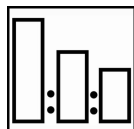


# Autoclear Mix & Matt

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



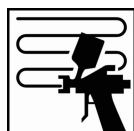
Use Sikkens measuring stick

**43**

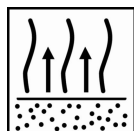


Spray gun set-up:  
 1.3 – 1.4 mm

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

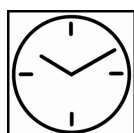


2 x 1 coat



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.

Read complete TDS for detailed product information



# 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.

## Product and additives

- Clearcoat** AutoclearMix & Matt Low Gloss  
 AutoclearMix & 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.*

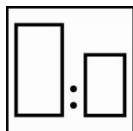
## Basic raw materials

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

## Suitable substrates

- Autowave  
 Autobase Plus

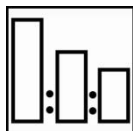
## Gloss level



	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	
<b>100</b>	Autoclear Mix & Matt	<b>100</b>	Autoclear Mix & Matt
<b>40</b>	Autoclear Mix & Matt Hardener	<b>42</b>	Autoclear Mix & Matt Hardener
<b>60</b>	Autoclear Mix & Matt Reducer	<b>55</b>	Autoclear Mix & Matt Reducer

Use measuring stick No. 43

**Note:** Stir Autoclear Mix & Matt before use.

**Note:** Always use a 125 micron paint strainer.

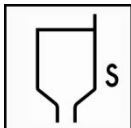
**Note:** Make sure to mask body apertures to avoid gloss differences.



# 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.

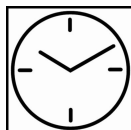
**Note:** This product is designed for total respray or edge to edge application.

## 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

FOR PROFESSIONAL USE ONLY

## Drying times (continued)



Allow 15 minutes flash off prior to infra red curing.

2 minutes at high intensity + 6 minutes at low 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 m<sup>2</sup>/liter

Semi Gloss

320 m<sup>2</sup>/liter

## Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

## VOC

### 2004/42/IIb(e)(840)608

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. 608 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 S8.01.07



# Autoclear Mix & Matt

FOR PROFESSIONAL USE ONLY

**Akzo Nobel Car Refinish bv.**  
**Address: Rijksstraatweg 31, PO Box 3, 2170 BA Sassenheim**  
**Tel: +31(0)71308-6944**

## FOR PROFESSIONAL USE ONLY

**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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