

# Multi Matt Clear

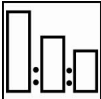



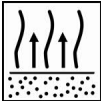


Clearcoats

02/03/2020

L1.05.13 UK & Ireland

## DESCRIPTION

Low gloss (matt) clear for application over hard dry topcoats and all Lesonal basecoats. The desired gloss level can be achieved by mixing of the Low-Gloss and Semi-Gloss components.

Mixing ratio		5 2 3	Multi Matt Clear Multi Matt Clear Hardener Multi Matt Clear Reducer	
Mixing stick		S		
Equipment		Spray gun set up: 1.2-1.4 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap	
Application		2 x 1 coat		
Flash-off		Between coats 15 minutes at 20°C	Before curing 15 minutes at 20°C	
Drying		Low-Gloss Semi-Gloss	20°C 1 hour 1.5 hours	60°C 15 minutes 20 minutes
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator		

Read complete technical data sheet for detailed product information

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## PRODUCT AND ADDITIVES

Product Multi Matt Clear Low-Gloss  
Multi Matt Clear Semi-Gloss

Hardener Multi Matt Clear Hardener

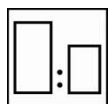
Thinner Multi Matt Clear Reducer Standard  
Multi Matt Clear Reducer Slow

Chemical Basis Multi Matt Clear Polyester resins  
Multi Matt Clear Hardener Polyisocyanate resins

## METHOD OF USE

Substrates Sanded OE Finishes  
Basecoat WB GT

### Mixing ratio



The following gloss levels can be achieved by mixing Multi Matt Clear Low-Gloss and Semi-Gloss. Spray a test panel to check the gloss level obtained as the result may be influenced by layer thickness and drying conditions.

Mix	Gloss level	Low-Gloss	Semi-Gloss
M1	Low-Gloss	100	0
M2		80	20
M3		50	50
M4		20	80
M5	Semi-Gloss	0	100

Mix Multi Matt Clear Low and Semi-Gloss by weight (see table above). The gloss level is an impression and can be judged by the gloss level swatch, but it is advised to produce a set of spray out panels

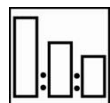
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**Mixing ratio**


By volume	By weight
5 Multi Matt Clear	100 Multi Matt Clear
2 Multi Matt Clear Hardener	42 Multi Matt Clear Hardener
3 Multi Matt Clear Reducer	55 Multi Matt Clear Reducer

Mixing stick S

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 Spraying viscosity 17-19 sec. DIN Cup 4 at 20°C
 

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 Potlife 1 hour at 20°C
 

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**Spray gun set up**


Sanding	Fluid opening:	Spraying pressure:
Spray gun:	1.2-1.4 mm	0.7 bar (at air cap)
HVLP Gravity	1.2-1.4 mm	1.7-2.2 bar (at air inlet)
LVLP/HR Gravity		

Refer to user manual spray gun used

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## APPLICATION TECHNIQUE

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**Application**


Apply 2 flowing coats and to flash-off until completely matt. (between coats and before bake)

For horizontal parts, apply 1 coat and allow to flash off. Next apply a cross coat.

(Flash-off time is influenced by the product combination used and the application conditions)

Note: This product is designed for total re-spray or edge to edge application.

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**Points of attention**

- To avoid gloss differences, make sure to mask body apertures and mouldings / badge holes.
- Spot repairs are not possible. Only edge to edge repair is possible.
- Avoid visible masking lines, since polishing is not possible.
- It is not possible to apply decals, stickers or graphics to Multi Matt Clear.

Dirt ingress after curing: Denib the dirt ingress and rework the panel.

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 Layer thickness 40 - 50 microns
 

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Equipment cleaning Use Multi Thinners or nitro cellulose thinner

Drying



			20°C	50°C	60°C
Low-Gloss Reducer Standard	Dust dry		15 min	5 min	5 min
	Dry to handle		1 hr	20 min	15 min
Low-Gloss Reducer Slow	Dust dry		25 min	10 min	10 min
	Dry to handle		2 hrs	25 min	20 min
Semi-Gloss Reducer Standard	Dust dry		20 min	5 min	5 min
	Dry to handle		1.5 hrs	25 min	20 min
Semi-Gloss Reducer Slow	Dust dry		30 min	15 min	10 min
	Dry to handle		3 hrs	30 min	25 min

Material usage Ready for use mixture at 1 µm layer thickness :

Low Gloss	335 m <sup>2</sup> /liter
Semi Gloss	320 m <sup>2</sup> /liter

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances

Product storage Avoid extreme temperature fluctuation and high humidity levels

Shelf life 1 year at 20°C

VOC 2004/42/IIIB(e)(840)620  
 The EU limit value for this product (product category : IIB.e) in ready to use form is max. 840 g/l VOC.  
 The VOC content of this product in ready to use form is max. 620 g/litre.

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