



4725 S. Camp Kearns Rd.
Kearns, UT 84118
(801) 966-5300
www.lusidtechnologies.com



TECHNICAL DATA SHEET

MC311 2.1 VOC AUTOMOTIVE MATTE CLEAR

04122021



MC311 is a premium automotive 2.1 VOC matte finish clear which is required in certain applications, such as the sign industry and other OEM applications requiring a 10° gloss rating.



COMPONENTS

- | | |
|---------------------|---|
| • MC311 | Matte Finish Clear |
| • H5/H05 | Low VOC/National Rule Activators |
| • S065/S075/S085 | Fast/Medium/Slow – Low VOC Reducers |
| • S9860/S9870/S9885 | Fast/Medium/Slow – National Rule Reducers |
| • GS065/075/085 | Fast/Medium/Slow Low VOC Reducers |



MIXING RATIO

Mix three (3) parts MC311 clear with one (1) part selected activator and one (1) part selected reducer.



POT LIFE

2 hours @ 77° F/25° C



CLEAN UP

Use NORTHSTAR Lacquer Thinner or zero VOC solvents. (Check local regulation)



PHYSICAL DATA

Solids wt. (as mixed)	36.11 %
VOC as mixed (restricted areas)	2.09 lbs
Color	Clear



DRY / FLASH TIMES

Air Dry at 77° F/25°C	
Flash between coats	15-20 minutes
Tack free	60 minutes
Dust free	30 minutes



GUN SETUPS

Compliant

Gravity Feed	1.3 mm – 1.5 mm
Siphon Feed	1.3 mm – 1.5 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed	30 – 40 psi
Siphon Feed	35 – 45 psi
HVLP at cap	8 – 10 psi



SURFACE PREPARATION

Use NORTHSTAR Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.



APPLICATION AT 77° F/25°C

- Apply 2 medium wet coats over substrate to desired film thickness
- Allow 10 – 15 minutes between coats
- Scuff after 24 hours before recoating
- Clean gun after spraying is completed



SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

NORTHSTAR