

Modern Classikk RM WB

Modern Classikk RM WB is premium waterborne 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.



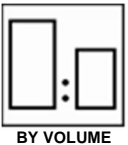
Surface Preparation

- 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
10-30

Solid Colors
Parts Modern Classikk RM WB
Parts Modern Classikk
Waterborne Activator

Mixing
100
30-50

Metallic or Effect Colors
Parts Modern Classikk RM WB
Parts Modern Classikk
Waterborne Activator



HVLP or Compliant Spray-Gun Set-Up:

- HVLP Gravity – 1.3 – 1.5 mm
- Compliant Gravity – 1.3 – 1.5 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.

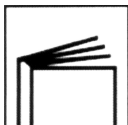
Application – Metallic or Effect Colors

- 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 and Production (National Rule VOC only)
- Autoclear HS+ 2 Pack Fast and Slow (National Rule VOC only)
- Autoclear Energy Select LV Fast and Slow (VOC compliant)
- Autoclear Performance LV 2 Pack Fast and Slow (VOC compliant)
- Autoclear Superior 250 2 Pack Fast and Slow (VOC compliant)

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

Description

Modern Classikk RM WB is premium waterborne 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
- Autosurfacer UV

Cannot be applied over –

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

Products and Additives



- Modern Classikk RM WB
- Modern Classikk Waterborne Activator
- Sikkens WB Hardener (0.5 Liter)
- Ready mix colors
- All applications, Item #562340
- Optional hardener, Item #540824
- ü The addition of 5% Sikkens WB Hardener can be used to improve system robustness including stone chip resistance, adhesion and system hardness. WB Hardener is also recommended when multi-color systems are applied where the recommended layer thickness may be exceeded.

Basic Raw Materials



- Modern Classikk RM WB
- Modern Classikk Waterborne Activator
- Sikkens WB Hardener
- Physically drying binders
- Water / Glycol mixture
- 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

- Primer Surfacer – Dry Sanding
- Existing Finishes – Dry Sanding

Initial Sanding

P360 to P400
P360 to P400

Final Sanding

P500 to P600
P500 to P600



- Primer Surfacer – Wet Sanding
- Existing Finishes – Wet Sanding

P400 to P500
P400 to P500

P600 to P800
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 and/or shake vigorously before use.
 - If using a mechanical shaker, do not shake for more than 60 seconds.
 - For metallic, pearl or effect colors, also stir the color after shaking.

Mixing



BY VOLUME
STICK #14

Mix
100
10-30

Solid Colors
Parts Modern Classikk RM WB
Parts Modern Classikk Activator WB



BY VOLUME
STICK #14

Mix
100
30-50

Metallic or Effect Colors
Parts Modern Classikk RM WB
Parts Modern Classikk Activator WB



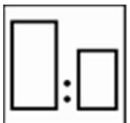
BY VOLUME
STICK #14

Mix
100
10-30

Mid-Coat Pearl or Translucent Colors
Parts Modern Classikk RM WB
Parts Modern Classikk Activator WB



- Sikkens Hardener WB may be desired in Modern Classikk RM WB for improved system robustness including stone chip resistance, adhesion and system hardness. Hardener WB is also suggested when the total basecoat thickness will exceed 1.2mils (30.5 µm). In that case use the mixing method below

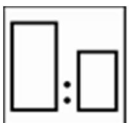


BY VOLUME

Mix
100
5

Basecoat + Hardener Mix – Step 1
Parts Modern Classikk RM WB Color
Sikkens Hardener WB

Stir together and then reduce –

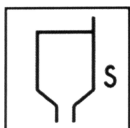


BY VOLUME

Mix
100
10-50

Basecoat + Hardener Mix – Step 2
Parts Modern Classikk RM WB with Sikkens Hardener WB
Parts Modern Classikk Activator WB as described in sections above dependent on color type.

Viscosity – Ready to Spray



- Measured with a DIN #4 viscosity cup at 70°F (21°C).
 - Modern Classikk RM WB color reduced has a viscosity of 20-30 seconds.

Pot-Life When Mixed



Product Mix

- Modern Classikk RM WB, solid or pearl
- Modern Classikk RM WB, metallic colors
- Modern Classikk RM WB with Hardener WB

70°F (21°C)

3 Months

24 Hours

1-½ Hours

Spray-Gun Set-Up



HVLP or Compliant Spray-Gun Set-Up:

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

Application Air Pressure:

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

Application – Overall Complete Refinish



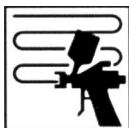
Solid Color Application

- Apply 2-3 coats or until opacity is reached.
- Allow a flash off time between coats of 3 to 5 minutes at 70°F (21°C).
 - Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.
- The first coat is applied as a closed wet coat with a gun distance of 6".
- The 2nd – 3rd coats are applied medium wet until coverage is achieved.
 - With proper application the foundation color should be smooth when completed.



Metallic Color Application

- Apply 2-3 coats or until opacity is reached.
 - The first coat is applied as a full, closed, wet, coat with a gun distance of 6"
 - Allow a flash off time between coats of 3 to 5 minutes at 70°F (21°C) or until completely matte in appearance.
 - ü Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.
- Next apply intermediate coats. The 2nd – 3rd coats should be 80% closed with a gun distance of 6-8" from the panel, until coverage is achieved.
- Refine 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 medium wet coats. Flash 3 to 5 minutes (until matte) 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 (until matte) between coats at 70°F (21°C).



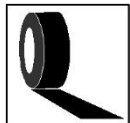
- Humidity and airflow will influence the Modern Classikk RM WB flash-off and drying times. These times can be reduced to a minimum by using air accelerator systems with a minimum distance of 3 feet (1 meter) from the object, thereby increasing the airflow over the object.

Application – Spot Repair



- When making spot repairs apply thin coats extending each until opacity is achieved. Dry until matte 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 WB solid or metallic colors can be taped off with fine line masking tape after a 30 minute flash-off at 70°F (20°C). After masking the second basecoat color can be applied.

Drying / Curing Time



- Allow Modern Classikk RM WB 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 recoat time is 24 hours at 75°F (24 ° C).

Film Thickness – Using Suitable Application



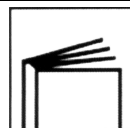
- One coat of Modern Classikk RM WB solid, metallic and effect colors is 0.3-0.4mils (7.6-10.2μm).
- Sikkens Hardener WB is recommended for multi-color systems where the maximum suggested basecoat thickness of 1.2mils (30.5μm) is anticipated. See the mixing and pot-life sections above for more information.

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.
- Modern Classikk RM WB ready to spray 6.3m²/liter at 25.4μm (1mil) film thickness and 100% transfer efficiency.

Recoating



- Modern Classikk RM WB may be clear coated with these high quality Sikkens clearcoats after the dry time described above –
 - Autoclear PC Standard and Production (National Rule VOC only)
 - Autoclear HS+ 2 Pack Fast and Slow (National Rule VOC only)
 - Autoclear Energy Select LV Fast and Slow (VOC compliant)
 - Autoclear Performance LV 2 Pack Fast and Slow (VOC compliant)
 - Autoclear Superior 250 2 Pack Fast and Slow (VOC compliant)

What To Do?



De-Nibbing, Dust Removal

- If during the application of Modern Classikk RM WB 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 WB, 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 WB 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 WB.

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 WB Ready to spray VOC:

- Modern Classikk RM WB solid colors – 3.5lb/gallon (<420g/liter).
- Modern Classikk RM WB metallic and effect colors – 3.5lb/gallon (<420g/liter).
- Modern Classikk RM WB mid-coat colors – 3.5lb/gallon (<420g/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).

AkzoNobel Inc., North America

Address: 1845 Maxwell Street – Troy, MI USA

Telephone: 800.618.1010

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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 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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Head Office

AkzoNobel Car Refinishes B.V., PO Box 3, 2170 BA Sassenheim, The Netherlands.