

Autoclear[®] Mat

FOR PROFESSIONAL USE ONLY

Description

Two-pack, colourless matting finish for application over hard dry topcoats, Autobase, 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

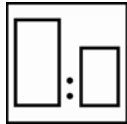
Autoclear Mat; Polyester resin
Clearcoat Hardeners; Poly-Isocyanate resins

Suitable substrates

Existing (hard dry) finishes
Autobase
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.

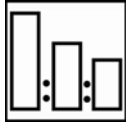
Gloss level impression	Clearcoat by volume	Autoclear Mat by volume
High gloss	100	0
	70	30
Semi gloss	50	50
	30	70
Matt	0	100

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

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

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 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 III

Autoclear Mat	Autoclear III	Clearcoat mix	Autoclear III Hardener	Autoclear III Activator
100	0	100 parts	50 parts	30 parts
50	50	100 parts	50 parts	30 parts *
0	100	Mixing ratio according product TDS		

* 40 parts in combination with Activator Extra Slow

Autoclear LV Superior

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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Autoclear LV Classic

Autoclear Mat	Autoclear LV	Clearcoat mix	Autoclear LV Hardener
100	0	3 parts	1 part
70	30	3 parts	1 part
50	50	2 parts	1 part
30	70	2 parts	1 part
0	100	2 parts	1 part

Autoclear LV & Autoclear LV Slow

Autoclear Mat	Autoclear LV Autoclear LV Slow	Clearcoat mix	LV Hardener	LV Reducer
100	0	3 parts	1 part	1 part
70	30	100 parts	50 parts	10 parts
50	50	100 parts	50 parts	10 parts
30	70	100 parts	50 parts	10 parts
0	100	100 parts	50 parts	10 parts

Pot-life

Autoclear	4 hours at 70°F (20°C)
Autoclear Plus	3-4 hours at 70°F (20°C)
Autoclear LV Supreme	1½ hours at 70°F (20°C)
Autoclear Plus HS	3-4 hours at 70°F (20°C)
Autoclear III	1-4 hours at 70°F (20°C)
Autoclear Basiq HS Fast	2-3 hours at 70°F (20°C)
Autoclear Basiq HS Slow	3-4 hours at 70°F (20°C)
Autoclear Xtra	3 hours at 70°F (20°C)
Autoclear Titan LV	2½ hours at 70°F (20°C)
Autoclear LV Superior Fast	30 minutes at 70°F (20°C)
Autoclear LV Superior Medium	1 hour at 70°F (20°C)
Autoclear LV Superior Slow	1½ hours at 70°F (20°C)
Autoclear LV Classic	1 hour at 70°F (20°C)
Autoclear LV (Slow)	30 minutes at 70°F (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.

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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	70°F (20°C)	140 °F (60°C)
P25 Hardener	4 hours	30 minutes
P35 Hardener	5 hours	55 minutes
P45 Hardener	6 hours	60 minutes
Basiq HS Hardener Fast	4 hours	30 minutes
Basiq HS Hardener Slow	5 hours	55 minutes
Autoclear LV Supreme Hardener		35 minutes
Autoclear III Activator Fast	4 hours	10 minutes
Autoclear III Activator Medium	7 hours	20 minutes
Autoclear III Activator Slow	10 hours	30 minutes
Autoclear Xtra Hardener	24 hours	1¼ hours
Autoclear LV Titan Hardener		60 minutes
Autoclear LV Superior Fast		35 minutes
Autoclear LV Superior Medium		45 minutes
Autoclear LV Superior Slow		60 minutes
Autoclear LV Classic		45 minutes
Autoclear LV (Slow)		35 minutes



Allow 5 minutes flash off prior to infra red curing
The panel must not reach a temperature above 212°F (100°C) while curing.
For additional infra red drying information; see TDS S9.01.01

Material usage

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.

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

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VOC

2004/42/IIb(e)(840)615

The EU limit value for this product (product category: IIB. e) in ready to use form is max. 840 g/liter of VOC. The VOC content of this product in ready to use form is max.615 g/liter.

VOC level overview:

Hardener:	
P15 Hardener	613 g/ liter
P25 Hardener	613 g/ liter
P35 Hardener	613 g/ liter
P45 Hardener	613 g/ liter
Autoclear III Activator Fast	490 g/ liter
Autoclear III Activator Medium	490 g/ liter
Autoclear III Activator Slow	490 g/ liter
Autoclear Xtra Hardener	525 g/ liter
Autoclear LV Titan Hardener	460 g/ liter
Autoclear LV Supreme Hardener	400 g/ liter
Autoclear LV Superior Hardener (100:60:20)	564 g/ liter
Autoclear LV Classic Hardener	564 g/ liter
Autoclear LV Hardener	543 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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