

**TRANSPARENT MAT HS- DIFFERENT GLOSS****923.MAT4****D89**

SCHEMA TECNICA

EDIZ. 2004/42/IIB  
4-2011 (e) (840) 610

**923.MAT4** is the acrylic clear 2k, mat, offering high solid residue with a high degree of opacity together with good resistance to scratch.

**923.MAT4** is normally used on the Bumper of cars, on the motorcycles, and as a rule where it is necessary apply on the base-coat mat a clear coat with a good degree of opacity.

923.MAT4 can be applied both in solvent ( 900 Multicryl ) as in waterborne (120 Hydropal) base-coat mat.

To obtain an homogeneous mat surface it is necessary to spray very regularly the same thickness of product on all the support.

With a regular and homogeneous application, on applying always the same thickness, it is possible to paint big surfaces too, like the roof or the bonnet of the car.

**The clear 923.MAT4 must be completely reticulated before to be exposed to the exterior.** ( AFTER THE APPLICATION, wait minimum 48 hours at 20°C - or ,after 60' at 60°C., 24 hours BEFORE TO EXPOSE THE ELEMENT TO THE EXTERIOR.)

If the gloss required is near 10 - 20, it is necessary to apply about 40 or 50 microns, to have an homogeneous final mat effect with the same level of gloss..

**It is possible to obtain different level of gloss, on mixing 923.MAT4 with the clear 223.FLASH.**

Here the table reporting different glosses following different mixing ratio between 923.MAT4 and 223.FLASH.

## **Table of glosses**

**ALL REPORTED DATA ARE IN WEIGHT.**






















**The required hardener is 293.HS20**

**The required thinner is 075.0020**

MIXING RATIO IN WEIGHT	APPLIED ON SOLVENT BASE-COAT		APPLIED ON W.B. BASE-COAT		% IN WEIGHT OF HARDENER 293.HS20	% IN WEIGHT OF THINNER 075.0020
	GLOSS 24 h a 20°C   60' a 60°C		GLOSS 24 h a 20°C.   60' a 60°C			
923.MAT4 100	17	12	12	9	30	70
923.MAT4/223FLASH 95/5	30	28	18	15	30	70
923.MAT4/223FLASH 90/10	50	45	40	30	30	60
923.MAT4/223FLASH 85/15	55	53	50	43	30	60
923.MAT4/223FLASH 80/20	65	58	61	56	30	60

**The high quantity of added thinner allows a more easy and homogeneous application.**

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**923.MAT4**

	Natura del prodotto Nature of product Produktbasis Nature du Produit	Acrylic			Spessore film secco Dry film thickness Trockenschichtstarke Epaisseur du film sec	20- 30 micron
	Aspetto Appearance Aussehen Aspect	Mat 3- 5 GLOSS			Appassimento Flash time Abluftzeit Dessèchement	15'
	Colore Colour Farbe Couleur	Opalescent			Fuori polvere (20° C) Dustfree Staubtrocknen Hors poussière	20'
	Viscosità vendita Selling viscosity Verkaufviskosität Viscosité de vente	50 +- 5 DIN 4			Secco al tatto (20° C) Touch free Berührungstrocknen Sec au toucher	60'
	Peso specifico Specific gravity Spezifisches gewicht Poids spécifique	0,985			Pronto al montaggio 20°C Dry to assemble 20°C Montage fertig 20°C Dur pour assemblage 20°C	24 hours
	Rapporto miscela Mixing ratio Mischverhältnis Proportion de melange				Essic. Completa Throigh drying 20°C Durckgetrocknet 60°C Sec en profondeur	48 hours at 20°c.(ON INTERIOR 60' at 60°c.+ 24 H. ON INTERIOR
  	Prodotto - Product Produkt - Produit  Catalizzatore - Hardener Harter - Catalyseur  Diluyente - Thinner Verdunner - Diluant	923.MAT4 100 (WEIGHT)  293.HS20. 30 (WEIGHT)  075.0020 70 (WEIGHT)		    	Sopraverniciabile Next coat wet-on-wet Überlackierbar Recouvrable  Cart manuale bagnato Sanding by hand wet Schleifenman.nass Papier abrasif à l'eau  Cart. Manuale secco Sanding by hand dry Schleifenman. Trocken Papier abrasif sec	
	Pot - life (20° C) Topfzeit (20° C) Vie en pot (20° C)	2 HOURS			Roto orbitale bagnato Flat bed sander wet Schleifenmask.nass Orbital mouille	
	Viscosità applicazione Spraying viscosity Verarbeit viscosität Viscosité d'application	13'' +- 1 Din 4			Roto orbitale secco Flat bed sander dry Schleifenmask.troc Orbital sec	
	Tazza a caduta Gravity feed spray gun Fließbecher Projecteur - buse	1,2 - 1,3 mm			Lucidatura Polishing Polierung Polissage	
	Tazza ad aspirazione Suction feed spray gun Saugbecher Projecteur - buse	1,6- 1,7 mm			Resa Yield Ergiebigkeit Rendement	10 about
	Pressione aria (bar) Air pressure Luftdruck (bar) Pression d'application	3 - 4 normal gun  2 HLVP			Prodotti Complementari Subsidiary products	293.HS10 FAST 293.HS30 SLOW 075.0015 FAST THINNER
	Numero mani Number of coats Spritzegänge Nombre des couches	2 SPACED OF 5'			Komplementar Produkte Produits Complementaires	
	Applicazione Spatola Application of putty Auftragung spachtel Application a spatule				Conservabilità Ageing Haltbarkeit Conservabilité	2 years in dry and fresh place

TDS : D58 2004/42/IIB

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