

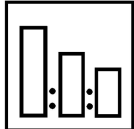


# Mat Clear

FOR PROFESSIONAL USE ONLY

## Description

Lesonal Mat clear provides a matt appearance over Lesonal Basecoat SB or may be intermixed with other suitable Lesonal clears to provide various gloss levels, for the protection and durability of the base coat system.



3:1:1  
Mat Clear  
Clear Hardener  
Clear Slow Activator



Use Lesonal measuring stick  
# 7

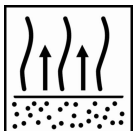


Spray gun set-up:  
1.3 – 1.5 mm  
HVLP max. 10 psi at air cap

Application pressure:  
29 psi(spray gun air inlet)  
o Check gun manufacturer specification



Application  
2 - 3 X 1 coat



Between coats:  
5 – 10 minutes at 70°F (20°C).



10 hours at 70°F (20°C).  
35 minutes at 140°F (60°C).



Use suitable respiratory protection  
Akzo Nobel Car Refinishes Inc. recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information



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## Description

Lesonal Mat clear provides a matt appearance over Lesonal Basecoat SB or may be intermixed with other suitable Lesonal clears to provide various gloss levels, for the protection and durability of the base coat system.

## Suitable substrates

- Lesonal Basecoat SB Solid, Metallic and Pearl colors: after a flash-off time of 15– 20 minutes at 70°F (20°C).
- Existing finishes: in the case of spot repair see TDS “Spot Repairs with Lesonal Basecoat SB”.

## Products and additives

- Product:** Lesonal Mat Clear
- Hardeners:** —Lesonal Clear Hardener  
—ProAir Clear Slow hardener  
—ProAir Clear Fast hardener
- Reducers:** —Lesonal Clear Fast Activator  
—Lesonal Clear Slow Activator  
—Lesonal Glamour Clear Reducer  
—Lesonal Glamour Clear Accelerator (Reducer)  
—Lesonal Reducer Medium (for those customers using Lesonal ProAir Clear)
- Additive:** — Lesonal Flex Additive

## Basic raw materials

- Mat Clear: Hydroxyl acrylic resins  
All Lesonal urethane hardeners: Polyisocyanate resins

## Material preparation and Mixing ratio

Lesonal Mat Clear may be used with Glamour Clear, Universal Clear or ProAir Clear in any combination to achieve the desired gloss level.

Gloss level	Parts Mat Clear	Parts Clear
Mat 10 to 20 GU	100	0
Eggshell 40 to 60 GU	60	40
Gloss	0	100

Lesonal Mat Clear is used by itself or in combination with **Universal Clear** to achieve desired gloss level.

- 3 Parts of Lesonal Mat Clear with  
1 Part of Lesonal Clear Hardener and  
1 or 1½ Part of Lesonal Clear Activators.



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## Material preparation and Mixing ratio

Alternate Mixing; with **Glamour Clear**

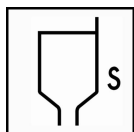
Lesonal Mat Clear is used by itself or in combination with Glamour Clear or ProAir Clear to achieve desired gloss level.

2 parts of Lesonal Mat clear with  
1 part of Clear Hardener plus  
20% of Glamour Clear Reducer or Accelerator.

Alternate Mixing; with **ProAir Clear**

3 parts of Lesonal Mat clear with  
1 part of ProAir Clear Hardener plus  
1 part of Lesonal Reducer.

## Spray Viscosity



16 -17 seconds DIN cup #4 at 70°F (20°C).

## Spray gun set-up / application pressure



### Spray gun

HVLP Gravity feed  
High transfer Gravity feed  
Conventional Gravity feed

### Fluid tip –set up

1.3 – 1.5mm  
1.3 – 1.5mm  
1.4 – 1.5mm

### Application pressure

HVLP. Max. 10 psi at air cap  
\*29 to 36 psi at air inlet  
45 psi at air inlet

\*Check gun manufacturer specification

## Pot-life

2 hours at 70°F (20°C)

45 minutes at 70°F (20°C) with 4.0 Accelerator

## Application process



Apply one single closed coat followed immediately by one full flowing coat.  
For single panel or small repairs, allow a flash off of 5–10 minutes at 70°F (20°C) between coats.

## Flexible parts

Mix Mat Clear (5:1) with Lesonal Flex Additive before adding the appropriate hardener and reducer. (See Flex Additive technical data sheet.)

- Gloss levels will increase with the addition of Lesonal Flex Additive.



# Mat Clear

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## Drying

Below is a table showing the drying times of Lesonal Mat Clear. The air-dry times stated may vary with insufficient airflow.

Metal Temp	Drying	Clear Slow Activator	Clear Fast Activator	1:1 blend of: Clear Slow Activator Clear Fast Activator
70° F (20° C)	Dust free	1 hour	30 min	50 min
	Dry	10 hours	5 hours	8 hours
140° F (60° C)	Dust free	25 minutes	10 min	15 – 20 min
	Dry	35 minutes	20 min	25 min

### Drying times with alternate hardeners and reducers:

Below is a table showing the drying times of Lesonal Mat Clear. The air-dry times stated may vary with insufficient airflow.

Metal Temp	Drying	Glamour Clear Reducer	Glamour Clear Accelerator (Reducer)
70° F (20° C)	Dust free	1 ½ hour	50 min
	Dry	16 hours	8 hours
140° F (60° C)	Dust free	35 minutes	25 min
	Dry	45 minutes	30 min

## Film thickness

With two coat application: 1.2-2.4 mils. (30-60µm)

## Polishing

Lesonal Mat Clear is designed to produce a low gloss appearance, polishing is not recommended.

## Material usage

Theoretical material usage is ± 64 sq.ft./litre RTS mixture. at a film thickness of 0.9 mils

*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

Clean and rinse the spray gun thoroughly after use with a suitable solvent based gun cleaning thinner.



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**VOC**

The VOC content of this product in ready to use form is:

Glamour Clear users	Lesonal Mat Clear / Clear Hardener / Glamour Clear Reducer: o Ratio 2:1+ 20% = 4.42 lb/gal 530 g/liter
Universal Clear users	Lesonal Mat Clear / Clear Hardener / Slow activator: o Ratio 3:1:1 = 4.50lb/gal 540 g/liter. Ratio 3:1:1½ = 4.0 lb/gal 480 g/liter
ProAir Clear users	Lesonal Mat Clear / ProAir Clear Hardener / Lesonal Reducer Medium o Ratio 3:1:1 = 5.01 lbs/gal 601 g/liter

**Storage**

Product shelf-life is determined when products are stored unopened at 70°F (20° C).  
Avoid too much temperature fluctuation.  
o Lesonal Mat Clear: Two years if stored unopened.

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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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