

## Technical Data Sheet

# **Spectral KLAR 535 MAT**

Two-component matt acryl clearcoat

### **RELATED PRODUCTS**






Spectral KLAR 535 MAT  
Spectral H 6125  
Spectral SOLV 855



Spectral PLAST 775  
Spectral EXTRA 835

Matt acryl clearcoat  
Standard, fast and slow hardeners  
Standard, fast, slow and extra slow acrylic  
thinners  
Elasticity increasing agent  
Texture additive

### **PROPERTIES**

- High-quality matt coating
- High scratching resistance (SR)
- HS process - high solids content
  - Very good flowability
  - Fast drying
- Increased chemical resistance

SUBSTRATES				
Base layers Spectral BASE		Dry matt surface. Slightly mat if necessary.		
Base layers Spectral WAVE		Dry matt surface. Slightly mat if necessary.		
The product is also compatible with most of commercial thinner and water-borne basecoats.				
MIXING RATIO				
	Spectral KLAR 535 MAT Spectral H 6125 Spectral SOLV 855	Volume ratio		Weight ratio
		2		100
		1		47
		0.2 ÷ 0,4		8 ÷ 16
Application notes: The longer the curing time is, the less is the coat prone to clouding, especially on large surfaces at high temperatures. Using a slow thinner and a higher thinning rate improves the distribution of the matting additives in the coat.				
VISCOSITY				
	DIN 4/20°C	14 – 21 s		
VOC CONTENT				
VOC II/B/e limit*		840 g/l		
Actual VOC content		545 g/l		
* For ready to apply mixture compliant with Directive UE 2004/42/CE				
APPLICATION CONDITIONS				
It is recommended to apply the clearcoat over 15°C and under a humidity of 80%. Under these conditions the cured coating can be used after a minimum of 14 hours.				
APPLICATION				
	Traditional gravity spray gun	Nozzle	Pressure	Distance
		1.2 – 1.4 mm	CAUTION: follow the equipment manufacturer's guidelines	
	No. of layers	2 – 3		
	Single dry layer thickness	20 – 25 µm		
	The yield of the ready to use mixture for the given range of dry layer thickness	8.0 m²/l at 50 µm		
	Mixture life at 20 °C	H 6125 (slow), (standard)	H 6125 (fast)	
		2 hours	30 min.	

	Flash-off time between layers	5 - 10 mins				
CURING TIMES						
	H 6125 Standard					
	20°C		60°C			
Dust-free	25 mins		5 mins			
Tack-free	3 h		10 mins			
Operating hardness	14 h		45 mins			
Ending hardness	7 days		45 mins + 1 day / 20°C			
CAUTION: The curing times apply to the temperature of specific elements. The coating is ready for hot curing in 30 minutes from application of the last layer.						
IR DRYING						
	Distance		Follow the equipment manufacturer's guidelines			
	Time, depending on lamp type and power		10 - 25 mins			
CAUTION: Start IR heating after at least 10 mins from applying the last layer.						
RELATED PRODUCTS, DEPENDING ON THE PROCESSING TEMPERATURE						
	15 - 20°C	20 - 25°C	25 - 35°C	+ 35°C		
Spectral H 6125	Fast	Standard	Slow	Slow		
Spectral SOLV 855	Fast	Standard	Slow	Extra Slow		
Spectral PLAST 775 ELASTICITY INCREASING AGENT						
In order to increase the elasticity of the paint coating of plastic elements or to increase the resistance of the coating to impact by stones (e.g. front fascia, hood), add 10% (by volume ratio) of Spectral PLAST 775 on the finished mixture of Spectral KLAR 535 Mat and Spectral H 6125 and adjust the thinner quantity as appropriate. Adding Spectral PLAST 775 will, however, increase gloss.						
GLOSS LEVELS WITH CLEARCOATS						
Due to the various versions of acryl coats, varying gloss levels can be obtained. It is recommended to do a test spray to check the obtained gloss.						
Mixing volume ratio: Spectral KLAR 535 MAT / any Spectral gloss acryl clearcoat			Gloss			
75 / 25			Semi-gloss			
90 / 10			Semi-matt			
100 / 0			Matt			
Spectral EXTRA 835 TEXTURE ADDITIVE						
Surface	Effect	Final mixture quantity	Spectral	Spectral	Spectral	Spectral

			KLAR 535 MAT	EXTRA 835	H 6125	SOLV 855
- steel; - galvanized steel, aluminium, rigid plastics	Textured matt	1 l	520 g	155 g	316 g	55 g
CAUTION: If painting elastic plastic surfaces, add approx. 10% (by volume ratio) of Spectral PLAST 775 per the ready to spray mixture.						
EQUIPMENT CLEANING						
SOLV 855 acrylic thinner or NC solvent						
STORAGE CONDITIONS						
Store in a dry and cool room, away from sources of fire and heat. Avoid direct exposure to sunlight.						
SHELF LIFE						
Spectral KLAR 535 MAT			24 months/20°C			
Spectral H 6125			12 months/20°C			
Spectral SOLV 855			24 months/20°C			
Spectral PLAST 775			24 months/20°C			
Spectral EXTRA 835			24 months/20°C			
SAFETY						
See the Safety Data Sheet						
OTHER INFORMATIONS						
The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.						

**OTHER INFORMATION**
**WEIGHT CONTENTS OF COMPONENTS 2:1:0,2:**

**CAUTION!**

In order to obtain a coat with suitable parameters, it is very important to precisely dose the specific components.

Mixture amount	Spectral KLAR 535 MAT	Spectral H 6125	Spectral SOLV 855
0.10 l	65 g	31.6 g	5.6 g
0.15 l	98 g	47 g	8 g
0.20 l	130 g	63 g	11 g
0.25 l	163 g	79 g	14 g
0.30 l	195 g	95 g	17 g
0.40 l	260 g	126 g	22 g
0.50 l	325 g	158 g	28 g
0.75 l	488 g	237 g	42 g
1.00 l	650 g	316 g	56 g
2.00 l	1300 g	632 g	111 g

**OTHER INFORMATION**
**WEIGHT CONTENTS OF COMPONENTS 2:1:0,4:**
**CAUTION!**

In order to obtain a coat with suitable parameters, it is very important to precisely dose the specific components.

Mixture amount	Spectral KLAR 535 MAT	Spectral H 6125	Spectral SOLV 855
0.10 l	61 g	30 g	10.5 g
0.15 l	92 g	45 g	16 g
0.20 l	122 g	60 g	21 g
0.25 l	153 g	74 g	26 g
0.30 l	184 g	89 g	31 g
0.40 l	245 g	119 g	42 g
0.50 l	306 g	149 g	52 g
0.75 l	459 g	223 g	78 g
1.00 l	612 g	298 g	105 g
2.00 l	1224 g	595 g	209 g