

Multi Matt Clear

LESONAL

Technical Data Sheet

27 / 01 / 2018

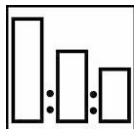
L1.05.13 UK & Ireland

Clearcoats

Description

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

Mixing ratio



5 Lesonal Multi Matt Clear
2 Lesonal Multi Matt Clear Hardener
3 Lesonal Multi Matt Clear Reducer

Mixing stick

**S**

Equipment

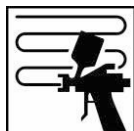


Spray gun set-up:
1.2-1.4 mm

Application pressure:
2 – 4 *

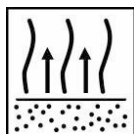
*Refer to user manual spraygun used

Application



2 x 1 coat
Allow to become matt between coats

Flash-off



Between coats
15 minutes at 20°C

Before curing
15 minutes at 20°C

Drying



| | | |
|------------|-----------|------------|
| 20°C | | 60°C |
| Low Gloss | 1 hour | 15 minutes |
| Semi Gloss | 1,5 hours | 20 minutes |

Protection



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

Read complete technical data sheet for detailed product information

Description

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

Product and additives

| | |
|------------------|--|
| Product | Lesonal Multi Matt Clear Low Gloss Lesonal Multi Matt Clear Semi Gloss |
| Hardeners | Lesonal Multi Matt Clear Hardener |
| Thinners | Lesonal Multi Matt Clear Reducer Standard Lesonal Multi Matt Clear Reducer Slow |

Chemical Basis

| | |
|-----------------------------------|-----------------------|
| Lesonal Multi Matt Clear | Polyester resin |
| Lesonal Multi Matt Clear Hardener | Poly-isocyanate resin |
| Lesonal Multi Matt Clear Reducers | A blend of solvents |

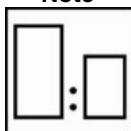
Method of use

Suitable substrates

Basecoat WB
Basecoat WB GT
Sanded hard dry clearcoats/ topcoats

Mixing Ratios

Note



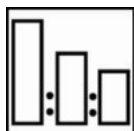
The following gloss levels can be achieved by mixing the Multi Matt Clear Low Gloss with Multi Matt Clear Semi Gloss. It is advisable to spray a test panel to check the gloss level obtained as the final result may be influenced :

- the layer thickness applied (horizontal/vertical)
- the drying conditions
- humidity

| Mix | Gloss level | % Mult Matt Clear Low Gloss | % Mult Matt Clear Semi Gloss |
|-----------|-------------------|-----------------------------|------------------------------|
| M1 | Low Gloss | 100 | 0 |
| M2 | | 80 | 20 |
| M3 | | 50 | 50 |
| M4 | | 20 | 80 |
| M5 | Semi Gloss | 0 | 100 |

All gloss levels between M1 and M5 can be achieved by using the Low Gloss and the Semi Gloss components alone or by mixing them together by weight (see table above). The gloss level is an impression and can be judged by the gloss level swatch but the advice is to produce your own sprayout

Mixing



| | By volume | Grams | By weight |
|-------|---------------------------|-------|---------------------------|
| Parts | | | |
| 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 |

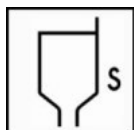
Use Lesonal Mixing Stick S

Note: Stir Multi Matt Clear before use

Note: Always use a paint strainer of max 125 Micron

Note: Make sure to mask body apertures to avoid gloss differences.

Viscosity



17-19 seconds DIN Cup 4 at 20°C

Spraying pressure



| Spraygun (gravity Feed) | Fluid opening | Spraying pressure |
|-------------------------|---------------|-------------------------|
| LVLP (HR) | 1.2-1.4 mm | 2-3 bar (at air inlet)* |
| HVLP | 1.2-1.4 mm | 0.7 bar (at air cap)* |
| Conventional | 1.2-1.4 mm | 3-4 bar (at air inlet)* |

*Refer to user manual spraygun used

Application



Apply 2 flowing coats, allowing 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.

(This time will be very much influenced by the product combination used, and the application conditions.)

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

Pot life

1 hour at 20°C

Drying Times



| Lesonal Multi Matt Clear Low gloss | | Lesonal Multi Matt Clear Semi Gloss | |
|---------------------------------------|-----------------|--|-----------------|
| Reducer Standard | Reducer Slow | Reducer Standard | Reducer Slow |

| 20°C | Dust dry | 15 min | 25 min | 20 min | 30 min |
|------|----------------|--------|---------|----------|---------|
| | Dry to handle* | 1 hour | 2 hours | 1½ hours | 3 hours |

| 50°C | Dust dry | 5 min | 10 min | 5 min | 15 min |
|------|----------------|--------|--------|--------|--------|
| | Dry to handle* | 20 min | 25 min | 25 min | 30 min |

| 60°C | Dust dry | 5 min | 10 min | 5 min | 10 min |
|------|----------------|--------|--------|--------|--------|
| | Dry to handle* | 15 min | 20 min | 20 min | 25 min |

Infra Red Dying

Please refer to Technical Data Sheet L9.01.01

Layer Thickness

40-50 microns in two coats

VOC content

2004/42/Ilb(e)(840)620

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 840 g/liter VOC.
The VOC content of this product in ready to use form is max. 620 g/liter.

Theoretical coverage

Ready for use mixture at 1 µm layer thickness:

Low Gloss 335 m²/liter
Semi Gloss 320 m²/liter

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

Cleaning Equipment

Use Multi Thinners or nitro cellulose thinner.

Shelflife

1 year at 20°C for Multi Matt Clears, Hardener and Reducers

Notes

Multi Matt Clear can be applied to original hard dry topcoats and clearcoats only after following the correct preparation and degreasing steps.

Polishing is not possible so extra care should be taken to avoid dust ingress.

Spot repair is not possible, only complete panels should be refinished.

Take care when masking to avoid masking lines.

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