

Technical Information

Gloss levels – Mat finish



Refinishing process for baslac basecoat/clear coat systems with:

baslac 40-620 2K Clear extra mat

baslac 40-440 2K VOC Clear

baslac 40-450 HS Universal Clear VOC

- Due to the different mixing ratios of the baslac clears, you may achieve a gloss level between **12-65 units (at an angle of 60°)**. The gloss level may be higher for light and pure silver colors. Additionally, car bodies may show gloss level differences between vertically and horizontally coated panels. Therefore, we recommend producing a spray-out sample before each refinishing job and to compare it to the area to be repaired.
- Deviations of + or – 5 GU (gloss units) are possible.
- In order to avoid any gloss deviation when refinishing mat clear coats, it is important to:
 - Stir 40-620 thoroughly manually.
 - Apply two equally full layers and staggered overlaps to produce consistent basecoat and clear coat film thicknesses.
 - Allow the clear to flash off until completely mat after each spray coat. (Generally, after the first spray coat 10-15 min and after the second spray coat 15-20 min before baking. That depends on air speed and spray booth temperature.) **Do not flash off for more than 25 min.**
 - Use baslac 50-420 2K Clear Hardener VOC normal and 60-20 Reducer Universal Normal.
 - Use a gravity spraygun with 1.3 nozzle size.
- With mat surfaces it is **not** possible:
 - To remove dust inclusions by polishing because polishing changes the gloss level. Therefore, it is important to work carefully during cleaning and application.
 - To fade out the clear because the film thickness in the blending area varies, which changes the gloss level. Therefore, panel repair is mandatory.
- Correct gloss levels will be achieved after:
 - 24 h when baking 30 min at 60°C.
 - 72 h when airdrying.
- Please also observe the technical product data sheet for baslac 40-620 2K Clear extra mat.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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Mixing ratios of the baslac clear coats 40-620 and 40-450 for 12-65 gloss units. Mixing ratios in % by weight.				
Gloss unit +/- 2 for 60° measurement geometry	40-620	40-450	50-420	60-20
12	100	0	33	17
20	95	5	34	17
25	92	8	35	17
30	90	10	35	16
40	84	16	36	16
53	77	23	37	16
65	70	30	38	16

Mixing ratios of the baslac clear coats 40-620 and 40-440 for 12-65 gloss units. Mixing ratios in % by weight.				
Gloss unit +/- 2 for 60° measurement geometry	40-620	40-440	50-420	60-20
12	100	0	33	17
20	94	6	34	16
25	91	9	34	15
30	88	12	35	15
40	82	18	35	14
53	74	26	36	12
65	68	32	37	11

Safety instructions:

**The products are suitable for professional use only.
It cannot be ruled out that this product contains particles < 0.1 µm.**

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