



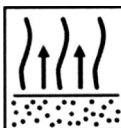


	North America	Technical Data Sheet
	Multi Matt Clear™	Clearcoat
		04/07/2017
FOR PROFESSIONAL USE ONLY		

Description

Multi Matt Clear is a three component matting finish for application over either Lesonal WB or Lesonal SB in National Rule markets. The desired gloss level can be achieved by mixing the Low Gloss and Semi-Gloss components.

	Safety Considerations Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.										
 S Stick	Mixing 5 Parts by volume Multi Matt Clear Clearcoat 2 Parts by volume Multi Matt Hardener 3 Parts by volume Multi Matt Reducer Standard or Reducer Slow										
	HVLP or Compliant Spray-Gun Set-Up: 1.3-1.4 mm	Application Air Pressure: 24-32 psi at the air inlet HVLP – 10 psi at the air cap maximum. Consult spray gun manufacturers' specifications.									
	Application 2 coat application										
	Flash Between Coats at 70°F (21°C) 15 minutes	Flash Before Force Drying at 70°F (21°C) 15 minutes									
	<table border="1" style="width: 100%; text-align: center;"> <thead> <tr> <th>Drying</th> <th>70°F (21°C)</th> <th>140°F (60°C)</th> </tr> </thead> <tbody> <tr> <td>Low Gloss clearcoat</td> <td>1 hour</td> <td>15 minutes</td> </tr> <tr> <td>Semi-Gloss clearcoat</td> <td>1.5 hours</td> <td>20 minutes</td> </tr> </tbody> </table>		Drying	70°F (21°C)	140°F (60°C)	Low Gloss clearcoat	1 hour	15 minutes	Semi-Gloss clearcoat	1.5 hours	20 minutes
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Low Gloss clearcoat	1 hour	15 minutes									
Semi-Gloss clearcoat	1.5 hours	20 minutes									

Read complete TDS for detailed product information.

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Suitable Substrates

- Lesonal WB
- Lesonal SB
- Properly prepared existing finishes

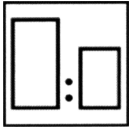
Products and Additives

Product	Multi Matt Clear Low Gloss Clearcoat	Item #546438 (1 L)
	Multi Matt Clear Semi-Gloss Clearcoat	Item #546436 (1L)
Hardeners	Multi Matt Hardener	Item #546437 (1 L)
Reducer	Multi Matt Reducer Standard	Item #546439 (1 L)
	Multi Matt Reducer Slow	Item #546440 (1 L)
Additives	Flex additive is not required for application on plastic parts.	
Ancillaries	Mix & Matt Swatch	Item #237392
	Mixing Stick #43	Item #236843

Basic Raw Materials

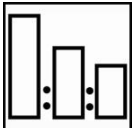
- Multi Matt Clear – Polyester resin
- Multi Matt Clear Hardener – Polyisocyanate resin
- Multi Matt Clear Reducers – Special solvent blend

Mixing – Desired Gloss Level

	<p>All gloss levels between M1-M5 can be achieved by mixing Multi Matt Clear Low Gloss and Semi-Gloss Clearcoat by weight. The gloss level can be judged by using the gloss level swatch, however, it is recommended to create a reference spray out.</p> <p>Gloss levels will vary depending on the following:</p> <ul style="list-style-type: none"> • Basecoat type • Application technique • Flash time between coats • Flash time before bake • Surface preparation • Temperature and humidity • Accuracy of mixing • Clearcoat Filmbuild, the higher the Filmbuild the higher the gloss
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Gloss Level	60° Gloss Achieved	Multi Matt Clear Low Gloss Clearcoat (Weight)	Multi Matt Clear Semi-Gloss Clearcoat (Weight)
M1 – Low Gloss	5 – 10	100 parts	0 parts
M2	10 – 15	80 parts	20 parts
M3	25 – 30	50 parts	50 parts
M4	40 – 45	20 parts	80 parts
M5 – Semi-Gloss	80 - 85	0 parts	100 parts

Mixing

 S Stick	Volume Mix		Weight Mix	
	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

Note: Stir Multi Matt Clear before use and use a 125 micron paint strainer prior to painting.


Viscosity When Mixed

 DIN #4	17-19 seconds	Measured with a DIN #4 viscosity cup at 70°F (21°C).
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Pot-Life When Mixed


Product Mix	70°F (21°C)
Multi Matt Clear Ready to Spray	1 hour

Spray Gun Set-Up

	Consult spray gun manufactures instructions for specific spray gun pressure specifications.		
	Spray Gun	Fluid Tip	Application Pressure
	HVLP Gravity Fed	1.3-1.4 mm	Max 10 psi at cap
Compliant Gravity Fed	1.3-1.4 mm	24-32 psi	

Application

	<p>Apply 2 coats allowing complete flash off until matt. For horizontal panels, apply 1 coat and allow to flash followed by a cross coat. This product is designed for total respray or edge to edge application</p> <p>Allow a flash off time between coats of 15 minutes. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.</p>
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Film Thickness – Using Suitable Application


2 Coats will achieve a thickness of 1.6-2.0 mils (40-50 µm).

Drying / Curing Time


Drying times are stated a recommended application method, film thickness and object temperature.

		Multi Matt Clear Low Gloss		Multi Matt Clear Semi-Gloss	
		Standard Reducer	Slow Reducer	Standard Reducer	Slow Reducer
68°F (20°C)	Dust Free	15 minutes	25 minutes	20 minutes	30 minutes
	Dry to Handle	1 hour	2 hours	1.5 hours	3 hours
122°F (50°C)	Dust Free	5 minutes	10 minutes	5 minutes	15 minutes
	Dry to Handle	20 minutes	25 minutes	25 minutes	30 minutes
140°F (60°C)	Dust Free	5 minutes	10 minutes	5 minutes	10 minutes
	Dry to Handle	15 minutes	20 minutes	20 minutes	25 minutes


*Dry to handle – Following the drying cycle at 140°F (60°C) object temperature, allow the Multi Matt Clear to cool down fully to ambient temperature.

	<p>Drying / Curing with short wave light IR equipment and a surface distance of 20 – 27 inches (50 – 70cm). The object temperature must not reach a temperature above 212°F (100°C).</p> <ul style="list-style-type: none"> Allow 15 minute flash off before infra-red curing. Cure 2 minutes on low power followed directly by a 6 minute full power cure.
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Cleaning of Equipment


	Clean equipment using Lesonal Cleaning Solvent.
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Recoating

	Recoating matte clears is not recommended without properly sanding and preparing the surface and repeating the repair process.
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Polishing / De-Nibbing

	<p>De-Nibbing is not recommended as dust inclusion cannot be removed by polishing. Automatic car washes and wax cannot be used. Do not use rough cloth or paper towel to clean the repair surface.</p>
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Theoretical Coverage

	<p>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.</p> <ul style="list-style-type: none"> • 13.4 m² / liter • 546 Sq. ft. / gallon
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VOC / Regulatory Information

	<p>VOC is reported ready to spray:</p> <p>Multi Matt Clear Low Gloss with Standard or Slow Reducer 4.88-4.97 lbs/gal (586-596 g/L)</p> <p>Multi Matt Clear Semi-Gloss with Standard or Slow Reducer 5.00-5.07 lbs/gal (601-608 g/L)</p>
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Product Storage


	<p>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).</p>	
	Multi Matt Clear Low Gloss Clearcoat	2 years
	Multi Matt Clear Semi-Gloss Clearcoat	2 years
	Multi Matt Clear Hardener	1 year
	Multi Matt Clear Reducer Standard	2 years
	Multi Matt Clear Reducer Slow	2 years

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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 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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Matt Finishes Cleaning and Maintenance

Description

This following information describes the best practices in caring for Matt Finishes. Vehicle manufactures are using Matt Finishes within their range of options and great care should be taken during use and cleaning of this type of finish. The information hereby given is based on the use of the Lesonal brand products and should not be used as a reference document for original finishes.

General Remarks

This paint system is the equivalent to systems recommended by all of the major motor manufacturers, and is applied in state of the art facilities under strict quality control standards.


Vehicles are often subjected to continual and regular cleaning using a wide range of chemical cleaners and varied cleaning types of equipment.

In the majority of cases this causes no problems but instances do occur when the cleaning process can damage the paint film, usually irreversibly.

Whatever the choice of cleaning, either mechanical, or manual, the surface dirt should be removed by a non-contact method such as power washing, preferably with cold or slightly warm water.

Cleaning Method and Maintenance

When:	When a vehicle is freshly painted the paint film is at its most sensitive with respect to attack by chemical cleaner and the cleaning process. It is recommended that freshly painted vehicles be allowed a minimum of 7 days before being subjected to any form of chemical cleaning process, ideally extended to 21 days.
Method:	<p>Thoroughly rinse the vehicle with clean cold water preferably using a hose or a pressure washer to remove any loose road traffic film and dust particles. The use of a high pressure steam washer is not recommended.</p> <p>The vehicle can then be washed by using a PH neutral based soap and soft sponge to minimize the risk of any type of abrasions. Use a cleaning soap that is PH neutral possibly a good quality wash n wax will be ideal for this operation. At all times avoid excessive rubbing of the paint surface as this could lead to the surface increasing in gloss as compared to other areas.</p> <p>Rinse thoroughly with clean cold water preferably using a hose or a pressure washer. Allow the vehicle to dry naturally until only a few water drops are present on the surface. To remove the remaining water drops and to prevent any water marking dry gently using a soft chamois avoiding excessive rubbing of the paint surface.</p>

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Notes:	<p>Avoid washing the vehicle in direct sunlight and or when the vehicle surface temperature is excessive i.e. above 77°F (25°C).</p> <p>Any contamination found on the paint surface should be removed immediately i.e. bird droppings or insects. Thoroughly soak the affected area with clean water preferably with a hose or high pressure washer to soften the contaminated area and remove gently using a soft sponge and PH neutral soap. For difficult to remove contamination it might be necessary to use a solution designed specifically to remove insects found in car care shops. Care should be taken not to allow any type of solution to dry on the paint surface as this can damage the surface even further. Always follow the manufacturer's instructions on use.</p> <p>* Never use a car wash or any type of brush to wash/clean matt finishes</p>
Maintenance:	<p>It is not possible to carry out any type of polishing or waxing to the matt finish. Polishing or waxing of the matt finish will only lead to areas being left glossy due to the rubbing technique and abrasive compounds found in polishing materials.</p> <p>Regular washing is the only way possible to maintain the paint surface as described above. Remove contamination as soon as it becomes visible using the method detailed above to prevent damage.</p> <p>Particular care should also be taken when opening and closing doors, bonnet and boot lid as excessive rubbing around handle areas will also lead to the area becoming glossy. Please note that once an area increases in gloss the only remedy is to repaint the affected area(s).</p>