

# Multi Matt Clear

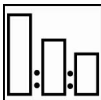
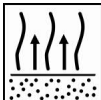
Clearcoats

02/03/2020

L1.05.13 UK &amp; 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<br>2<br>3                                                                                                        | Multi Matt Clear<br>Multi Matt Clear Hardener<br>Multi Matt Clear Reducer                    |
| Mixing stick |    | S                                                                                                                  |                                                                                              |
| Equipment    |   | Spray gun set up:<br>1.2-1.4 mm                                                                                    | Application pressure:<br>1.7-2.2 bar at the air inlet<br>HVLV max 0.6-0.7 bar at the air cap |
| Application  |  | 2 x 1 coat                                                                                                         |                                                                                              |
| Flash-off    |  | Between coats<br>15 minutes at 20°C                                                                                | Before curing<br>15 minutes at 20°C                                                          |
| Drying       |  | Low-Gloss<br>Semi-Gloss                                                                                            | 20°C<br>1 hour<br>1.5 hours<br>60°C<br>15 minutes<br>20 minutes                              |
| Protection   |  | Use suitable respiratory protection<br>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

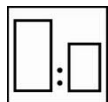
Thinner Multi Matt Clear Reducer Standard  
Multi Matt Clear Reducer Slow

|                |                           |                       |
|----------------|---------------------------|-----------------------|
| 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

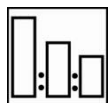
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## Mixing ratio



## By volume

|   |                           |
|---|---------------------------|
| 5 | Multi Matt Clear          |
| 2 | Multi Matt Clear Hardener |
| 3 | Multi Matt Clear Reducer  |

|     |
|-----|
| 100 |
| 42  |
| 55  |

## By weight

|                           |
|---------------------------|
| Multi Matt Clear          |
| Multi Matt Clear Hardener |
| Multi Matt Clear Reducer  |

Mixing stick S

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

|         |                |
|---------|----------------|
| Potlife | 1 hour at 20°C |
|---------|----------------|

## Spray gun set up



## Sanding

Spray gun:  
HVLP Gravity  
LVLP/HR Gravity

## Fluid opening:

1.2-1.4 mm  
1.2-1.4 mm

## Spraying pressure:

0.7 bar (at air cap)  
1.7-2.2 bar (at air inlet)

Refer to user manual spray gun used

## APPLICATION TECHNIQUE

### 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.



### 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.

|                 |                 |
|-----------------|-----------------|
| 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        | Dust dry      |  | 15 min  | 5 min  | 5 min  |
| Reducer Standard | Dry to handle |  | 1 hr    | 20 min | 15 min |
| Low-Gloss        | Dust dry      |  | 25 min  | 10 min | 10 min |
| Reducer Slow     | Dry to handle |  | 2 hrs   | 25 min | 20 min |
| Semi-Gloss       | Dust dry      |  | 20 min  | 5 min  | 5 min  |
| Reducer Standard | Dry to handle |  | 1.5 hrs | 25 min | 20 min |
| Semi-Gloss       | Dust dry      |  | 30 min  | 15 min | 10 min |
| Reducer Slow     | 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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**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 fulfil 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.

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