



HiQ Matt Clear (MC-2500)

Version 24.03

PRODUCT DESCRIPTION

■ Outline

HiQ Matt Clear MC-2500 is an acrylic urethane clearcoat which is applicable to a matt finish such as the underbody of a vehicle.

MC-2500C is a non-gloss type clearcoat and suitable for plastic bumper. It offers excellent matt finish and various gloss level.

■ Suitable Substrates

- HiQ basecoat colors (metallic/solid/pearl)
- Bodyian basecoat colors (metallic/solid/pearl)
- WATER Q waterbased system (metallic/solid/pearl)
- OEM finishes
- Thoroughly dried two-component coats (urethane, epoxy, etc.)

■ Product Configuration

Product Name	Pack(ℓ)	Contents(ℓ)	Storage
HiQ Matt Clear (MC-2500)	4.0	4.0	12 months
Matt Clear Hardener (CCH-200, 230, 250)	1.0	1.0	12 months

* Standard temperature of storage is 20°C.

■ Mixing Viscosity

13~15 sec. Viscosity(A+B+T) Ford Cup #4 at 77°F (25°C)

■ Pot Life

4 hours at 77°F (25°C) after mixing

■ Hardener

	Temperature			
	5~15°C	10~25°C	20~35°C	30°C or above
1~2 panel repair	CCH-250	CCH-200	CCH-230	CCH-230
Multi panel repair	CCH-250	CCH-200	CCH-230	CCH-230
Overall repair	CCH-200	CCH-200	CCH-230	CCH-230

APPLICATION GUIDE

■ Use

Stirring



Stir thoroughly before use.

Surface Preparation



Apply clearcoat after applying basecoat and wiping off the dust in the fully-dried condition.

Mixing Ratio



Product Name	Mixing Ratio
HiQ Matt Clear (MC-2500)	2
Matt Clear Hardener (CCH-200, 230, 250)	0.8
HiQ Urethane Thinner DR-421 Series	0.2

* Mix by volume.

Spray Condition



1.8~2.5 bar

2 wet coats keeping 15~20cm from the surface

Fluid tip : 1.3~1.4mm, D.F.T.=50~60μm



Flash time : 10 min

Set time : 10 min

Protective Equipment



Use fresh air mask or charcoal respirator to avoid inhaling or being exposed to fumes.

■ Mixing - Desired Gloss Level

All gloss levels between M1-M5 can be achieved by mixing MC-2500 and Medium Solid Clearcoat by weight.

It is recommended to create a reference spray out.

Gloss levels will vary depending on the following:

- ▶ Basecoat type and Color
- ▶ Flash time between coat
- ▶ Flash time before bake
- ▶ Temperature and humidity
- ▶ Accuracy of mixing
- ▶ Position of repair on vehicle
- ▶ Layer thickness

Gloss Level	60° Gloss Achieved	MC-2600(weight)	MS Clearcoat(weight)
M1 - Low Gloss	8~13	100 parts	0 parts
M2	15~20	97.5 parts	2.5 parts

M3	25~30	95 parts	5 parts
M4	45~50	90 parts	10 parts
M5 - Semi Gloss	80~85	80 parts	20 parts

■ Drying Times

	Temp.	Time	Temp.	Time	Remark
Set time	25°C	10 min			
Time to handle	25°C	10 hrs	60°C	30 min	
Time to stripe	25°C	10 hrs	60°C	30 min	

(*) If coats are thicker, the drying schedule will be delayed.

ADDITIONAL INFORMATION

■ Recoatability

- 1) Recoatable time : 24 hours at ambient temperature after force dry
- 2) Sand and wipe off the dust with DR-180 before recoating.



Dry sand P800



Wet sand P400 - P500

■ Blending



Product : HiQ Blending Reducer (DR-600)

Spray pressure : 2 bar

Number of coats : 1~2 coats

- Procedure :
- 1) Apply HiQ Matt Clear. (MC-2500)
 - 2) On the second application, apply wider than the first application area.
 - 3) Dilute MC-2500 with DR-600 by the portion of 1:1 and apply once wider than the previous application area.
 - 4) Melt the edge of the previous coat using DR-600.

■ VOC Content

VOC content of 4.2lbs/gal (500g/liter)

■ Notice

1. For 2K products, short pot life, delayed drying time or unreactive substance can occur depending on hardener volume. Thus please mix base(A) and hardener(B) according to the proper mixing ratio.
2. Stir thoroughly before use.
3. Avoid direct sunlight during delivery, storage and handling. Store in a cool, dry dark place under room temperature(5°C-35°C).
4. Keep container tightly closed and store upright. When spilled, absorb contents with sand.

5. During application(including touch-up application), color difference may occur depending on mixing ratio, painting tools and application method. It may occur in same color product and same LOT No.
6. Please check whether color difference occurred or not. If possible, apply the same LOT No. product in consistent application method.
7. Putty marks might appear when you directly apply over the lacquer coating. As time goes by, it can peel off.
8. Completely eliminate the moisture of spray equipment before use.
Cleanse immediately after application not to have any leftover on spray equipment.
9. Suitable condition for application and hardening is 10°C or above.
10. Surface temperature must be at or above 3°C to avoid moisture condensation.
11. Do not mix with other paint products.
12. Proceed a test application before applying on a precedent or an old paint film (check adhesion, color spread and transparency).
13. Please refer to technical data sheet before system application(primer, midcoat and topcoat).
14. Please do not apply paint above 85% RH or below 5°C because it may influence physical properties.
15. Contents must not flow into drain, river and soil.
16. Hardener must be stored under room temperature, avoid direct sunlight and keep away from humidity.
17. To prevent environmental pollution, dispose contents after complete use and dispose the residue through waste disposal company authorized by the ministry of environment.
18. Beware of ingestion, inhalation and contact of animals and plants.
19. Use masking tape, covering tape, vinyl or newspapers to cover areas that should not be painted.

■ Health and Safety

1. Be well-informed of MSDS before use.
2. Keep out of the reach of infants and children. Do not apply a product to baby products and food containers.
3. Do not use a product for any other uses. (Sniffing is prohibited. Do not use as a fuel.)
4. If on skin or eye, wash thoroughly with running water and get a medical treatment.
5. Do not apply a product in an enclosed area.
In order to prevent suffocation during application and drying, use power blower to keep the area fully ventilated. Workers must wear gas mask and safety gears all the time.
6. Contents include organic solvents and can cause health problems such as headache, dizziness and dermatitis.
Do not ingest or inhale the product and avoid skin contact.
Wear safety glasses, coveralls and latex gloves when mixing and applying.
7. Keep away from fire and heat during application or storage because it is flammable and has risk of fire.
Beware of spark from impact, droppage and friction while handling.
8. Storing a product with combustible substances such as stained clothes or paper may cause fire by spontaneous ignition. Thus do not pile products with combustible substances.
Keep it in a non-flammable container filled with water, then put a lid on and dispose it.
9. Please contact our customer service or refer to GHS-MSDS and technical data on the website for further details.