sikkens
Autocoat BT

Technical Data Sheet
Topcoats
September 2022

LV 255 Topcoat 3K

FOR PROFESSIONAL USE ONLY

Description
High gloss, state of the art 3K High Solids polyurethane topcoat. The target use for this product is refinishing and refurbish of existing vehicles and the painting of newly build commercial vehicles, trailers and truck chassis. The EU VOC limit for this product (product category: IIB. D) in ready to use form is max 420 g/liter. The VOC content of this product in ready to use form is max. 420 g/liter.



100	Autocoat BT LV 255 Topcoat
25	Autocoat BT LV 255 Topcoat 3K Hardener
25-35	Autocoat BT LV 255 Reducer



5 & 38



Spray gun set-up		Application pressure:
Air assisted Airless	1.3-1.6 mm 4.09-6.11	1.7 -2.2 bar at the air inlet 90-120 bar (material) 2-2.5 bar (atomization)
Low pressure pump	0.8-1.1	1.0 – 1.5 (material) 2.5 bar (atomization)



Conventional low pressure application: 2 x 1 coat
High pressure (air assisted) airless: ½ + 1 coat
(recommended mix ratio high pressure application 100:25:25)



Between coats	Before curing
15 minutes at 20°C	15 minutes at 20°C



Drying	20°C	40°C	60°C
Reducer Fast	3 hours	60 mins	20 mins
Reducer Medium	4 hours	60 mins	30 mins
Reducer Slow	5 hours	90 mins	40 mins



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

sikkens
Autocoat BT

Technical Data Sheet
Topcoats
September 2022

LV 255 Topcoat 3K

FOR PROFESSIONAL USE ONLY

Description

High gloss, state of the art 3K High Solids polyurethane topcoat. The target use for this product is refinishing and refurbish of existing vehicles and the painting of newly build commercial vehicles, trailers and truck chassis. The EU VOC limit for this product (product category: IIB. D) in ready to use form is max 420 g/liter. The VOC content of this product in ready to use form is max. 420 g/liter.

Product and Additives:

Autocoat BT Toner	
Autocoat BT LV 255 Converter	2559-020
Autocoat BT LV 255 Topcoat RM	
Autocoat BT LV 255 Topcoat 3K Hardener	2559-104
Autocoat BT LV 255 Topcoat Accelerated Reducer	2559-202
Autocoat BT LV 255 Topcoat Reducer Fast	2559-203
Autocoat BT LV 255 Topcoat Reducer Medium	2559-204
Autocoat BT LV 255 Topcoat Reducer Slow	2559-205
Autocoat BT LV 255 Air Dry Additive	
Autocoat BT Matt Converter B650M	8099-704
Autocoat BT 800 Structure Paste Fine B60S	8099-703
Autocoat BT 800 Structure Paste Medium B60M	8099-703
Autocoat BT 800 Structure Paste Coarse B60C	8099-703

Basic Raw Materials:

Autocoat BT Toner	: acrylic / polyester resins
Autocoat BT LV 255 Topcoat RM	: acrylic / polyester resins
Autocoat BT LV 255 Converter	: acrylic / polyester resins
Autocoat BT LV 255 Topcoat Hardener	: poly-isocyanate resins

Suitable Substrates:

- Autocoat BT LV 250 Primer EP Beige / Gray
- Autocoat BT LV 350 Primer EP
- Autocoat BT LV 251 Primer UHS
- Autocoat BT LV 254 AS Primer
- Autocoat BT LV 355 Primer UHS Premium
- Autocoat BT LV 350 Filler
- Autocoat BT LV 850 Sealer

Surface Preparation:

Degrease with LV 350 Antistatic Silicone Remover 3511-001. Sand with P360-P400 grit

sikkens
Autocoat BT

Technical Data Sheet
Topcoats
September 2022

LV 255 Topcoat 3K

FOR PROFESSIONAL USE ONLY

Color mixing without formula:

In case an Autocoat BT LV 255 color is made without the use of a formula, always mix 60 parts of BT color with 40 parts of BT LV 255 Converter B255C

Mixing Ratio by Volume:

Standard:

100 parts of Autocoat BT LV 255 Topcoat
25 parts of Autocoat BT LV 255 Topcoat 3K Hardener
25-35 parts of Autocoat BT LV 255 (accelerated) Reducer
Mixing stick 5

Mixing ratios related to mixing with Matt Converter B650M:

	Semi-Gloss	Matt
Toner / Color	2	2
Matt Converter B650M	1	3

Note: The required amount of Matt Converter B650M to obtain a certain gloss level is related to color.
White colors need less matting agent.

Spraying Viscosity:
Rheological characteristics of the LV 255 Topcoat make cup viscosity measurements inaccurate.
For optimum application ensure the paint temperature is between 18ºC and 25ºC

Potlife:

Accelerated Reducer:	60 minutes at 20°C
Reducer Fast:	90 minutes at 20°C
Reducer Medium/Slow:	120 minutes at 20ºC

Note: If temperature exceeds 30°C, potlife will decrease

---

sikkens
Autocoat BT

Technical Data Sheet
Topcoats
September 2022

LV 255 Topcoat 3K

FOR PROFESSIONAL USE ONLY

Application Process:

Conventional/low pressure application:
Apply a thin continuous single coat, followed by a full coat. Flash-off time 15 minutes at 20°C between coats

High pressure (air assisted) airless:
Apply a thin continuous single coat, followed by a full coat.

Note! For complex objects and also in case of high pressure application we recommend to use mix ratio of 100:25:25.

Film Thickness:
Total 50-70 µm (at recommended application)

Cleaning of Equipment:
Use Sikkens Solvent

Cover rate:
Theoretically 10-11 m²/l ready for use mixture at 50 µm dry.

Note: The practical cover rate depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Drying times:

	20°C	40°C	60°C
Dry to handle			
Reducer Slow / Medium / Fast + Air Dry Additive (5%)	1,5 hours		
Accelerated Reducer	2,5 hours	45 minutes	15 minutes
Reducer Fast	3 hours	60 minutes	20 minutes
Reducer Medium	4 hours	60 minutes	30 minutes
Reducer Slow	5 hours	90 minutes	40 minutes

Recoatability:
After 90 mins and within 48 hours at 20°C or after 40 minutes at 60ºC.
.

LV 255 Topcoat 3K

FOR PROFESSIONAL USE ONLY

Recoatable with:
Autocoat BT LV 255 Topcoat
Autocoat BT 300 Clear
Autocoat BT 300 Clear ASG
Autocoat BT LV 853 Clear
Autocoat BT LV 850 Sealer

VOC
2004/42/IIB(d)(420)420
The EU VOC limit for this product (product category: IIB. d) in ready to use form is max 420 g/l.
The VOC content of this product in ready to use form is max. 420 g/l.

Packaging:

Autocoat BT Toner:	3.75 ltr. in 3.75 ltr. can
Autocoat BT LV 255 Converter:	3.75 ltr. in 3.75 ltr. can
Autocoat BT LV 255 Topcoat 3K Hardener:	5 ltr in 5 ltr can
Autocoat BT LV 255 Reducers:	5 ltr in 5 ltr can

Shelflife:

Autocoat BT Toner	2 years
Autocoat BT LV 255 Topcoat RM	1 year
Autocoat BT LV 255 Converter B255C	1 year
Autocoat BT LV 255 Topcoat 3K Hardener	1 year
Autocoat BT LV 255 Topcoat Reducers	1,5 years
Autocoat BT LV 255 Air Dry Additive	2 years

Product storage:
Product shelf-life is determined when products are stored unopened at 20°C
Avoid extreme temperature fluctuation.

Minimum storage temperature:	5°C
Maximum storage temperature:	35°C

sikkens
Autocoat BT

Technical Data Sheet
Topcoats
September 2022

LV 255 Topcoat 3K

FOR PROFESSIONAL USE ONLY

HEALTH & SAFETY DATA regarding
Autocoat BT LV 255 Topcoat and additives:

EB

For professional use only. (See **M**aterial **S**afety **D**ata **S**heet).
See text on the label of this product.
The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.

Akzo Nobel Car Refinish bv.
Address: Rijksstraatweg 31, PO Box 3, 2170 BA Sassenheim
Tel: +31(0)71308-6944

FOR PROFESSIONAL USE WITH SUITABLE HS&E 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 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.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.
Head Office
Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com