

Autoclear[®] Mat

FOR PROFESSIONAL USE ONLY

Description

Two-pack, colourless matting finish for application over hard dry topcoats, Autobase Plus or Autowave. If applied in conjunction with one of the specifically mentioned Sikkens clearcoats any desired gloss level can be achieved by reduce the gloss level of the clearcoat mixed with.

Product and additives

Autoclear Mat

Basic raw materials

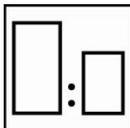
Autoclear Mat; Polyester resin
Clearcoat Hardeners; Poly-Isocyanate resins

Suitable substrates

Existing (hard dry) finishes
Autobase Plus
Autowave

Note: not all clearcoats are suitable for all indicated substrates, check basecoat TDS for clearcoat suitability.

Gloss level adjustments



The following gloss levels can be achieved by mixing Autoclear Mat by volume in different ratios with the available Sikkens clearcoat. Due to the different gloss levels of the clearcoats (different reflection values); mixing ratios can differ per clearcoat. The gloss level is an impression and can be judged by the structure/gloss level swatch but preferably by own created spray outs.

Gloss level impression	Clearcoat by volume	Autoclear Mat by volume
High gloss	100	0
	70	30
Semi gloss	50	50
	30	70
Matt	0	100

Read complete TDS for detailed product information

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Mixing


After the right gloss level is determined by use of either the gloss level swatch or own created spray outs, mix the Autoclear Mat with the required amount of the clearcoat. Then follow the indicated mixing ratios with the hardener/reducer according the clearcoat TDS.

Following clearcoats require different ratios between the clearcoat mixture and hardener then indicated in the clearcoat TDS to achieve different gloss levels tough optimum system properties.

Autoclear Plus HS (Autobase Plus)

Autoclear Mat	Autoclear Plus HS	Clearcoat mix	P Hardener	Plus Reducer
100	0	100 parts	50 parts	30 parts
50	50	100 parts	50 parts	10 parts
0	100	Mixing ratio according product TDS		

Autoclear Rapid (Autobase Plus)

Autoclear Mat	Autoclear Rapid	Clearcoat mix	P Hardener	Plus Reducer
100	0	100 parts	50 parts	30 parts
50	50	100 parts	50 parts	10-20 parts
0	100	Mixing ratio according product TDS		

Autoclear Rapid (Autobase Plus and (Autowave up to single panel)

Autoclear Mat	Autoclear Rapid	Clearcoat mix	Autoclear Rapid Hardener	Plus Reducer
100	0	100 parts	50 parts	20 parts
50	50	100 parts	50 parts	10-20 parts
0	100	Mixing ratio according product TDS		

Autoclear LV Superior (Autowave)

Autoclear Mat	Autoclear LV Superior	Clearcoat mix	LV Hardener	LV Reducer
100	0	3 parts	1 part	1 part
50	50	3 parts	1 part	1 part
0	100	Mixing ratio according product TDS		

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Pot-life

Autoclear Plus HS	3-4 hours at (20°C)
Autoclear LV Superior Fast / Autoclear Rapid	30 minutes at (20°C)
Autoclear LV Superior Medium	1 hour at (20°C)
Autoclear LV Superior Slow	1½ hours at (20°C)

In general the pot life indicated in the TDS of the above mentioned clearcoats can be used as guideline. Pot-life is dependent on hardener, reducer/ thinner or accelerator selection.
A higher amount of Autoclear Mat in the clearcoat mixture will give a slight longer pot life.

Drying times



The drying is dependent on the mixing ratio of Autoclear Mat and the selected clearcoat. Drying times of these clearcoat mixtures will be slightly longer than indicated at the selected clearcoat TDS. The following drying times are for 100% Autoclear Mat when mixed with indicated clearcoat hardener:

Hardeners	(20°C)	(60°C)
P25 Hardener	4 hours	30 minutes
P35 Hardener	5 hours	55 minutes
Autoclear Rapid	4 hours	30 minutes
Autoclear LV Superior Fast		35 minutes
Autoclear LV Superior Medium		45 minutes
Autoclear LV Superior Slow		60 minutes



Allow 5 minutes flash off prior to infra red curing
 The panel must not reach a temperature above (100°C) while curing.
For additional infra red drying information; see TDS S9.01.01

Autoclear Mat is a medium solid clearcoat. The material usage of a medium solid clearcoat is higher than any high solid clearcoat. The higher the concentration of Autoclear Mat in the clearcoat mixture, the higher the theoretical material usage will become and is therefore not reliable to indicate.

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

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FOR PROFESSIONAL USE ONLY**VOC**

The VOC content of this product in ready to use form is max.615 g/liter.

VOC level overview:

Hardener:

P25 Hardener	600 g/ liter
P35 Hardener	600 g/ liter
Autoclear LV Superior Hardener (100:60:20)	564 g/ liter

Product storage

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

Avoid extreme temperature fluctuation.

- o *Product shelf life data see TDS S9.01.02*

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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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