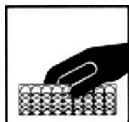


Description

Reducer SRA 4.5 is a specialty solvent designed for dissolving the overspray and fade out edge created during spot repairing or blending. Reducer SRA 4.5 can be used with any Sikkens acrylic urethane topcoat or clearcoat. The mix of special solvents in Reducer SRA 4.5 assists in making a seamless transition from repair to existing finish.



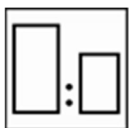
Fade Out Edge Preparation

- Prepare the full strength topcoat or clearcoat application area with P1000 on a D/A with interface pad or a gray scuff pad and Sikkens Blend Prep.
- Prepare the clear melt-in application area with a gold scuff pad or damp sponge and Sikkens Blend Prep. The area must extend past the intended melt-in area.



Use With Ready to Spray Paint

- For blending applications, prepare the topcoat or clearcoat as described in the clearcoat TDS then add Reducer SRA 4.5.



STICK # 1

Mix
100
50

SRA 4.5 By Volume

Ready to spray clear coat
 Reducer SRA 4.5

Note: Reducer SRA 4.5 must be mixed with clearcoat and never used alone.

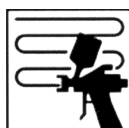


SRA 4.5 + Clearcoat Spray-Gun Set-Up:

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

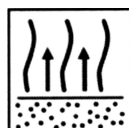
Reduce Application Air Pressures:

- HVLP – 6-8 psi (.41-.55 bar) at the air cap.
- Consult manufacturer specifications.



Reducer SRA 4.5 + Clearcoat Application

- Apply 1 thin coat of SRA 4.5 + Clearcoat over the full strength over spray edge, extending into the clear melt-in application area.
- Apply a second application after a short flash if needed.
- Control application to restrict the overspray to the edge of the application.



Flash Between Coats at 70°F (21°C)

- Clearcoat, 1-3 minutes.
- Reducer SRA 4.5+Clear, 15-30 seconds.

Flash at 70°F (21°C) Before Force Drying

- Refer to the mixed product TDS for flash and bake recommendations.



Drying

- Refer to the mixed and applied product TDS for drying recommendations.

Read complete TDS for detailed product information.

Description

Reducer SRA 4.5 is a specialty solvent designed for dissolving the overspray and fade out edge created during spot repairing or blending. Reducer SRA 4.5 can be used with any Sikkens acrylic urethane clearcoat. The mix of special solvents in Reducer SRA 4.5 assists in making a seamless transition from repair to existing finish.

Blending of Topcoat or Clearcoat

- AkzoNobel strongly recommends the application of clear coat over the entire panel being repaired. There are, however, instances where this is not practical. Such as repairs on older vehicles where economics would dictate that a warranty is not required. In these instances, it may be acceptable to solvent blend the clear coat into small areas such as a rocker panel, sail panel or on vertical areas only.
- Solvent blending techniques and procedures explained in this TDS are not warranted by AkzoNobel or OEM approved.

Suitable Substrates

- Refer to TDS for the paint product that Reducer SRA 4.5 will be used with for information on suitable substrates.

Compatible Products**Product**

- Sikkens Acrylic Urethane Clearcoats

Note: Reducer SRA 4.5 must be mixed with clearcoat and never used alone.

Products and Additives**Product**

- Reducer SRA 4.5, Quart – Stock #397904

Basic Raw Materials**Product**

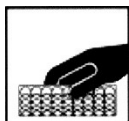
- Reducer SRA 4.5 – Hydroxyl acrylic resins blended with specially formulated solvents.

Substrate Preparation



Pre-Cleaning

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with AutoPrep UltraPrep Surface Cleaner.



Fade Out Edge Preparation

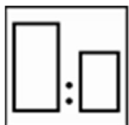
- Prepare the full strength topcoat or clearcoat application area with P1000 on a D/A with interface pad or a gray scuff pad and Sikkens Blend Prep.
- Prepare the clear melt-in application area with a gold scuff pad or damp sponge and Sikkens Blend Prep. The area must extend past the intended melt-in area.



Surface Cleaning – Prior to Paint Application

- Clean with AutoPrep UltraPrep Surface Cleaner.

Mixing



STICK # 1

Mix
100
50

SRA 4.5 By Volume

Ready to spray clear coat
Reducer SRA 4.5

Note: Reducer SRA 4.5 must be mixed with clearcoat and never used alone.

Pot-Life When Mixed



- The recommended pot-life does not change with the addition of Reducer SRA 4.5.
- Refer the TDS of the product being applied for pot-life information.

Spray Gun Set-Up



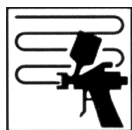
SRA 4.5 + Clearcoat Spray-Gun Set-Up:

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

Reduce Application Air Pressures:

- HVLP – 6-8 psi (.41-.55 bar) at the air cap.
- Consult manufacturer specifications.

Application Reducer SRA 4.5 + Clearcoat



Reducer SRA 4.5 + Clearcoat Application

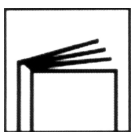
- Control the application to restrict the overspray from the application.
- Apply 1-2 coats from the outside in. To avoid too much build-up of overspray apply in the direction of the wet full strength clearcoat and not in the direction of the prepared existing finish.
- Apply 1 thin coat of SRA 4.5 + Clearcoat at the outside of the area prepared for the clear coat blend. Work your way toward the full strength clear as you apply the SRA 4.5 clearcoat combination.
- Apply a second application after a short flash if needed.

Drying / Curing Time



- Dry the applied paint according to its TDS specifications.
- Additional drying with infrared will provide the most favorable through hardening in the blend area and less chance of damaging it during detail.
- If the paint is baked, follow the product TDS recommendations for cool down before detailing.

Recoating



- Refer to the applied product TDS for information on recoating.

Detailing / Polishing



- Polish the blended area by hand with 3M #06064 Perfect-It Machine Polish or a similar fine polishing compound. Do not use an abrasive polishing compound.
- In case more effort is required, polish by machine, using light pressure and a 3M #05707 Perfect-It Foam Polish Pad. Final clean up with a 3M #06016 Perfect-It Detail Cloth.
- After polishing the area may be waxed with a silicon free wax.

Cleaning of Equipment



- Clean equipment following local and federal regulations. In compliant localities, use a VOC compliant high quality solvent borne gun cleaner. For national rule regions, a use high quality lacquer thinner.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

VOC / Regulatory Information



Product

- Reducer SRA 4.5

VOC Pounds per Gallon

3.82

VOC Grams per Liter

458

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)

- Reducer SRA 4.5 – 2 years

AkzoNobel Inc, North America**Address: 1845 Maxwell Street – Troy, MI USA****Telephone: 800.618.1010****FOR PROFESSIONAL USE WITH SUITABLE HSE EQUIPMENT**

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.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.

Head Office

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