

TECHNICAL INFORMATION

DYNACOAT CLEAR MATT

— D1.05.25 UK & Ireland

Dynacoat Clear Matt is a matt clearcoat that can be used either on its own or mixed with one of the Dynacoat Clearcoats mentioned below to obtain the required gloss level. Clear Matt is a very easy to apply matt clearcoat. Various Dynacoat Hardeners and thinners / activators are available to adjust the clear to different application conditions and the regional VOC legislation.



MIXING RATIO CLEAR MATT

2 Dynacoat Clear Matt
1 Dynacoat Flexi Hardeners
10% Dynacoat Thinners



MIXING STICK

Use Dynacoat mixing stick D1



EQUIPMENT

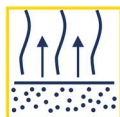
Spray gun set-up: 1.2 - 1.4mm
Application pressure: 1.7 - 2.2 bar at the air inlet*

*See user manual spray gun



APPLICATION

2 x 1 coat
First apply a flowing closed layer, followed by a full flowing layer



FLASH-OFF

5 - 10 minutes between coats
10 - 15 minutes before curing



DRYING

	20°C	60°C
Dynacoat Flexi Hardener	6 - 7 hours	20 - 25 minutes



PROTECTION

Use suitable respiratory protection. AkzoNobel Vehicle Refinishes recommends the use of a fresh air supply respirator.

Read complete technical data sheet for detailed product information

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**MIXING RATIO CLEAR 9000**

- 2 Dynacoat Clear Matt mixed with Clear 9000
- 1 Dynacoat Hardener 420
- 10% Dynacoat Thinner 420

**MIXING RATIO CLEAR 6000 HS AS**

- 2 Dynacoat Clear Matt mixed with Clear 6000HS AS
- 1 Dynacoat Flexi Hardeners
- 10% Dynacoat Thinners

**MIXING RATIO CLEAR UHS Speed**

- 2 Dynacoat Clear Matt mixed with Clear UHS Speed
- 1 Dynacoat Hardener UHS
- 10% Dynacoat Thinner UHS Fast / Standard

**MIXING STICK**

Use Dynacoat mixing stick D1

**EQUIPMENT**

Spray gun set-up: 1.2 - 1.4mm
Application pressure: 1.7 - 2.2 bar at the air inlet*

*See user manual spray gun

**APPLICATION**

2 x 1 coat

First apply a flowing closed layer, followed by a full flowing layer

**FLASH-OFF**

5 - 10 minutes between coats
10 - 15 minutes before curing

**DRYING**

Clear 6000 HS AS
Clear 9000
Clear UHS Speed

20°C

6 hours
3 hours
3 hours

60°C

35 minutes
30 - 45 minutes
10 - 15 minutes

**PROTECTION**

Use suitable respiratory protection. AkzoNobel Vehicle Refinishes recommends the use of a fresh air supply respirator.

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PRODUCT AND ADDITIVES

Dynacoat Clear Matt
 Dynacoat Flexi Hardener Fast / Medium
 Dynacoat Hardener 420
 Dynacoat Hardener UHS
 Dynacoat Thinner Fast / Medium
 Dynacoat Thinners 420

BASIC RAW MATERIALS

Dynacoat Clear Matt: polyol resins
 Dynacoat Hardeners: poly-isocyanate resins

SUITABLE SUBSTRATES

Waterborne and solventborne basecoats
 Existing finishes

MIXING

The following gloss levels can be achieved by mixing Dynacoat Clear Matt with Dynacoat Clear 6000 HS AS.
 This table is a guideline for the different gloss levels.
 It is advised to spray a test panel to check the gloss level, as the result may be influenced by:
 a) the layer thickness applied
 b) the drying conditions

	Gloss Units
Matt finish	
100% Dynacoat Clear Matt	± 10 - 20
Eggshell finish (v/v)	
4 Dynacoat Clear Matt 1 Dynacoat Clear 6000 HS AS	± 30 - 40
Semi-gloss finish (v/v)	
3 Dynacoat Clear Matt 2 Dynacoat Clear 6000 HS AS	± 50 - 70
1 Dynacoat Clear Matt 1 Dynacoat Clear 6000 HS AS	± 70 - 80

2 Dynacoat Clear Matt 100% or mixed with Clear 6000HS AS
 1 Dynacoat Flexi Hardeners
 10% Dynacoat Thinners

Use Mixing stick D1

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MIXING

<p>The following gloss levels can be achieved by mixing Dynacoat Clear Matt with Dynacoat Clear 9000 / UHS Speed</p> <p>This table is a guideline for the different gloss levels.</p> <p>It is advised to spray a test panel to check the gloss level, as the result may be influenced by:</p> <p>a) the layer thickness applied</p> <p>b) the drying conditions</p>	
Matt finish	Gloss Units
100% Dynacoat Clear Matt	± 10 – 20
Eggshell finish (v/v)	
4 Dynacoat Clear Matt 1 Dynacoat Clear 9000 / UHS Speed	± 35 - 45
Semi-gloss finish (v/v)	
3 Dynacoat Clear Matt 2 Dynacoat Clear 9000 / UHS Speed	± 60 – 75

2 Dynacoat Clear Matt mixed with Clear 9000*
 1 Hardener 420
 10% Dynacoat Thinner 420
** 3:1:1 if only Dynacoat Clear Matt is used with Hardener 420*

Use Mixing stick D1

2 Dynacoat Clear Matt mixed with Clear UHS Speed*
 1 Hardener UHS
 10% Thinner UHS Fast / Thinner UHS Standard
** 3:1:1 if only Dynacoat Clear Matt is used with Hardener UHS*

Use Mixing stick D1

VISCOSITY

13-18 seconds DIN Cup 4 at 20°C

POTLIFE

A Component / Mixture Clear / Hardener used

Dynacoat Flexi Hardeners	2 - 3 hours at 20°C
Hardener 420:	30 - 45 minutes at 20°C
Hardener UHS	45 min – 3 hrs at 20°C

SPRAY GUN FLUID TIP AND WORKING PRESSURE

Spray gun:	Fluid tip:	Pressure:
Gravity feed:	1.2 - 1.4 mm	1.7 – 2.2 bar (see user manual spray gun) HVLP max 0.7 at air cap

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APPLICATION Apply a flowing closed layer, allowing for a 5 - 10 minutes flash-off time at 20°C.
(flash off time depends on hardener / thinner combination used)
Next, apply a full flowing layer allowing for a 10 - 15 minutes flash-off time at 20°C before bake.

**This time can be greatly influenced by the conditions at the time of application*

CLEANING OF EQUIPMENT Use solvent based Guncleaner, or nitrocellulose thinner

FILM THICKNESS Per coat: 25-30 µm
Recommended application (2 layer): 45-60 µm

DRYING	Dry to handle	
	20°C	60°C
	Flexi Hardener Medium	6 hrs

IR DRYING Dry to handle after 4 minutes low power 8 minutes high power

THEORETICAL COVERAGE Ready for use mixture at 1 µm layer thickness: ± 367 m²/litre
The practical coverage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

PRODUCT STORAGE Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.

SHELF LIFE 4 years at 20°C.

VOC **2004/42/IIb(e)(840)600**
The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/litre of VOC.
The VOC content of this product (100% Dynacoat Clear Matt) in ready to use form is max. 600 g/litre RTS mixture



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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 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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