



DUAL MATT HS

2K MATT CLEAR COAT VARNISH

E45

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DEFINITION

DUAL MATT HS is a highly versatile 2K clear coat for car refinish and industry. It can be used as a clear coat for applications requiring matt topcoats. Also, when satin topcoats are required, **DUAL MATT HS** can be mixed with the different 2K clear coats offered in the Roberlo range to offer different levels of topcoats. Similarly, if extra matt topcoats are required, it can be mixed with UB-100 matting paste.



Especially recommended for partial coatings, **DUAL MATT HS** guarantees high quality and durable topcoats.

PHYSICAL CHARACTERISTICS

Nature:	Acrylic 2K
Colour:	Translucent white
Specific weight:	1.0 kg/l a 20°C
Viscosity CF/4:	18-20" a 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

COMPLEMENTARY PRODUCTS

KX44	Hardener slow hardener	S322	Standard Thinner
KX45	Standard Hardener	S324	Slow Thinner
KX46	Fast hardener Hardener	UB-100	Matting paste

			
<i>T^a</i> (°C)	<i>Hardener</i>	<i>Hardener</i>	<i>Thinner</i>
< 18	KX46	KX46	S322
18 - 25	KX45- KX46	KX45	S322
> 25	KX45	KX44	S324

PREPARATION OF THE MIXTURE

First mix **DUAL MATT HS** very well. Then mix it with the complementary products. When adding the complementary products, mix well after adding each of them. Shake the mixture just before application.

SURFACE OR SUBSTRATE PREPARATION

Apply **DUAL MATT HS** after the evaporation time recommended by the manufacturer has elapsed.

APPLICATION

DUAL MATT HS				
			20°C	
KX45	100:33:15 Weight	3:1+15%	18-20" F/4	3h

	mm	bar	cm		
	1,2-1,3	2-2,5	15 - 20	2 coats	5'
	1,5-1,7	2-3	15 - 20		
	1,2-1,3	2-2,5	10		

Wait until complete evaporation before applying the second coat, and before drying at room temperature.

DUAL MATT HS DRYING

20° C					60° C		IR - OC		
								FLASH OFF	FULL BAKE
KX45	20'	3h	5h	7h	KX45	30'	LIGHT COLOURS	5'	10'
							DARK COLOURS	4'	8'
							METALLISED	5'	10'

The drying temperature influences the final Gloss, drying at room temperature, oven or IR will result in different Glosses.

MIXING AND GLOSS TABLE

GRADE	GLOSS % (^60°)	GLOSS CLEAR COAT	DUAL MATT	TINTING PASTE UB-100
SEMIBRILLANT	50-75	20	80	-
SATIN	40-50	10	90	-
SEMIMATE	30-40	5	95	-
MATT	20-30	0	100	-
EXTRAMATE	10-20	0	95	5
ULTRAMATE	<10	0	90	10

- See Annex I

The Gloss of a clear coat is greatly affected by:

- Thickness of film
- Number of coats
- Amount of added Thinner
- Drying conditions
- Substrate on which it is applied (two coat water base, two coat solvent base...)

REMARKS

Moisture alters the components of the clear coat and therefore the application equipment must be absolutely dry.

Close the Hardener container immediately after use.

In conditions of relative humidity above 70% and/or temperatures below +10°C, drying at 60°C is recommended.

The uniformity of the topcoat is very important. Therefore it is necessary to apply the clear coat evenly. The matting is given by discontinuities created in the film. Consequently, application processes and more or less loaded coats are very important to allow a correct positioning of the particles, which cause the interferences encountered by the light when it hits the film.

Gloss differences will be observed if there are different film thicknesses: a topcoat with low thickness and dry application will give a lower gloss than a topcoat with high thickness and wet application.

When it is necessary to paint small surfaces next to each other, it is advisable to make a test piece with the same equipment and application and drying conditions with which the repair project is going to be carried out, in order to control the Gloss and colour. Use a tape that does not leave adhesive residues, as cleaning it could cause an increase in gloss in that area.

When working with matt clear coats, it is necessary to check the dirt and the application of the product very carefully, as it is not possible to remove defects by polishing. Polishing would increase the Gloss of the area. It is not possible to use the patching technique as the increased thickness of the blending area causes gloss variation.

CLEANING OF THE EQUIPMENT

Clean with cleaning thinner before the product hardens.

SAFETY

Refer to the product label. For further information see safety data sheet. Comply with health and safety at work and waste disposal directives.

STORAGE

Keep in a cool and ventilated place avoiding exposure to direct sunlight. Store between +5°C and +30°C

SHELF LIFE

One year in original unopened packaging.

ANNEX I

MIXING RATIOS BY WEIGHT

GLOSS	KRONOX 3700	DUAL MATT HS	UB-100	K35	S322
SEMIBRILLANT	20	80	0	35	10-15
SATIN	10	90	0	35	10-15
SEMIMATE	5	95	0	35	10-15
MATT	0	100	0	35	10-15
EXTRAMATE	0	95	5	35	10-15
GLOSS	KRONOX 3200	DUAL MATT HS	UB-100	K35	S322
SEMIBRILLANT	20	80	0	35	10-15
SATIN	10	90	0	35	10-15
SEMIMATE	5	95	0	35	10-15
MATT	0	100	0	35	10-15
EXTRAMATE	0	95	5	35	10-15
GLOSS	KRONOX 620	DUAL MATT HS	UB-100	KX45	S322
SEMIBRILLANT	20	80	0	35	10-15
SATIN	10	90	0	35	10-15
SEMIMATE	5	95	0	35	10-15
MATT	0	100	0	35	10-15
EXTRAMATE	0	95	5	35	10-15
GLOSS	KRONOX 510	DUAL MATT HS	UB-100	KX45	S322
SEMIBRILLANT	20	80	0	35	10-15
SATIN	10	90	0	35	10-15
SEMIMATE	5	95	0	35	10-15
MATT	0	100	0	35	10-15
EXTRAMATE	0	95	5	35	10-15
GLOSS	KRONOX 500	DUAL MATT HS	UB-100	KX45	S322
SEMIBRILLANT	20	80	0	35	10-15
SATIN	10	90	0	35	10-15
SEMIMATE	5	95	0	35	10-15
MATT	0	100	0	35	10-15
EXTRAMATE	0	95	5	35	10-15

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GLOSS	UNIX 650HS	DUAL MATT HS	UB-100	C355	S322
SEMIBRILLANT	20	80	0	50	0-5
SATIN	10	90	0	50	0-5
SEMIMATE	5	95	0	50	0-5
MATT	0	100	0	50	0-5
EXTRAMATE	0	95	5	50	0-5
GLOSS	UNIX 450HS	DUAL MATT HS	UB-100	C355	S322
SEMIBRILLANT	20	80	0	50	-
SATIN	10	90	0	50	0-5
SEMIMATE	5	95	0	50	0-5
MATT	0	100	0	50	0-5
EXTRAMATE	0	95	5	50	0-5
GLOSS	UNIX 250HS	DUAL MATT HS	UB-100	C355	S322
SEMIBRILLANT	20	80	0	40	5-10
SATIN	10	90	0	40	5-10
SEMIMATE	5	95	0	40	5-10
MATT	0	100	0	40	5-10
EXTRAMATE	0	95	5	40	5-10
GLOSS	UNIX 150HS	DUAL MATT HS	UB-100	P5000	S322
SEMIBRILLANT	20	80	0	45	0-5
SATIN	10	90	0	45	0-5
SEMIMATE	5	95	0	45	0-5
MATT	0	100	0	45	0-5
EXTRAMATE	0	95	5	45	0-5
GLOSS	UNIX 50HS	DUAL MATT HS	UB-100	KX45	S322
SEMIBRILLANT	20	80	0	35	10-15
SATIN	10	90	0	35	10-15
SEMIMATE	5	95	0	35	10-15
MATT	0	100	0	35	10-15
EXTRAMATE	0	95	5	35	10-15

GLOSS	VT141 EXPRESS	DUAL MATT HS	UB-100	CT5	S322
SEMIBRILLANT	20	80	0	35	10-15
SATIN	10	90	0	35	10-15
SEMIMATE	5	95	0	35	10-15
MATT	0	100	0	35	10-15
EXTRAMATE	0	95	5	35	10-15
GLOSS	GLOBAL 6000	DUAL MATT HS	UB-100	KX45	S322
SEMIBRILLANT	20	80	0	35	10-15
SATIN	10	90	0	35	10-15
SEMIMATE	5	95	0	35	10-15
MATT	0	100	0	35	10-15
EXTRAMATE	0	95	5	35	10-15

These products are for professional use only. The Safety Data Sheet must be consulted before use and the precautionary warnings on the product packaging must be observed. Their correct use, in accordance with their purpose and respecting the technical and safety data provided in these documents, is the sole and exclusive responsibility of the user. ROBERLO S.A.U. declines any responsibility due to the incorrect use of any product.

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