


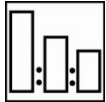


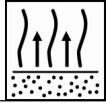



# Multi Matt Clear™

Programmed System Technique (PST)  
Clearcoat  
09/19/2022

## DESCRIPTION

Lesonal Multi Matt 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 combinations of Multi Matt Low Gloss and Semi-Gloss.

<b>Safety Considerations</b>	<ul style="list-style-type: none"> <li>• Use suitable personal protection.</li> <li>• AkzoNobel recommends the use of a fresh air supply respirator.</li> <li>• Refer to the product Safety Data Sheet (SDS) for more complete safety information.</li> </ul>		
			
<b>Suitable Substrates</b>	<ul style="list-style-type: none"> <li>• Properly prepared existing finishes</li> </ul>		
			
<b>Mixing</b>	<b>To Make M3 Matte Gloss (25-30 Gloss Units) Clearcoat Combine</b>		
	1 Parts Lesonal Multi Matt Low-Gloss 1 Parts Lesonal Multi Matt Semi-Gloss	<b>- THEN -</b>	
<b>RTS Mixing</b>	5 Parts Lesonal Multi Matt Low-Gloss + Semi-Gloss combination 2 Parts Lesonal Multi Matt Hardener 3 Parts Lesonal Multi Matt Reducer Standard or Reducer Slow		
			
<b>STICK #S</b>			
<b>Equipment</b>	<b>HVLP or Compliant Spray-Gun Set-Up:</b> 1.3-1.4 mm	<b>Application Air Pressure:</b>	
	24-32 psi at the air inlet HVLP – 10 psi at the air cap maximum. Consult spray gun manufacturer specifications.		
<b>Application</b>	2 coat application		
			
<b>Flash off</b>	<b>Between coats at 70°F (21°C)</b> 15 minutes	<b>At 70°F (21°C) before Force Drying</b> 15 minutes	
			
<b>Drying time</b>	<b>Drying</b> Low Gloss clearcoat Semi-Gloss clearcoat	<b>70°F (21°C)</b> 1 hour 1.5 hours	<b>140°F (60°C)</b> 15 minutes 20 minutes
			

Read complete TDS for detailed product information

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## 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.

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**Suitable Substrates**

- Properly prepared existing finishes

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## PRODUCT AND ADDITIVES

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<b>Product</b>	Multi Matt Clear Low Gloss Clearcoat	Item #546438 (1 L)
	Multi Matt Clear Semi-Gloss Clearcoat	Item #546436 (1L)

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<b>Hardeners</b>	Multi Matt Hardener	Item #546437 (1 L)
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<b>Reducer</b>	Multi Matt Reducer Standard	Item #546439 (1 L)
	Multi Matt Reducer Slow	Item #546440 (1 L)

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<b>Additives</b>	Flex additive is not required for application on plastic parts.	
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<b>Ancillaries</b>	Multi Matt Swatch	Item #237392
	Mixing Stick #43	Item #236843

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## METHOD OF USE

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<b>Basic Raw Materials</b>	<ul style="list-style-type: none"><li>• Multi Matt Clear – Polyester resin</li><li>• Multi Matt Clear Hardener – Polyisocyanate resin</li><li>• Multi Matt Clear Reducers – Special solvent blend</li></ul>
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<b>Mixing – Desired Gloss Level</b>	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.
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Gloss levels will vary depending on the following:

- Basecoat type
  - Application technique
  - Flash time between coats
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- Flash time before bake
- Surface preparation
- Temperature and humidity
- Accuracy of mixing
- Clearcoat thickness, the higher the film build the higher the gloss.

## Mixing



- For easy mixing, it is suggested to use the mixing function within MIXIT or Color Manager computerized mixing system.



BY WEIGHT

- If computerized mixing is not available, use the tables below to mix Lesonal Multi Matt by weight.

Pint Mixing	M1 Low-Gloss	M2	M3 Matte-Gloss	M4	M5 Semi-Gloss
Multi Matt Low-Gloss	239g	189g	117g	46g	X
Multi Matt Semi-Gloss	X	47g	117g	185g	241g
Multi Matt Hardener	99g	99g	99g	99g	105g
Multi Matt Reducer	130g	130g	124g	119g	118g

Quart Mixing	M1 Low-Gloss	M2	M3 Matte-Gloss	M4	M5 Semi-Gloss
Multi Matt Low-Gloss	475g	377g	233g	92g	X
Multi Matt Semi-Gloss	X	94g	233g	370g	483g
Multi Matt Hardener	199g	199g	199g	199g	209g
Multi Matt Reducer	260g	260g	248g	238g	236g

### Mixing Notes:

- Either Multi Matt Standard Reducer or Multi Matt Slow Reducer may be used in the mix for reduction.
- Stir mixed Multi Matt before use and use a 125-micron paint strainer prior to painting.

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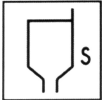
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**Viscosity  
When Mixed**

**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**  
Multi Matt Clear Ready to Spray

**70°F (21°C)**  
1 hour



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**Spray Gun  
Set-Up**

**Consult spray gun manufactures instructions for specific spray gun pressure specifications.**

**Spray Gun**  
HVLP Gravity Fed  
Compliant Gravity Fed

**Fluid Tip**  
1.3-1.4 mm  
1.3-1.4 mm

**Application Pressure**  
Max 10 psi at cap  
Per manufacturer specifications



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**Application**

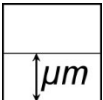
- Apply 2 coats allowing complete flash off until matt. For horizontal panels, apply 1 coat and allow to flash followed by a cross coat. This product is designed for total respray or edge to edge application
- Allow a flash off time between coats of 15 minutes. Flash time will be dependent on ambient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



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**Film Thickness**

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



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## DRYING / CURING TIME

**Drying / Curing Time**      Drying times are stated at recommended application method, film thickness and object temperature



	<b>Multi Matt Clear</b>		<b>Multi Matt Clear</b>	
	<b>Low Gloss</b>		<b>Semi-Gloss</b>	
	Standard Reducer	Slow Reducer	Standard Reducer	Slow Reducer

Temperature	Multi Matt Clear Low Gloss		Multi Matt Clear Semi-Gloss	
	Dust Free	Dry to Handle	Dust Free	Dry to Handle
70°F (21°C)	15 minutes	1 hour	20 minutes	30 minutes
122°F (50°C)	5 minutes	20 minutes	5 minutes	15 minutes
140°F (60°C)	5 minutes	15 minutes	5 minutes	10 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.

### Drying / Curing – IR or UV



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).

- Allow 15-minute flash off before infra-red curing.
- Cure 2 minutes on low power followed directly by a 6-minute full power cure.

## ADDITIONAL INFORMATION

**Cleaning of Equipment**      • Clean equipment using Lesonal Cleaning Solvent.



**Recoating**      • Recoating matte clear required properly sanding and preparing the surface and repeating the repair process.



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## Polishing / De-Nibbing

- De-Nibbing is not recommended as dust inclusion cannot be removed by polishing

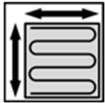


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## Theoretical Coverage

Actual coverage is dependent on many factors. These may include: the shape of the object, surface smoothness, application technique and other application variables.

- Theoretical Coverage: 546 ft<sup>2</sup> / gallon (13.4 m<sup>2</sup> / liter)



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## VOC / Regulatory Information

VOC is reported ready to spray:

- Multi Matt Clear with Standard or Slow Reducer: <5.07 lb/gal (≤607 g/L)



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## Product Storage

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).



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

- ✓ Refer to the Product Shelf Life Overview TDS or the current price list for the most up-to-date shelf-life information.

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## Matt Finishes Cleaning and Maintenance

The 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 Sikkens brand products and should not be used as a reference document for original finishes.

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## General Remarks

- This paint system is the equivalent to systems recommended by major motor manufacturers which 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, 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.
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## 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 cleaners 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:

1. 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.
2. 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.
3. 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.

### Notes

- Avoid washing the vehicle in direct sunlight and or when the vehicle surface temperature is excessive i.e. above 77°F (25°C).
- 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.
- Automatic car washes and wax cannot be used.
- Do not use rough cloth or paper towel to clean the repair surface.

**\* Never use a car wash or any type of brush to wash/clean matt finishes**

### Maintenance:

- 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.
- 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.
- 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).

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**AkzoNobel Inc., North America**  
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**TelepHone: 800-618-1010**

## **FOR PROFESSIONAL USE WITH SUITABLE HSE 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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