

Modern Classikk RM SB

Modern Classikk RM SB is premium solvent borne basecoat color system. When combined with Autoclear clearcoat it has unparalleled excellence in depth, clarity, and quality. This custom line of automotive paints is as far from average as can possibly be while still bringing to mind the look and feel of the iconic colors of yesterday.



Safety Considerations

- Use suitable personal protection.
- AkzoNobel recommends the use of a fresh air supply respirator.



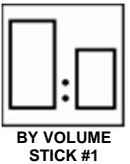
Surface Preparation

- Initial sanding with a coarser sanding grit of P400 dry or P500 grit wet sand paper.
- Final sand with P500-P600 grit dry or P600-P800 grit wet sand paper.



Surface Cleaning

- AkzoNobel UltraPrep AutoPrep Surface Cleaner – Waterborne surface cleaner.
- Sikkens M600 Cleaner – Solvent based surface cleaner.



Mixing

- 100** Parts Modern Classikk RM SB
50-80 Parts Modern Classikk Premium Reducer

BY VOLUME
STICK #1



HVLP or Compliant Spray-Gun Set-Up:

- HVLP Gravity – 1.3 – 1.5 mm
- Compliant Gravity – 1.2 – 1.4 mm

Application Air Pressure:

- HVLP – 10 psi (0.68 bar) at cap maximum.
- Consult manufacturers' specifications.



Application – Solid Colors

- 2 to 3 Single wet coats.
 - Flash 5 minutes between coats.

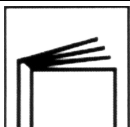
Application – Metallic or Effect Colors

- 3 Medium coats followed by an orientation coat.
 - Flash 5 minutes between coats.



Flash Drying Before Clearcoat

- Flash dry for 15-20 minutes before clearcoat at 70°F (21°C).



Recoatability

- Autoclear PC, Standard or Production
- Autoclear HS Plus 2 Pack, Fast or Slow
- Autoclear HS Plus LV 2 Pack, Fast or Slow
- Autoclear Energy Select LV Fast or Slow
- Autoclear Performance LV 2 Pack Fast or Slow
- Autoclear Superior 250 2 Pack Fast or Slow

Read the complete Technical Data Sheet and the Safety Data Sheet (SDS) for detailed product information.

Description

Modern Classikk RM SB is premium solvent borne basecoat color system. When combined with Autoclear clearcoat it has unparalleled excellence in depth, clarity, and quality.

Suitable Substrates

May be applied over prepared –

- Stable existing OEM finishes
- Sikkens Primer Surfacer EP-II
- Sikkens Colorbuild Plus
- Sikkens Colorbuild Plus 250
- Sikkens High Build Surfacer
- Sikkens Autosurfacer UV

Cannot be applied over –

- × Airbag covers
- × Thermoplastic acrylic lacquers
- × Acid containing wash primers
- × AutoPrep Pretreatment wipes
- × AutoPrep Pretreatment Pen CF

Products and Additives



- Modern Classikk RM SB
 - Modern Classikk Premium Reducer Fast
 - Modern Classikk Premium Reducer Medium
 - Modern Classikk Premium Reducer Slow
 - Modern Classikk Premium Reducer Extra-Slow
 - Sikkens Autoclear PC Hardener
 - Sikkens Autoclear HS Plus 2-Pack Hardener
 - Ready mix colors
 - 60-75°F (16-24°C), Item #562038, 562040
 - 70-85°F (20-30°C), Item #562041, 562042
 - 80-95°F (27-35°C), Item #562044, 562045
 - Above 95°F (35°C), Item #562043, 562039
 - Optional Hardener, Item #391299
 - Optional Hardener, Item #481305
- ü To prevent exceeding National Rule VOC levels for 3 stage colors 10% hardener must be added to the foundation color before reduction.

Basic Raw Materials



- Modern Classikk RM SB
- Modern Classikk Premium Reducer
- Autoclear PC or HS Plus 2-Pack Hardeners
- Physically drying binders
- Specially formulated solvent blends
- Polyisocyanate resin

Substrate Preparation



Pre-Cleaning

- Clean with AkzoNobel AutoPrep Ultra-Prep (VOC compliant), Sikkens M600 Surface Cleaner or Anti-Static Surface Cleaner.



Sanding Preparation

Initial Sanding

Final Sanding

· Primer Surfacer – Dry Sanding	P360 to P400	P500 to P600
· Existing Finishes – Dry Sanding	P360 to P400	P500 to P600
· Primer Surfacer – Wet Sanding	P400 to P500	P600 to P800
· Existing Finishes – Wet Sanding	P400 to P500	P600 to P800



Final-Cleaning

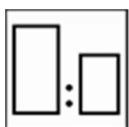
- Clean with AkzoNobel AutoPrep Ultra-Prep (VOC compliant), Sikkens M600 Surface Cleaner or Anti-Static Surface Cleaner.

Product Agitation



- Because Modern Classikk is a high solids paint it needs to be agitated before use.
- Stir or shake vigorously before each use.

Mixing



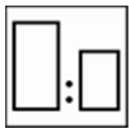
BY VOLUME
STICK #1

Mix
100
50-80

Standard Mix
Parts Modern Classikk RM SB
Parts Modern Classikk Premium Reducer



- Autoclear PC Hardener or Autoclear HS Plus 2-Pack Hardener may be desired in Modern Classikk RM SB –
 - 1) To maintain VOC levels it must be used in the first layer color of a 3-Stage system. For these situations only 50 parts reduction can be used.
 - 2) To extended recoat time for solid colors to 48 hours.
 - 3) For improved system robustness including stone chip resistance, adhesion and system hardness.

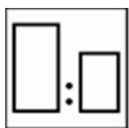


BY VOLUME
STICK #14

Mix
100
10

Basecoat + Hardener Mix – Step 1
Parts Modern Classikk RM SB
Autoclear PC Hardener or Autoclear HS Plus 2-Pack Hardener

Stir together and then reduce –

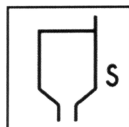


BY VOLUME
STICK #1

Mix
100
50-80

Basecoat + Hardener Mix – Step 2
Parts Modern Classikk RM SB with Autoclear Hardener
Parts Modern Classikk Premium Reducer

Viscosity – Ready to Spray



Measured with a DIN #4 viscosity cup at 70°F (21°C).

- 100:50 ratio – 16 to 17 seconds
- 100:80 ratio – 13 to 14 seconds

Pot-Life When Mixed



Product Mix

- Modern Classikk RM SB, solid or metallic
- Modern Classikk RM SB, 2nd layer mid-coat colors
- Modern Classikk RM SB with PC Hardener
- Modern Classikk RM SB with HS Plus 2 Pack Hardener

70°F (21°C)

- 6 Months
- 24 Hours
- 4 Hours
- 4 Hours

Spray-Gun Set-Up



HVLP or Compliant Spray-Gun Set-Up:

- HVLP Gravity – 1.3 – 1.5 mm
- Compliant Gravity – 1.2 – 1.4 mm

Application Air Pressure:

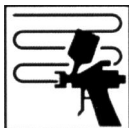
- HVLP – 10 psi (0.68 bar) at cap maximum.
- Consult manufacturers' specifications.

Application – Overall Complete Refinish



Solid Color Application

- Apply 2 single wet coats or until coverage is achieved.
 - Allow a flash off time between coats of 3 to 5 minutes between coats at 70°F (21°C). Flash time will be dependent on temperature, applied paint wetness/thickness and available air-flow.



Metallic Color Application

- Apply 1 full coat, 100% closed.
 - Flash dry between coats until the basecoat dries completely to a matte finish.
- Next apply intermediate coats, 80% as wet as the first coat until the area is covered.
 - If necessary even out the metallic pattern with an orientation coat after the last coat has flashed off completely. This is achieved by pulling the gun an additional two to four inches from the panel and applying a lighter orientation coat (drop coat). Do not make this coat too wet. With HVLP equipment, it is not necessary to lower the pressure, although this may be done in order to control the color.



Pearl or Mid-Coat Application for 3-Stage

- Pearl Mid-Coat – Apply 3 to 4 thin medium wet coats. Flash 3 to 5 minutes between coats at 70°F (21°C). Do not apply an orientation coat.
- Translucent Mid-Coat – Spray 3 to 4 even, wet coats, allowing 5-10 minutes flash-off between coats at 70°F (21°C).

Application – Spot Repair



- When making spot repairs apply thin coats extending each until opacity is achieved. Dry until matt between each coat before fading out beyond the coverage coats.
- Metallic colors may need lower air pressure may be needed for color control. Extend each coat until coverage is obtained. Finally apply an orientation coats fading out beyond the coverage coats.

Two Tone Applications



- Modern Classikk RM SB solid or metallic colors can be taped off with fine line masking tape after a 20-30 minute flash-off at 70°F (20°C).
 - RM SB that has been mixed with the optional hardener may require more flash before masking.
- After masking the second basecoat color can be applied.

Drying / Curing Time



- Allow Modern Classikk RM SB to dry for 15 to 20 minutes at 70°F (20°C) before applying clearcoat.
- Allow 3-Stage color applications to dry for 20 to 30 minutes at 70°F (20°C) after the second layer color application is completed.
- Drying times are stated at recommended application, film thickness and object temperature.
- The maximum time Modern Classikk RM SB may be left before clear:
 - Modern Classikk RM SB metallic color: 48 hours
 - Modern Classikk RM SB solid color: 5 hours
 - ü To extend the re-coat time of solid colors to 48 hours mix with hardener as described in Mixing above.

Film Thickness – Using Suitable Application



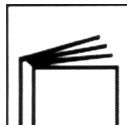
- One coat of Modern Classikk RM SB solid, metallic and effect colors is 0.3-0.4mils (7.6-10.2μm).

Theoretical Coverage



- Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others.
- 5.6m²/liter ready to spray at 25.4μm (1mil) dry film build and 100% transfer efficiency.

Recoating



- Modern Classikk RM SB may be clear coated with these high quality Sikkens clearcoats after the dry time described above –
 - Autoclear PC, Standard or Production
 - Autoclear HS Plus 2 Pack, Fast or Slow
 - Autoclear HS Plus LV 2 Pack, Fast or Slow
 - Autoclear Energy Select LV Fast or Slow
 - Autoclear Performance LV 2 Pack Fast or Slow
 - Autoclear Superior 250 2 Pack Fast or Slow

What To Do?



De-Nibbing, Dust Removal

- If during the application of Modern Classikk RM SB some dust impregnation occurs, allow the basecoat color to flash off sufficiently, at least 20 minutes at 70°F (20°C), then lightly sand the damaged area with P600 then P800 grit dry sanding paper. Thoroughly remove all sanding residue before continuing the basecoat application.

Lifting / Wrinkling

- Some substrates are not original or are unknown. Then it is reasonable to apply 2-3 coats of sanding primer surfacer, prior to Modern Classikk RM SB, over the whole panel. A pigmented sealer may be used while also incorporating longer flash-times in the application process.

Fisheyes / Craters

- Fisheyes maybe caused by silicones or other contamination. In that event apply 2 mist coats of Modern Classikk RM SB over the contaminated area and proceed with the repair allowing longer flash times. If severe, it may be necessary to allow a dry time of 20-30 minutes, sand, and continue the with basecoat application. Do not add Anti-Silicone to Modern Classikk RM SB as this may lead to risk of poor clearcoat adhesion.

VOC / Regulatory Information



Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

Modern Classikk RM SB Ready to spray VOC:

- Mixed with Modern Classikk Premium Reducer 100:50 – 6.5lb/gal. 780g/liter.
- Mixed with Modern Classikk Premium Reducer 100:80 – 6.7lb/gal. 804g/liter.
- Modern Classikk RM SB with 10% hardener, and then 100:80 with Modern Classikk Premium Reducer – 6.50lb/gal. 780g/liter.

Product Storage



Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).

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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 Safety 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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