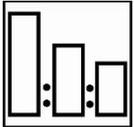


Autoclear® Mix & Matt

FOR PROFESSIONAL USE ONLY

Description

Two-pack, matting finish for application over Autobase Plus or Autowave.
The desired gloss level can be achieved by mixing of the Low and Semi Gloss components.



100 Autoclear Mix & Matt
40 Autoclear Mix & Matt Hardener
60 Autoclear Mix & Matt Reducer



Use Sikkens measuring stick

43

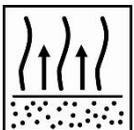


Spray gun set-up:
1.3 – 1.4 mm

Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



2 x 1 coat



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 | 1½ hour | 20 minutes |



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

Autoclear® Mix & Matt

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Description

Two-pack, matting finish for application over Autobase Plus or Autowave.
The desired gloss level can be achieved by mixing of the Low and Semi Gloss components.

Product and additives

| | |
|------------------|--|
| Clearcoat | Autoclear Mix & Matt Low Gloss Autoclear Mix & Matt Semi Gloss |
| Hardener | Autoclear Mix & Matt Hardener |
| Reducer | Autoclear Mix & Matt Reducer Standard Autoclear Mix & Matt Reducer Slow |

No plasticiser (Elast-O-Actif) required for application on plastic car parts.

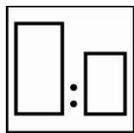
Basic raw materials

| | |
|--------------------------------|-----------------------|
| Autoclear Mix & Matt: | Polyester resin |
| Autoclear Mix & Matt Hardener: | Poly-isocyanate resin |

Suitable substrates

Autowave; after a minimum flash off time of 15 minutes at 25°C
Autowave 2.0; until completely matt and dry
Autobase Plus; after a minimum flash off time of 15 minutes at 20°C

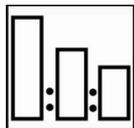
Gloss level



| | 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 |

All gloss levels between M1 and M5 can be achieved by mixing Autoclear Mix & 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 preferably by own created spray outs.

Mixing



| By volume | | By weight | |
|------------|-------------------------------|------------|-------------------------------|
| 100 | Autoclear Mix & Matt | 100 | Autoclear Mix & Matt |
| 40 | Autoclear Mix & Matt Hardener | 42 | Autoclear Mix & Matt Hardener |
| 60 | Autoclear Mix & Matt Reducer | 55 | Autoclear Mix & Matt Reducer |

Use measuring stick No. 43

Note: Stir Autoclear Mix & Matt before use.

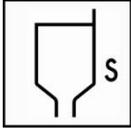
Note: Always use a paint strainer with a maximum mesh of 125 micron.

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

Autoclear® Mix & Matt

FOR PROFESSIONAL USE ONLY

Viscosity



17-19 seconds – DIN Cup 4 at 20°C

Spray gun set-up / application pressure



Spray gun
Gravity feed

Fluid tip – set-up
1.3-1.4 mm

Application pressure
1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

Application process



Apply 2 coats, allowing to flash-off until completely matt.

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

Note: This product is designed for total respray or edge to edge application.

Pot-life

1 hour at 20°C

Drying times

Allow to flash-off until completely matt.



| | | Autoclear Mix & Matt Low Gloss | | Autoclear Mix & Matt 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 |

Autoclear® Mix & Matt

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Drying times (continued)

*Dry to handle

Following the drying cycle at 60°C object temperature, allow the Autoclear Mix & Matt to cool down fully to ambient temperature.

Drying times (continued)



Allow 15 minutes flash off prior to infra red curing.

2 minutes at low intensity + 6 minutes at high intensity.

The panel must not reach a temperature above 100°C while curing.
For additional infra red drying information; see TDS S9.01.01

Film thickness

By using the recommended application:

40-50 µm

Theoretical coverage

Ready for use mixture at 1 µm layer thickness:

Low Gloss

335 m²/liter

Semi Gloss

320 m²/liter

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

The VOC content of this product in ready to use form is max. 620 g/liter.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.

Avoid extreme temperature fluctuation.

Product shelf life data see TDS S9.01.02

Maintenance

For cleaning and maintenance of matt finishes, see TDS S8.06.09

Autoclear® Mix & Matt

FOR PROFESSIONAL USE ONLY

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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.

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