



DUAL MATT HS

E45

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2K MATT CLEAR COAT

DEFINITION

DUAL MATT HS is an extremely versatile 2K matt clear coat for car refinishing and industrial applications. It can be used as a clear coat where a matt finish is required. In addition, where a satin finish is required, **DUAL MATT HS** can be mixed with various 2K clear coats from the Roberlo range to provide different levels of finish. Alternatively, if extra matt finishes are required, the product can be mixed with P100 matting agent.



Particularly recommended for partial paint jobs, using **DUAL MATT HS** guarantees high quality and a hardwearing finish.

PHYSICAL CHARACTERISTICS

Nature:	Acrylic 2K
Colour:	Translucent white
Specific weight:	1,0 kg/l at 20°C
Viscosity CF/4:	18-20" at 20°C
Dry film thickness:	25-35 microns 2 coats
VOC:	496 g/l Application 2004/42/EC - IIB(e)(840) 496 g/l
Solids content:	52 % Application

AUXILIARY PRODUCTS

KX44	Slow Hardener	VOC PLUS Low Voc Standard Additive
KX45	Standard Hardener	VOC PLUS Low Voc Slow Additive
KX46	Fast Hardener	P100 Matting agent

			
<i>T° (°C)</i>	<i>Hardener</i>	<i>Hardener</i>	<i>Voc Plus Low Voc</i>
< 18	KX46	KX46	Standard
18 - 25	KX45- KX46	KX45	Standard
> 25	KX45	KX44	Slow

MIXING PREPARATION

Mix **DUAL MATT HS** thoroughly, then mix with the additives. When mixing the additives make sure to mix thoroughly following each additional measure. Mix again just before use.

SURFACE PREPARATION

Apply **DUAL MATT HS** onto the basecoat according to the flash off time recommended by the manufacturer. When using with a solvent-based base coat, apply the clear coat only after the base coat is completely cured.

APPLICATION

DUAL MATT HS			20°C							
					mm	bar	cm			
KX45	100:33:15 Weight	3:1+15%	18-20" F/4	3h		1,2	2-3	15 - 20	2 coats	5'
						1,3	4	15 - 20		
						1,2	2	10		

Before applying the second coat and before force drying, wait until the complete flash off time has elapsed.

DUAL MATT HS DRYING TIMES

20° C					60° C		Short wave - IR		
								FLASH OFF	FULL BAKE
KX45	20'	3h	5h	7h	KX45	30'	LIGHT	5'	10'
							DARK	4'	8'
							METALLIC	5'	10'

The temperature when drying will influence the final gloss level; different drying at varying ambient temperatures, oven or infrared drying will also result in different levels of gloss.

MIXING AND GLOSS TABLE

GLOSS LEVEL	GLOSS % (^60°)	GLOSSY CLEAR COAT	DUAL MATT	MATTING AGENT P100
SEMI GLOSSY	50-75	20	80	-
SATIN	30-50	10	90	-
SEMI MATT	20-30	5	95	-
MATT	10-20	0	100	-
EXTRA MATT	<10	0	95	5

- See Annex I

Generally, the gloss of a clear coat can be affected specifically by:

- Thickness of film
- Number of coats
- Quantity of thinner to be added
- Drying time conditions
- Surface where it is applied (water-based basecoat, solvent based basecoat ...)

REMARKS

Humidity affects clear coat components so all application equipment should be completely dry. Close the hardener container immediately after use.

Do not use when relative humidity is higher than 70%.

Do not use in temperatures lower than +10°C. If temperature is less than 10°C use heated spraybooth.

Following the specific application method of matt clear coat is vitally important in order to achieve a perfectly uniform matt finish and allow correct layout of the particles that will produce the desired effect seen under different levels of light.

Varying film thicknesses will produce a different finish: A thinner film (a 'dry' application) will give lower level of gloss than that of a thicker film and a 'wet' application.

If painting adjacent panels on a vehicle, it is highly recommended to produce a spray out card (using the exact same equipment / conditions of application / drying time which would then be used in actual repair process) This should be done in order to compare the actual gloss/matt level required. Always use a masking tape that doesn't leave glue residues. Attempting to removal glue residue from panels on matt finished by means of rubbing or wiping may produce increased level of gloss in the contaminated area resulting in a differing level of finish in this area of the surface.

When working with matt clear coats it is very important to keep areas clean by limiting dirt and dust contamination. NOTE: It is not possible to rectify dust and dirt inclusions in matt clear coat by means of standard rectification technique by using wet or dry sandpaper and / or abrasive compound. Polishing will only detrimentally increase the gloss level of the desired matt finish resulting in a semi gloss effect in these specific areas.

EQUIPMENT CLEANING

Use a cleaning thinner before the pot life has expired.

SAFETY

Follow instructions of product label. For more information check the Safety Data Sheet. Compliant with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

STORAGE

Store the product in a ventilated at a temperature of between +5°C and +30°C Keep out of direct sunlight.

GUARANTEE

In unopened original packaging, one year from manufacturing date.

ANNEX I

MIXING RATIO BY WEIGHT

GLOSS	KRONOX 3100	DUAL MATT HS	P100	K35	VOC PLUS
SEMI GLOSSY	20	80	0	25	10-15
SATIN	10	90	0	25	10-15
SEMI MATT	5	95	0	25	10-15
MATT	0	100	0	25	10-15
EXTRA MATT	0	95	5	25	10-15
GLOSS	KRONOX 410	DUAL MATT HS	P100	KX45	VOC PLUS
SEMI GLOSSY	20	80	0	35	10-15
SATIN	10	90	0	35	10-15
SEMI MATT	5	95	0	35	10-15
MATT	0	100	0	35	10-15
EXTRA MATT	0	95	5	35	10-15
GLOSS	KRONOX HS420	DUAL MATT HS	P100	KH65	VOC PLUS
SEMI GLOSSY	20	80	0	35	0-5
SATIN	10	90	0	35	0-5
SEMI MATT	5	95	0	30	0-5
MATT	0	100	0	30	0-5
EXTRA MATT	0	95	5	30	0-5
GLOSS	ELITE 350HS	DUAL MATT HS	P100	C355	S322
SEMI GLOSSY	20	80	0	45	-
SATIN	10	90	0	40	-
SEMI MATT	5	95	0	40	-
MATT	0	100	0	40	-
EXTRA MATT	0	95	5	40	-
GLOSS	PREMIUM 250HS	DUAL MATT HS	P100	C355	S322
SEMI GLOSSY	20	80	0	45	-
SATIN	10	90	0	40	-
SEMI MATT	5	95	0	40	-
MATT	0	100	0	40	-
EXTRA MATT	0	95	5	40	-
GLOSS	SUPERIOR 150HS	DUAL MATT HS	P100	P5000	S322
SEMI GLOSSY	20	80	0	45	0-5
SATIN	10	90	0	45	0-5
SEMI MATT	5	95	0	45	0-5
MATT	0	100	0	45	0-5
EXTRA MATT	0	95	5	45	0-5
GLOSS	VT141 EXPRESS	DUAL MATT HS	P100	CT5	S322
SEMI GLOSSY	20	80	0	35	-
SATIN	10	90	0	35	0-5
SEMI MATT	5	95	0	35	0-5
MATT	0	100	0	35	0-5
EXTRA MATT	0	95	5	35	0-5

For any technical information contact with our Customer Attention Service or our Technical Department.
ROBERLO SA declines any responsibility due to an incorrect use of the product.