

Peugeot KAH Ice Black

Technical Bulletin

09/11/2019

L8.07.03 UK & Ireland







DESCRIPTION

To imitate the structured clearcoat finish of Peugeot’s “Ice” colors.

Suitable for application on OEM and Basecoat WB GT

The desired structure and gloss level can be achieved by adding Propyltex 140S to Multi Matt Clear.

Due to the variations in structure/gloss of the OEM we advise to create a set of spray-out panels that can be used as reference.

Mixing ratio		100 42 55	Multi Matt Clear (+ 2-3% of Propyltex 140S) Multi Matt Clear Hardener Multi Matt Clear Reducer						
Equipment		Spray gun set up: 1.3-1.4 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap						
Application		STEP 1: 1 x 1 Multi Matt Clear Low-Gloss (+ 2-3% of Propyltex 140S) STEP 2: 1-2 x 1 Multi Matt Clear Low-Gloss / Semi-Gloss							
Flash-off		Between coats Until matt	Before curing Until matt						
Drying		Reducer Standard Reducer Slow	<table border="0"> <tr> <td>20°C</td> <td>60°C</td> </tr> <tr> <td>1 hr</td> <td>20 min</td> </tr> <tr> <td>1.5 hrs</td> <td>25 min</td> </tr> </table>	20°C	60°C	1 hr	20 min	1.5 hrs	25 min
20°C	60°C								
1 hr	20 min								
1.5 hrs	25 min								
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator							

Read complete technical data sheet for detailed product information

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STRUCTURE AND GLOSS LEVEL BY SPRAY OUT SAMPLES

Due to the variations in structure of the OEM we advise to create a set of spray-out panels by applying the following samples over KAH Ice Black basecoat.

With this color the first layer consists of Multi Matt Clear Low-Gloss with a certain amount of Propyltex 140S, followed by a second layer of Multi Matt Clear Low-Gloss / Semi-Gloss.

Step 1: First layer (1-layer application) start with 2 sets of 4 panels each

Panel	Mixture
1 – 4	Multi Matt Clear Low-Gloss + 2% Propyltex 140S
5 – 8	Multi Matt Clear Low-Gloss + 3% Propyltex 140S

Step 2: Second layer (1 or 2-layer application)

Panel	Multi Matt Clear
1 + 5	60% Low-Gloss + 40% Semi-Gloss 1 coat
2 + 6	60% Low-Gloss + 40% Semi-Gloss 2 coats
3 + 7	70% Low-Gloss + 30% Semi-Gloss 1 coat
4 + 8	70% Low-Gloss + 30% Semi-Gloss 2 coats

The required gloss and structure level can be determined by using these samples.

Number each panel, indicating the Multi Matt Clear, percentage of Propyltex 140S and number of layers on each panel.










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REPAIR PROCESS

Application		Apply basecoat KAH Ice Black according to TDS						
Mixing		STEP 1 Add the required amount of Propyltex 140S to Multi Matt Clear Low Gloss						
Mixing ratio		100 Multi Matt Clear Low-Gloss (+ 2-3% of Propyltex 140S) 42 Multi Matt Clear Hardener 55 Multi Matt Clear Reducer						
Equipment		Spray gun set up: 1.3-1.4 mm Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap						
Application		Apply 1 coat, allowing to flash-off until completely matt						
Mixing		STEP 2 Mix Multi Matt Clear Low-Gloss and Semi-Gloss in the required ratio						
Mixing ratio		100 Multi Matt Clear Low-Gloss / Semi-Gloss mixture 42 Multi Matt Clear Hardener 55 Multi Matt Clear Reducer						
Application		Apply 1 or 2 coats (as determined from spray outs), allowing to flash-off until completely matt						
Drying		<table border="0"> <tr> <td>Reducer Standard</td> <td>20°C 1 hr</td> <td>60°C 20 min</td> </tr> <tr> <td>Reducer Slow</td> <td>1.5 hrs</td> <td>25 min</td> </tr> </table>	Reducer Standard	20°C 1 hr	60°C 20 min	Reducer Slow	1.5 hrs	25 min
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NOTES

- Check spray-outs adjacent to the panel under repair
- Stir thoroughly after addition of the Propyltex 140S to the Multi Matt Clear
- Do not use a mesh below 125 microns for paint straining
- Blending of the mixture Multi Matt Clear / Propyltex 140S mix is not advised, therefore always paint this mixture edge to edge.
- It is advised not to paint single panels
- The basecoat (color) can be faded out on the (adjacent) OEM panel.
- First carefully sand away the structured OEM clearcoat with P800-P1000.
- Prevent sanding through the original clearcoat without damaging the basecoat
- After application clean the spray gun thoroughly to avoid contamination.

Product storage	After use close container directly, and store in a dry place
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