

Flattening Paste Addition Chart

Add the listed amount of flattening paste in ounces to one gallon of 90 sheen product, to reach the desired sheen level. To reduce the gloss of a 90 sheen product to a 20 sheen may require a lot of flattening paste, the extra solvent in the paste could reduce the viscosity and the solid of the coating excessively. The flattening paste chart is a good tool to reduce the gloss of any coating for 10 to 20 degrees maximum.

For example, if one wants to sheen down 117-1050 to 117-1030 use the number listed for the 30 sheen (14.9) to subtract the number listed for the 50 sheen (10.1), which equal to 4.8: add 4.8 oz of 870-1432 per gallon of 117-1050 to make 117-1030.

680 VOC

Gloss	Nitrocellulose Clear Topcoat	Pre-Catalyzed Clear Topcoat				Post-Catalyzed Clear Topcoat	
	Chemlack 441-21XX	Varicure® 431-46XX	E. S. Lacquer Elite II 431-47XX	Airguard® Solvent PreCat 431-58XX	Chemguard II 431-70XX	Plastofix® Light 421-48XX	E-Var 421-80XX
Flattening Paste	870-1432	870-1432	870-1432	870-1432	870-1432	870-1432	870-1432
90	0	0	0	0	0	0	0
70	0.3	0.9	0.8	0.1	0.5	6	6.3
60	0.5	1.3	1.2	1.1	0.8	6.7	7
50	0.7	2.3	2.1	1.8	1.7	14.8	15.5
40	0.8	2.6	2.4	2	2	16.6	17.4
35	1	3.3	2.8	2.5	2.5	17.1	18
30	1.3	4.2	3.7	3.3	3.1	18	18.9
20	1.9	6.3	5.5	4.8	4.7	24.6	25.7
10	2.8	9	8	7	6.8	34.9	34.8

Gloss	Nitrocellulose Pigmented Topcoat	Pre-Catalyzed Pigmented Topcoat			Post-Catalyzed Pigmented Topcoat		Polyurethane
	Chemlack White 230-65XX	E.S. Lacquer II White 131-11XX	Variset® 131-70XX	Variset® Plus 131-71XX	Plasticolor 117-10XX	Chemlife® White 117-24XX	ora Verde Unico 436-66XX
Flattening Paste	870-1432	870-1432	870-1432	870-1432	870-1432	870-1613	870-1432
90	0	0	0	0	0	0	0
70	0.8	0.9	1	2	4.5	3.8	0.9
60	1.4	1.3	1.6	3.2	6.3	5.4	1.3
50	2	2	2.5	5	10.1	8.6	2.3
40	3	2.6	3.7	7.4	12.2	10.4	2.3
35	3.5	3.1	4.3	8.6	13.1	11.1	3.3
30	4	5.1	5	10	14.9	12.7	4.2
20	6.3	7.5	7.8	17.6	21.8	18.5	6.3
10	8.8	10.6	11	22	30.9	26.3	9

Flattening Paste Addition Chart

275/550 VOC

Gloss	Nitrocellulose Clear Topcoat			Pre-Catalyzed Clear Topcoat		Post-Catalyzed Clear Topcoat		
	Chemlack Express 275 441-22XX	Chemlack 550 441-27XX	Chemlack 275 441-51XX	Varicure® 275 431-17XX	Opticlear Light 550 431-85XX	Plastofix® Plus 550 421-56XX	E-Var 550 421-82XX	E-Var 275 421-84XX
Flattening Paste	870-1432	870-1432	870-1432	870-1432	870-1432	870-1432	870-1432	870-1432
90	0	0	0	0	0	0	0	0
70	0.2	0.28	0.15	0.78	0.6	4.1	6.6	5.4
60	0.3	0.45	0.25	1.2	0.9	4.6	7.7	6.3
50	0.46	0.67	0.35	2	1.5	10.2	16	14
40	0.52	0.75	0.4	2.3	1.7	11.5	18.2	15.8
35	0.65	0.9	0.5	2.9	2.2	11.8	19.1	17.1
30	0.85	1.25	0.65	3.7	2.8	12.4	20	18
20	1.2	1.8	0.95	5.5	4.2	16.9	26.2	22.5
10	1.8	2.7	1.4	7.9	6	24.1	35.1	31.6

Gloss	Nitrocellulose Pigmented Topcoat		Pre-Catalyzed Pigmented Topcoat		Post-Catalyzed Pigmented Topcoat
	Chemlack Express 275 White 230-22XX	Chemlack White 230-27XX	Varset® 275 131-17XX	Optiset® White 131-82XX	Plasticolor 117-19XX
Flattening Paste	870-1432	870-1432	870-1432	870-1432	870-1432
90	0	0	0	0	0
70	1.48	0.8	1.3	1	4.8
60	2.6	1.4	2.1	1.6	6.7
50	3.7	2	3.3	2.5	10.7
40	5.55	3	4.9	3.7	12.9
35	6.4	3.5	5.7	4.3	13.9
30	7.4	4	6.7	5	15.8
20	11.7	6.3	10.4	7.8	23.1
10	16.3	8.8	14.6	11.0	32.8

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