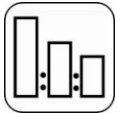


Description

nax Matt Clear is a premium modified acrylic urethane 2K System which provides a uniform soft matt finish with excellent scratch resistance and self-healing properties. It is designed to have an outstanding durability and chemical resistance property. Product shows excellent transparency thereby preserving the metallic affect.

Suitable Substrates

nax Premila 8000 series basecoat system
 nax E-Cube WB basecoat system



2 nax Matt Clear
 1 nax Matt Clear Hardener
 0-10% nax Premila Thinners

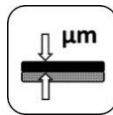


Spray-gun Setup:
 Gravity fed | 1.3-1.4 mm

Application Pressure:
 1.7-2.2 bar | 28-30 psi | At spray-gun air inlet
 HVLP max 0.6-0.7 bar (8-10 psi) at the air cap



2 coats



50-70 μm



Between Coats:
 10-15 minutes at | 20°C | 70°F |

Before 60°C (140°F) Baking:
 10-15 minutes at | 20°C | 70°F |



	20°C (70°F)	30°C (70°F)	40°C (70°F)	60°C (140°F)	Infra-Red
Dust dry	55 min.	40 min.	35 min.	-	4+8 minutes
Dry to handle	8 hours	8 hrs.	6 hrs.	30-40 min.	



► The VOC content of this product in ready to use form is maximum 590 g/liter



Use suitable respiratory protection

Nippon Paint Auto Refinishes recommends the use of fresh air supply respirator.

Read complete TDS for detailed product information

Description

nax Matt Clear is a premium modified acrylic urethane 2K System which provides a uniform soft matt finish with excellent scratch resistance and self-healing properties. It is designed to have an outstanding durability and chemical resistance property. Product shows excellent transparency thereby preserving the metallic affect.

Suitable Substrates

nax Premila 8000 series basecoat system
 nax E-Cube WB basecoat system

Notes: Follow recommended flash off and re-coating time of the basecoat.

Compatible Clearcoats

nax Premila 9600 Extra Solid Clear 2K (2:1)

Notes: Follow recommended flash off and re-coating time of the basecoat.

Product and Additives

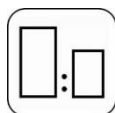
Product	nax Matt Clear	Acrylic Polyol	
Hardener	nax Matt Clear Hardener	Poly-isocyanate resin	
Reducers	nax Premila 10 Fast Thinner	Blend of solvents	5-20°C
	nax Premila 20 Medium Thinner	Blend of solvents	20-35°C
	nax Premila 30 Slow Thinner	Blend of solvents	35-45°C
	nax Premila 40 Extra-Slow Thinner	Blend of solvents	35-50°C

Matting Levels

	Satin	Semi-Gloss	
	100	100	nax Matt Clear
	10	20	nax Premila 9600 Extra Solid Clear 2K (2:1)

Notes: Stir well after adding the components

Mixing



Standard

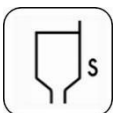
2	nax Matt Clear or Mixes
1	nax Matt Clear Hardener
0-10%	nax Premila Thinners

Thinner Selection

	5-20°C	20-35°C	35-45°C
1-2 panels	Fast	Medium	Slow
3-5 panels	Medium	Medium	Slow
>5 panels	Slow	Slow	Slow

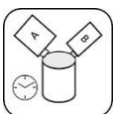
Notes: Stir after each added component
 nax Matt Clear is very flexible clear and hence does not require nax Softener.

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)
▶ Standard	17-18 sec	14-17 sec

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ Standard	2 hrs.	1½ hrs.	1 hr.

Spray Gun Set-up / Application Pressure



Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▶ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▶ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

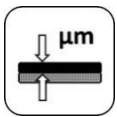
Application



Standard Application Apply one even wet coat using a minimum of 60% overlap. Before applying the second coat allow 10 to 15 minutes flash off time. The first coat should be uniform in appearance before applying second coat. Apply a second wet even coat with a minimum of 60% overlap, allow 10-15 minutes flash off time before baking.

Notes: Flash-off time depends on ambient temperature, applied layer thickness and airflow. Application should be done in dust free condition.

Film Thickness



▶ All	Using the recommended application technique	50-70 μm
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Drying time



Dust Dry	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
▶ Standard	55 min.	45 min.	35 min.	-	n/a
Dry to Handle					
▶ Standard	7 hrs.	5 hrs.	4 hrs.	30 min.	4+8 min.

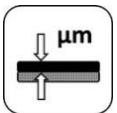
Notes: Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher. Allow 10 minutes flash off prior to Infra-Red drying. The panel must not reach a temperature above 100°C (210°F) while curing. Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.

Polishing



Polishing is not recommended for this product. Polishing will make the product glossy.

Coverage



By using the recommended application, the theoretical material coverage is:

- ▶ 8 m²/liter RTS mixture at 50 μm

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

Equipment Cleaning

Solvent borne gun cleaners

Solvent Content



- ▶ The VOC content of this product in ready to use form is maximum 590 g/liter

Shelf-life



nax Matt Clear

nax Matt Hardener

nax Premila Thinners

Minimum storage temperature: 5°C (41°F) Maximum storage temperature: 35°C (95°F)

Notes: Avoid extreme temperature fluctuation.

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