


REFINISH
**Technical Data Sheet
TDS**

Description

MAT CLEAR is a 2K acrylic mat clear used on bumpers and lower body panels. When mixed to Carlack, different gloss levels are obtained.

Technical details form supplied product

	MAT Clear	HS Hardener
Viscosity, DIN4 20°C	78" ± 2	12" ± 2
Solids Content %	46 ± 1	48 ± 1
Density 20°C	1,00 ± 0,03	0,99 ± 0.03
VOC content grams/litre	< 540	< 520
Gloss	<20	-----
Pack Size	1L	0.25L / 0,33L / 0,5L / 2,5L

Preparation

	By volume	By weight	Percentage
S 820 Clearcoat	1000ml	1000g	100%
Hardener: S 411 / S 412 / S 413 ("BS REFINISH" HS HARDENER)	330ml	328g	33%
Thinner: S 709 / S 710 / S 711 ("BS REFINISH" ACRYL. THINNER)	266 – 399ml	240 – 360g	20-30%
Ready for use viscosity DIN4 20°C	15-18" ± 2		
Ready for use solids content %	47% ± 1		
Pot Life	2 hours @ 20°C		

Application

	Conventional	High transfer efficienc
Gravity spray gun		
Gun nozzle	1,3-1,4	1,2-1,3
Pistol pressure	3-3,5 bar	0.5-0.7 bar
Suction fed spray gun	Conventional	High transfer efficienc
Gun nozzle	1,4-1,6	1,2-1,3
Pistol pressure	3.5-4 bar	0.3-0.7 bar
Flash between coat	15-20 minutes @ 20°C	
Number of coats	2	
Suggested thicknes	50 microns	

Drying

	20°C	50-60°C
Temperature		
Dust free	15 minutes	Flash before force dry 15 minutes
Handling	24 hours	30-40 minutes

INFRARED DRYIN	Medium wave	Short wave
Flash before infrared drying @ 20°C	5-7 minutes	5-7 minutes
Dry for sanding	20 minutes	15 minutes



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Hardeners - Thinners

Hardeners

S 411 Slow	To be used from 25 °C to 35 °C
S 412 Normal	To be used from 15 °C to 25 °C
S 413 Fast	To be used from 5 °C to 15 °C (Spot repairs @ 25 °C)

Thinners

S 709 Slow	To be used from 25 °C to 35 °C
S 710 Normal	To be used from 15 °C to 25 °C
S 711 Fast	To be used from 5 °C to 15 °C (Spot repairs @ 25 °C)

Additional information



Dry sanding P 800-1000



Wet sanding P 1200-2500



Clean



Follow all safety requirements

These products are for professional use only

and are not to be used for purposes other than those specified.

The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

Gloss levels

S 820 MAT Clear	100%	Mat (Gloss 15-20)
S 820 MAT Clear	100%	Semi-mat (Gloss 40-50)
S 800 CarLack	10%	
S 820 MAT Clear	100%	Semi-gloss (Gloss 70-80)
S 800 CarLack	20%	

For further information please contact.

Manufacturer

SERANO Company
6, Skra str. 55236, Panorama
Thessaloniki - Greece
e-mail: info@bsrefinish.com
fax: +30 2310 341988
<http://www.bsrefinish.com>

Distributor



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