

Technical Data Sheet

Spectral KLAR 535-00

Matt acrylic clearcoat
Two-component matt acrylic clearcoat

RELATED PRODUCTS

Spectral KLAR 535-00
Spectral KLAR 525-00
Spectral H 6115

Spectral SOLV 855

Spectral PLAST 775

Matt acrylic clearcoat

Acrylic clearcoat







Hardener: Fast, Standard, Slow,
Extra Slow

Acrylic thinner: Standard, Fast, Slow, Extra
Slow

Elasticity increasing agent

PROPERTIES

- High-quality matt-finish coating
 - High scratch resistance (SR)
 - Perfect flow and transparency
 - Uniform matt level
 - Cures very quickly
 - No coat clouding

SUBSTRATES				
Spectral BASE 2.0 basecoats		Apply on a thoroughly dry, dust-free basecoat surface. Use dust-collecting painter's wipes to remove dust from basecoat colours.		
Spectral WAVE 2.0 basecoats		Apply on a thoroughly dry, dust-free basecoat surface. Use dust-collecting painter's wipes to remove dust from basecoat colours.		
Compatible with the majority of solvent and waterborne basecoats available on the market.				
MIXING RATIO				
		Volume ratio	Weight ratio	
	Spectral KLAR 535-00	4	100	
	Spectral H 6115	1	25	
	Spectral SOLV 855	40-50%	36-45	
VISCOSITY				
	DIN 4/20°C	18 ÷ 20 s		
VOC CONTENT				
VOC II/B/e limit*		840 g/l		
Actual VOC at 40% of SOLV 855		650 g/l		
* For a ready for use mixture acc. to EU Directive 2004/42/CE				
APPLICATION CONDITIONS				
It is recommended to apply the clearcoat at a temperature above 15°C and a humidity of no more than 80%.				
APPLICATION				
		Nozzle	Pressure	Distance
	Conventional gravity fed spray gun	1.2 ÷ 1.4 mm	Follow the tool manufacturer's guidelines	
	Number of layers	2 ÷ 3		
	Single dry layer thickness	15 ÷ 20 µm		
	Ready to use mixture yield	4.8 m ² /l at 50 µm		
	Mixture life at 20°C	60 min		
	Flash-off time between layers	Spectral BASE 2.0	Spectral WAVE 2.0	
		Recoat with the next layer immediately once the matt effect shows. Do not extend the flash-off time between layers. Otherwise there will be a risk of lifting and waviness in the basecoat!		Until matt
	Flash-off after the last layer	Until matt		

NOTES: For large work surfaces and to ensure correct spray viscosity, prepare a new portion of the clearcoat for the final layer. Make sure that the coat fully flashes off before each next layer to ensure the correct matt finish across the whole work surface. The flash off time will depend on the actual thinner and hardener version combination and the application conditions.

INCLUSION REMOVAL


Spectral WAVE 2.0 basecoats	If any inclusions are evident after the first or second matt clearcoat is applied, wait approx. 20 min at 20°C, remove the inclusions with a P800-P1000 sponge sandpaper and then apply the next matt clearcoat layers.
Spectral BASE 2.0 basecoats	The inclusions cannot be repaired because of the limited flash-off time between layers.

CURING TIMES

	H 6115 STANDARD / Spectral SOLV 855 SLOW	
	20°C	60°C
Dust-free	20 min	5 min
Tack-free	2 h	10 min
Operating hardness	16 h	30 min
Final hardness	5 days	30 min + 2 days/20°C

CAUTION: The curing times depend on the temperatures of the individual workpieces. The cabin temperature should be approx. 10°C higher.

IR DRYING

	Distance The time depends on the type and power of the lamp	Follow the recommendations of the equipment manufacturer 15 ÷ 20 min
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CAUTION: Start IR heating once the last layer has turned matt.

RELATED PRODUCTS, DEPENDING ON THE PROCESSING TEMPERATURE

	15 ÷ 20°C	20 ÷ 25°C	25 ÷ 35°C	+ 35°C
Spectral H 6115	Fast	Standard	Standard / Slow	Extra Slow
Spectral SOLV 855	Standard	Standard / Slow	Slow / Extra Slow	Extra Slow

Spectral PLAST 775 ELASTICITY IMPROVER

To increase the elasticity of the coating on plastic parts or to increase the gravel resistance of the coat (i.e. on the front fascia and the bonnet), add Spectral PLAST 775 at 10% (vol.) of the ready-to-use mixture of Spectral KLAR 535-00 and Spectral H 6115, while adjusting the amount of the thinner as necessary. NOTE: Adding Spectral PLAST 775 will increase the gloss level.

GLOSS LEVELS WITH ACRYL CLEARCOATS

To produce a semi-matt or semi-gloss finish, add Spectral KLAR-525-00 at the right volume ratio to the Spectral KLAR 535-00 matt clearcoat. Add the hardener at the ratio correct for the total of the A components (matt clearcoat and the glossy clearcoat) according to each TDS of these coats. Add the SOLV 855 thinner only in a ratio to the 535-00 clearcoat. See the "Mixing ratio by weight" tables in the TDS or use the CarColor software.

Volume ratio per gloss level (use the CarColor software): <u>Spectral KLAR 535-00 Matt</u> Spectral KLAR 525-00 Clearcoat	Gloss level definition	Gloss level at 85°
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$\frac{100}{30}$	Semi-gloss	70
$\frac{100}{20}$	Semi-matt	40
$\frac{100}{0}$	Matt	10

The gloss level may vary with the coat layer thickness, the orientation of the recoated element, the hardener and thinner combination, and the application technique. A lower coat thickness with a dry application method reduces the gloss level. Conversely, a higher coat thickness and a wet application method increases the gloss level.

EQUIPMENT CLEANING

Spectral 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 535-00	24 months/20°C
Spectral H 6115 Standard, Slow, Extra Slow	18 months/20°C
Spectral SOLV 6115 Fast	12 months/20°C
Spectral SOLV 855	24 months/20°C
Spectral PLAST 775	24 months/20°C

SAFETY

See the Safety Data Sheet.

OTHER INFORMATION

Index number: 000024104.

The effectiveness of our systems results from laboratory research and many years of experience. The data contained here 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 perform a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if final results were affected by factors beyond our control.

ADDITIONAL INFORMATION

Avoid exposure of matt surfaces with fuels and oils. Remove these contaminants immediately to prevent permanent damage to the coating or a permanent gloss level change.

The recoated vehicle **MUST NOT** be polished. Polishing will result in non-uniform (patched) gloss level increase. To preserve the matt finish, avoid all types of polishing media and wax pastes.

Avoid automatic car washing or washing in direct sunlight.

The recommended method of washing a matt-coated vehicle is by hand with a soft, clean sponge. It is recommended to dry the car with compressed air or a soft, dry wipe afterwards.

The matt finish may change due to normal use of the vehicle, e.g. rubbing with rough clothing when opening or closing the doors, bonnet, boot, etc.

WEIGHT RATIO OF COMPONENTS			
MATT version (diluted with 40% SOLV 855):			
CAUTION! In order to obtain a coating with appropriate parameters, it is very important to precisely dose the components.			
Mixture quantity	Spectral KLAR 535-00	Spectral H 6115	Spectral SOLV 855
0.10 l	61 g	15 g	22 g
0.15 l	91 g	23 g	33 g
0.20 l	122 g	30 g	44 g
0.25 l	152 g	38 g	55 g
0.30 l	183 g	45 g	66 g
0.40 l	244 g	60 g	87 g
0.50 l	305 g	76 g	109 g
0.75 l	457 g	113 g	164 g
1.00 l	609 g	151 g	218 g
2.00 l	1218 g	302 g	436 g
MATT version (diluted with 50% SOLV 855):			
CAUTION! In order to achieve a coating with the appropriate parameters it is very important to precisely measure the components.			
Mixture quantity	Spectral KLAR 535-00	Spectral H 6115	Spectral SOLV 855
0.10 l	57 g	14 g	26 g
0.15 l	86 g	21 g	39 g
0.20 l	115 g	29 g	51 g
0.25 l	144 g	36 g	64 g
0.30 l	172 g	43 g	77 g
0.40 l	230 g	57 g	103 g
0.50 l	287 g	71 g	129 g
0.75 l	431 g	107 g	193 g
1.00 l	574 g	142 g	257 g
2.00 l	1149 g	285 g	514 g

SEMI-MATT version (with **20% KLAR 525-00** and diluted with **40% SOLV 855**):

CAUTION!

In order to achieve a coating with the appropriate parameters it is very important to precisely measure the components.

Mixture quantity	Spectral KLAR 535-00	Spectral KLAR 525-00	Spectral H 6115	Spectral SOLV 855
0.10 l	51 g	11 g	18 g	18 g
0.15 l	76 g	17 g	27 g	27 g
0.20 l	102 g	22 g	36 g	36 g
0.25 l	127 g	28 g	45 g	45 g
0.30 l	152 g	33 g	54 g	55 g
0.40 l	203 g	44 g	73 g	73 g
0.50 l	254 g	55 g	91 g	91 g
0.75 l	381 g	83 g	136 g	136 g
1.00 l	507 g	110 g	181 g	182 g
2.00 l	1015 g	220 g	363 g	364 g

SEMI-GLOSS version (with **30% KLAR 525-00** and diluted with **40% SOLV 855**):

CAUTION!

In order to achieve a coating with the appropriate parameters it is very important to precisely measure the components.

Mixture quantity	Spectral KLAR 535-00	Spectral KLAR 525-00	Spectral H 6115	Spectral SOLV 855
0.10 l	47 g	15 g	19 g	17 g
0.15 l	70 g	23 g	29 g	25 g
0.20 l	94 g	30 g	39 g	34 g
0.25 l	117 g	38 g	48 g	42 g
0.30 l	141 g	46 g	58 g	50 g
0.40 l	188 g	61 g	77 g	67 g
0.50 l	235 g	76 g	96 g	84 g
0.75 l	352 g	114 g	145 g	126 g
1.00 l	469 g	152 g	193 g	168 g
2.00 l	938 g	304 g	386 g	336 g