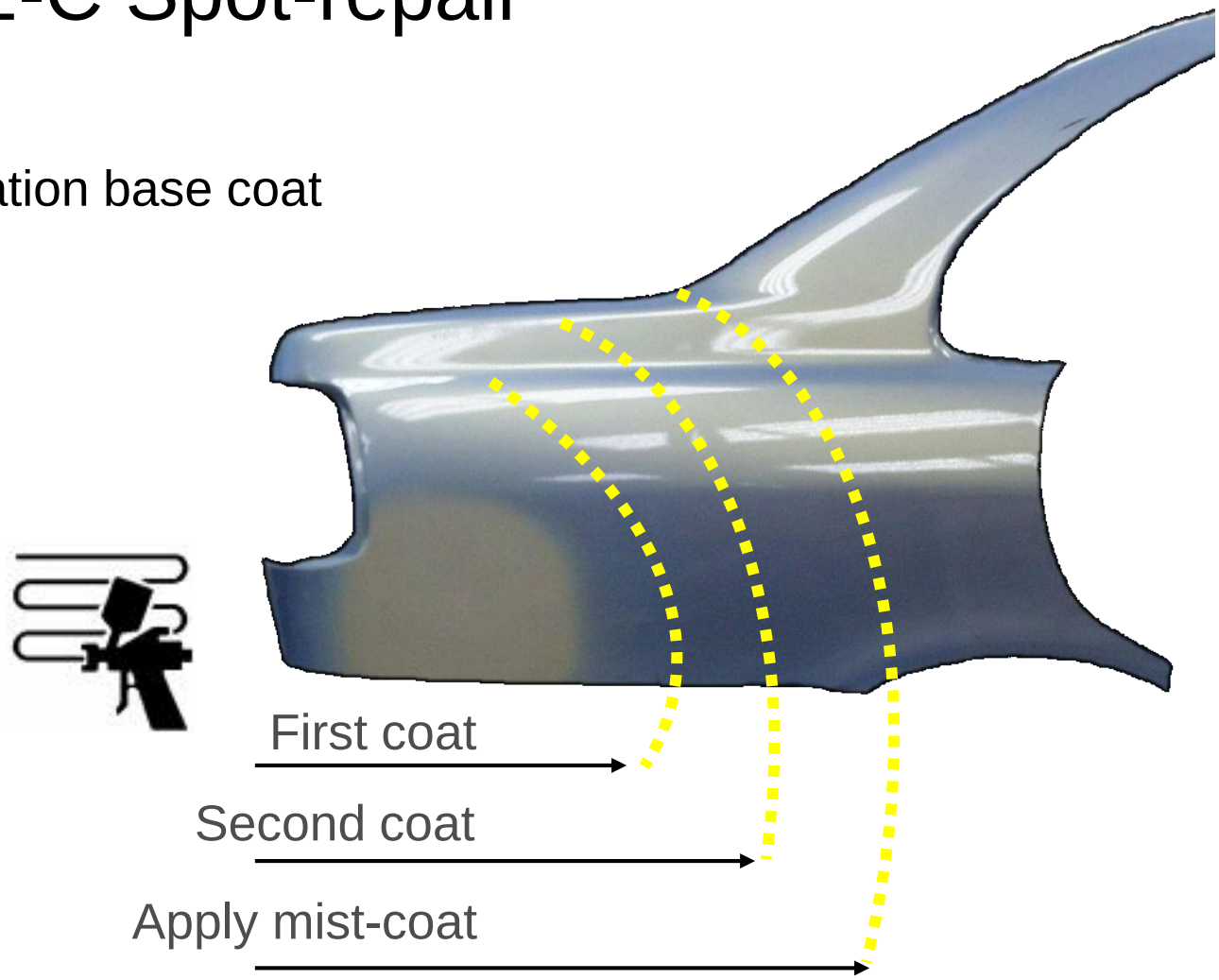
P500 / P1000

Scotch Brite

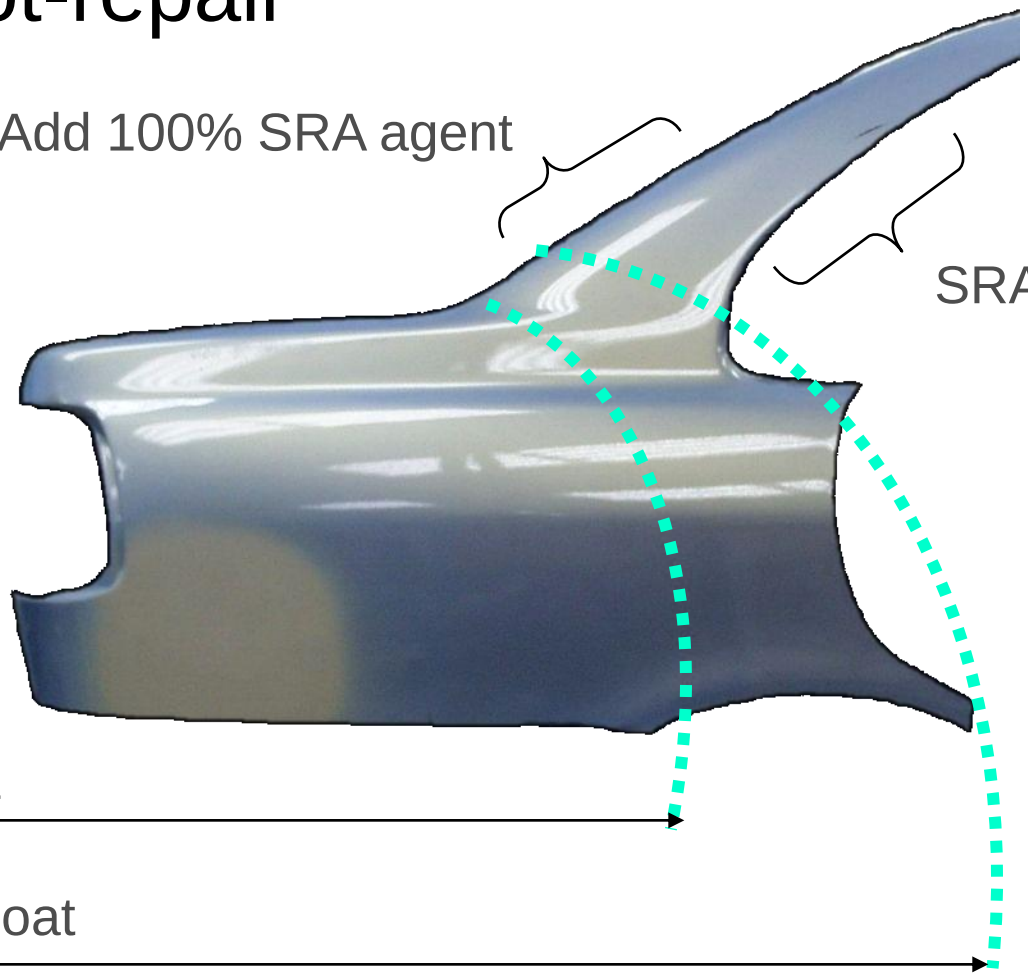
Degreaser

2-C Spot-repair

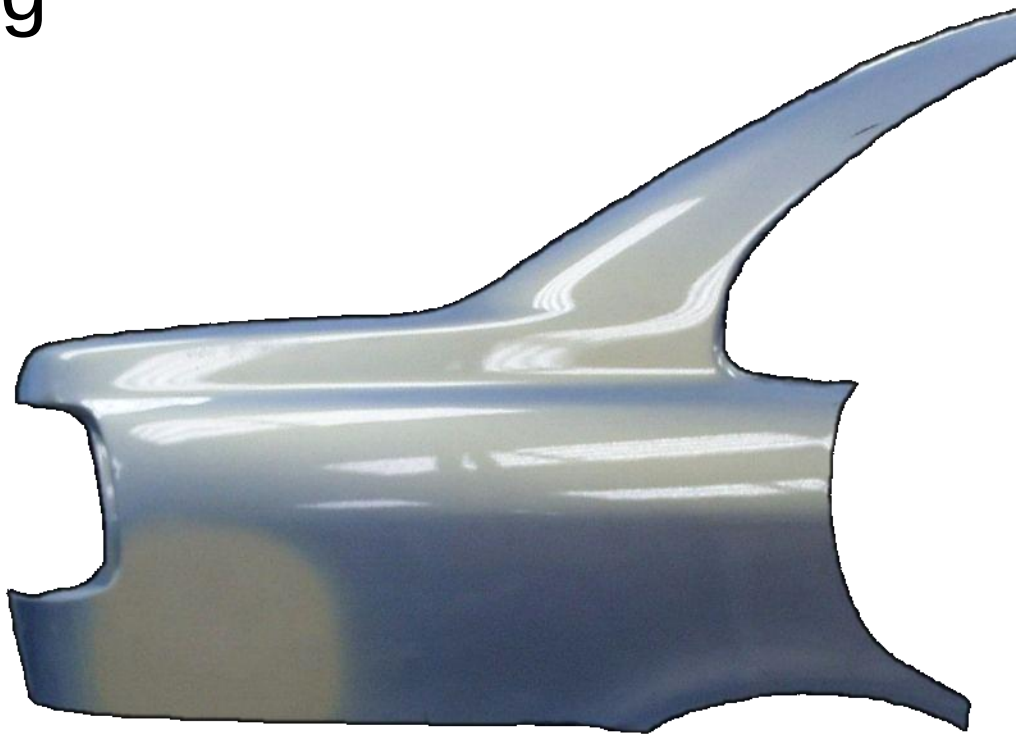
Application base coat

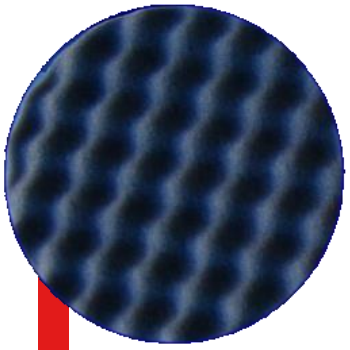


2-C Spot-repair



Polishing

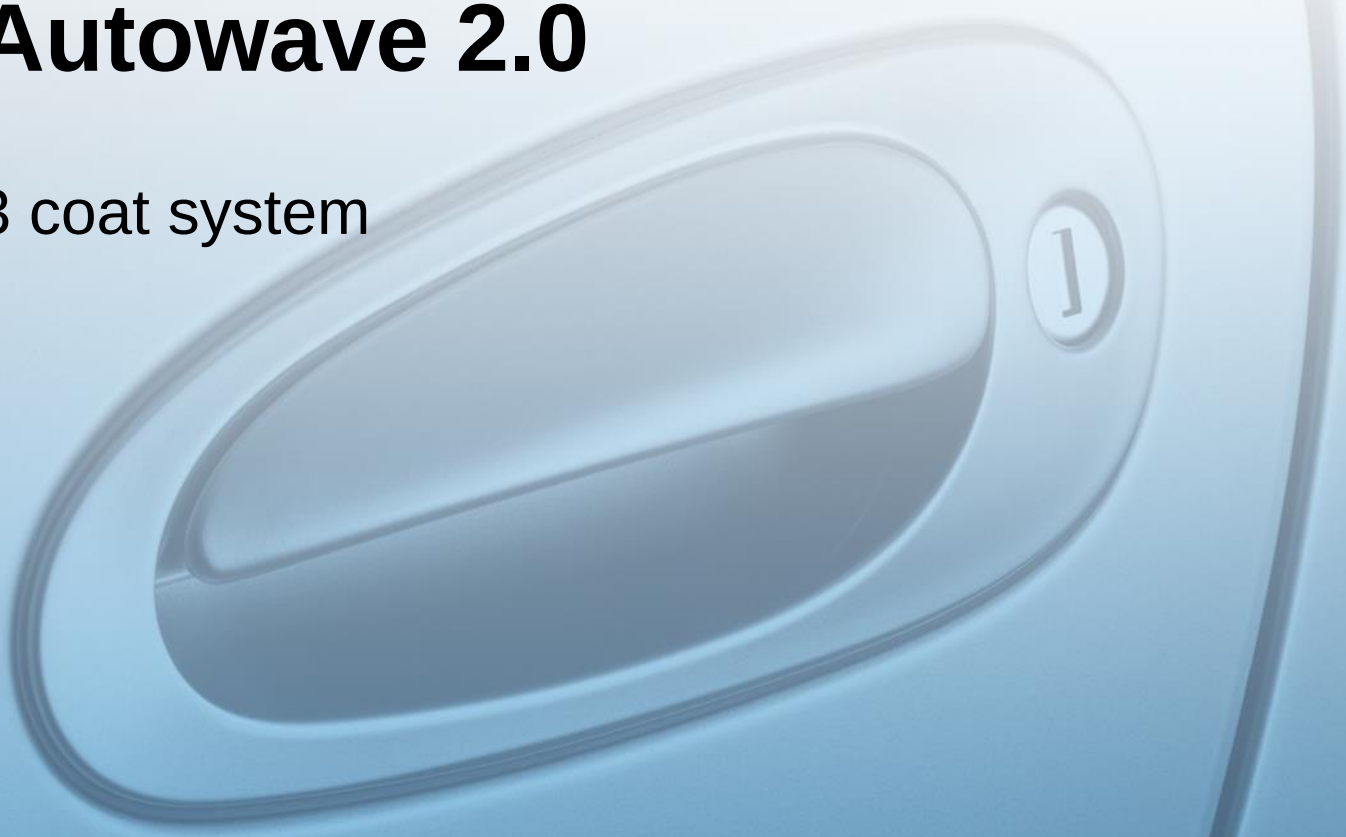




Soft pad with fine polish

Autowave 2.0

3 coat system



Program

Introduction

Theory – TDS explanation

3 coat system application

Theory – TDS explanation

Repair 3 coat system

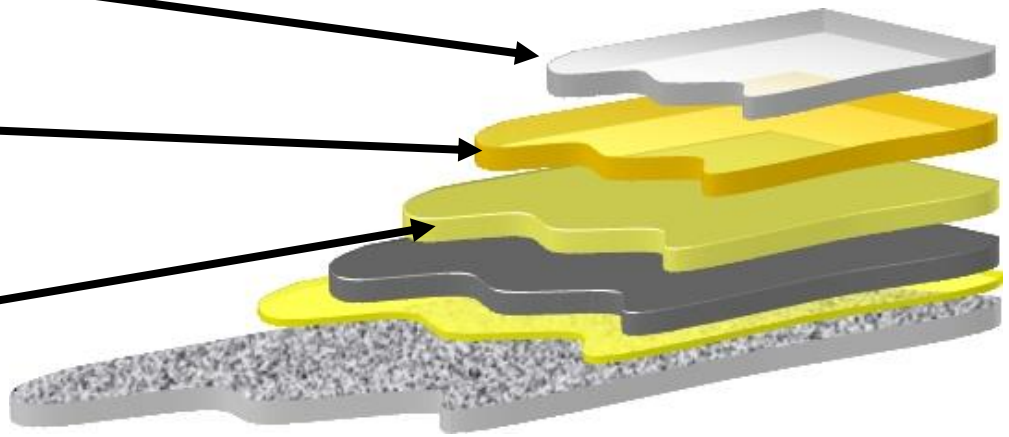
Evaluation 3 coat system

Most common 3 coat system

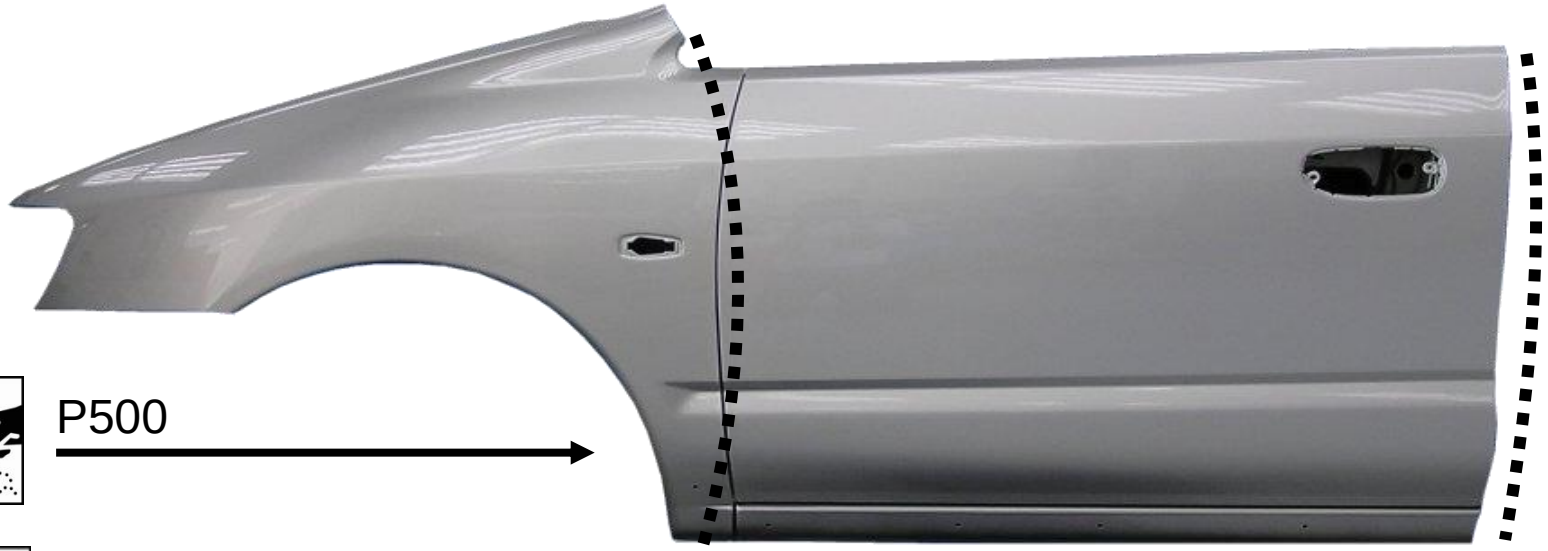
Clearcoat

Pearl effect coat

Solid Foundation coat



3 coat system preparation



P500

P1000 or Scotch brite Grey

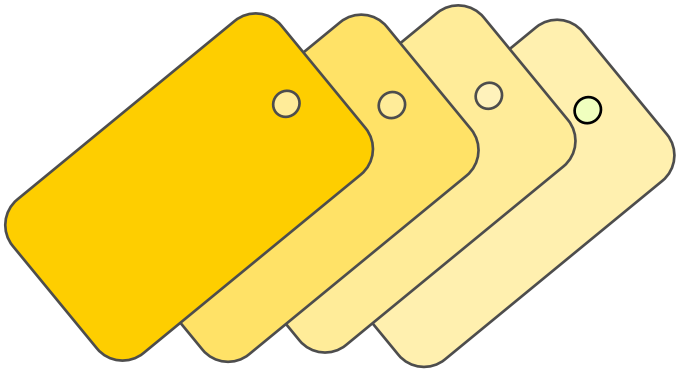
Surface Cleaning

Color check (video)

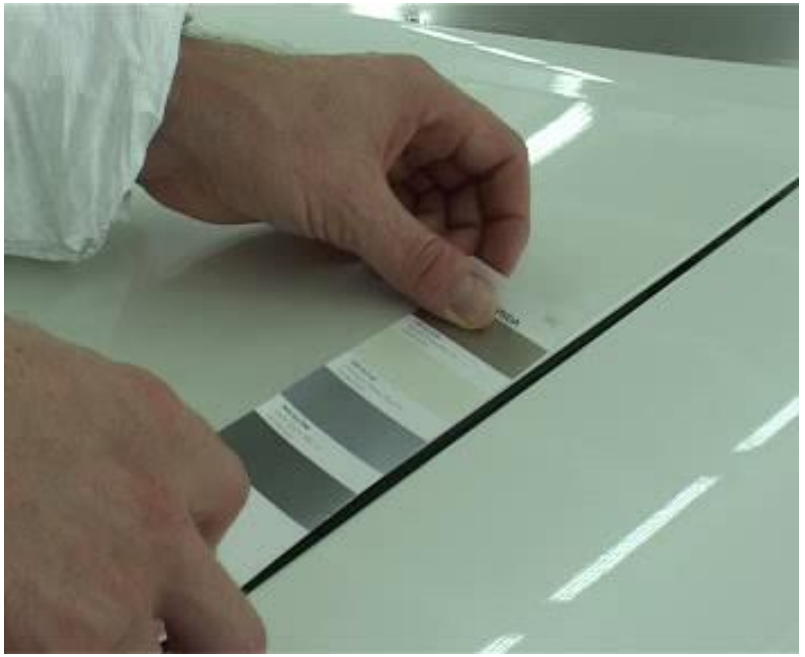
Multiple number of layers creating the color effect

- 5 panels in the foundation coat
- Cover with 1-5 coats of the effect color

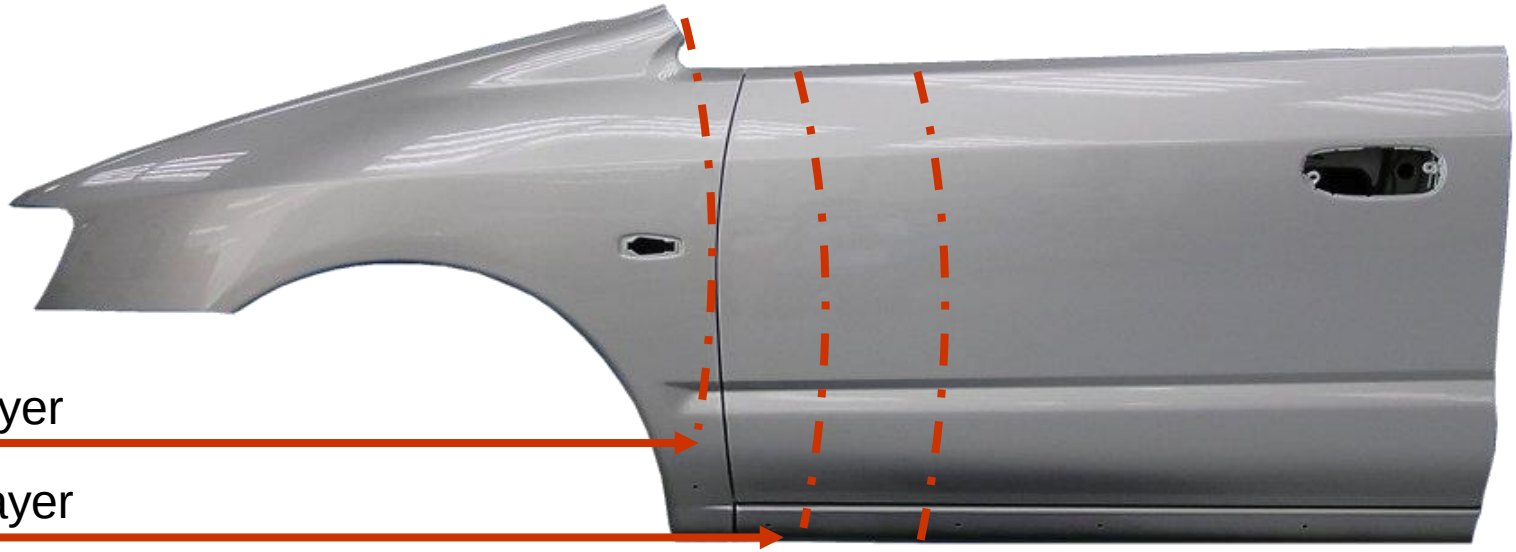
Always cover with a clearcoat



Select the closest matching panel



Application foundation coat

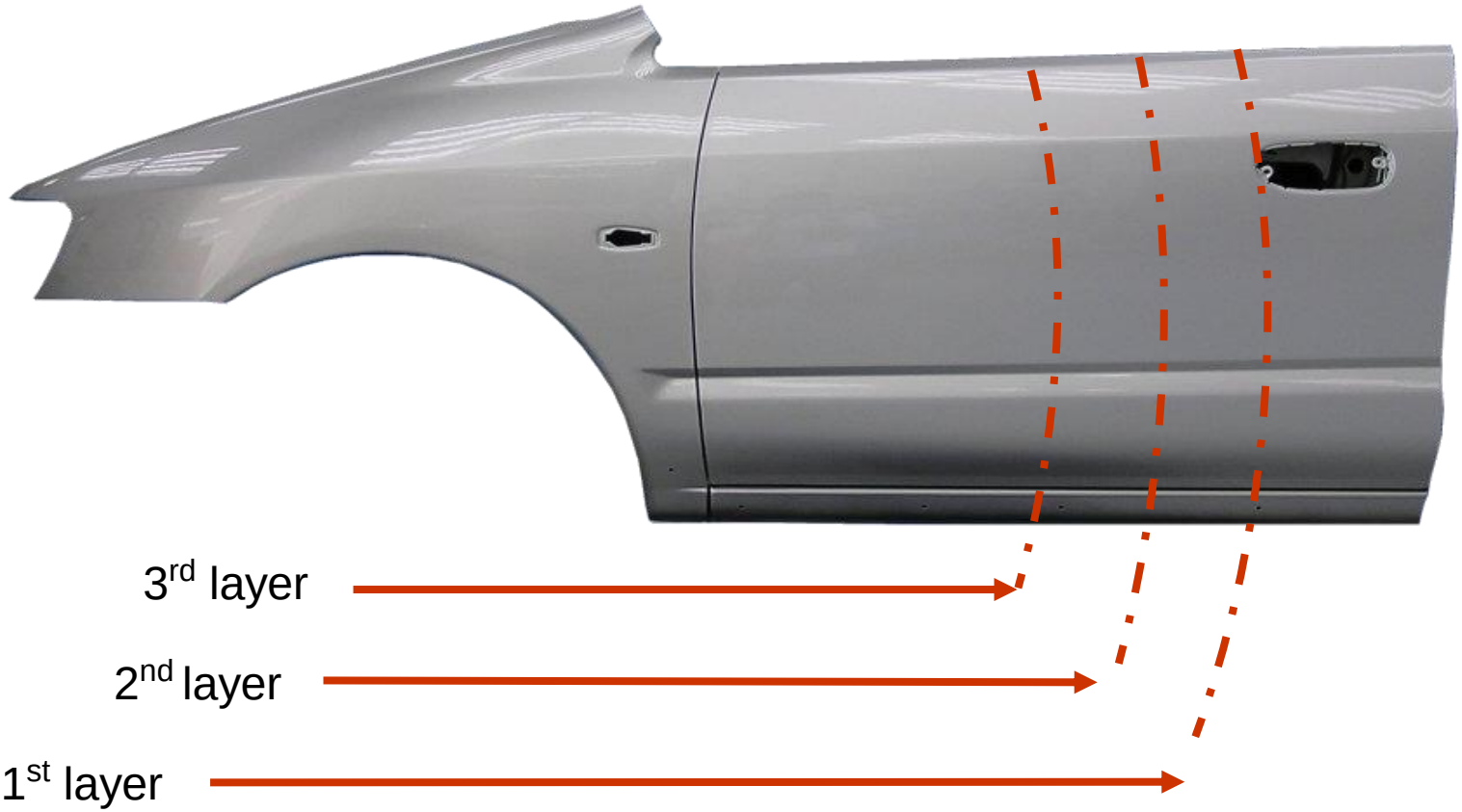


1st layer

2nd layer

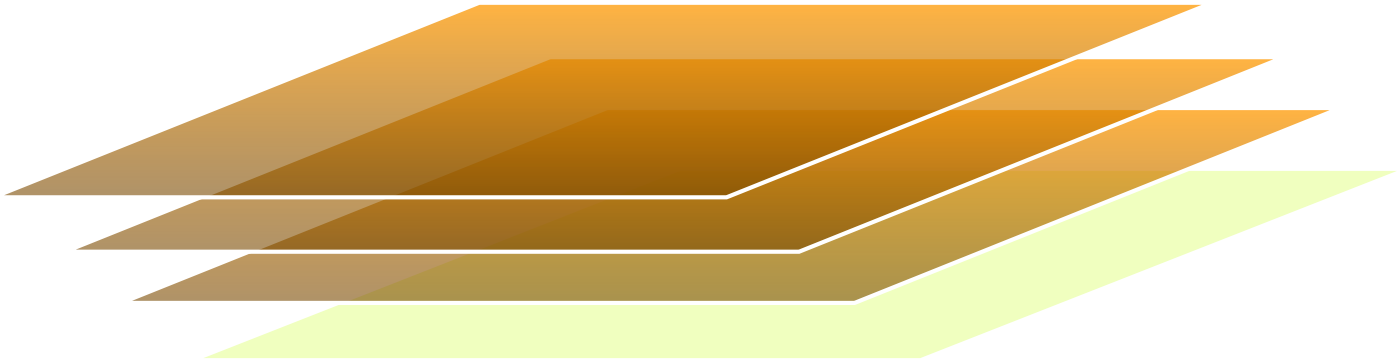
Mix foundation and effect color 1:1

Application effect coat



Clearcoat application

Multiple layers & system properties



Higher layer thickness requires:

- Longer flash-off times between the layers
- Temperature increase between foundation & effect color
- Extra temperature and longer flash-off time before clearcoat application

To secure optimum system properties

1. ± 10 minutes temperature rise to 60ºC after foundation coat
2. ± 15 minutes temperature rise to 60ºC after effect coat
3. Sufficient cool down before Clearcoat application