



**GENERAL INFORMATION:**

8-614 HS420 Air Dry Clear Coat is a polyurethane high quality clear coat with high durability for application over WaterBase 900\* Series and BeroBase 500 Series. Suitable for all types of repairs with very good drying and processing properties. Specially developed for air drying and also suitable for low bake and force drying.



**COMPONENTS:**

- 8-614 HS420 Air Dry Clear Coat
- 8-430 Hardener Very Fast
- 8-440 Hardener Fast
- 8-450 Hardener Medium
- 1-141 Uni Thinner Fast
- 1-151 Uni Thinner Standard
- 1-161 Uni Thinner Slow
- 47-39 2K Elastic



**SUBSTRATES:**

WaterBase 900\* Series (MM 900-999)  
BeroBase 500 Series (MM 500-599)

**Non-EU product**



**SURFACE PREPARATION:**

Base coat should be fully dry.



**MIXING RATIO:**

3 : 1 + 5% Clear Coat : Hardener + 5% Uni Thinner



**ADDITIVES:**

47-39 2K Elastic (information see TDS)



**POTLIFE at 20°C (68°F):**

Hardener	8-430	8-440	8-450
Potlife (min.)	20	30	55



**GUN SET UP:**

	Nozzle size (mm)	Spraying pressure (bar/psi)
HVLP	-	-
HE	1,2-1,4	2,0-2,5/ 29-36
Pressure pot	-	-



**APPLICATION:**

1,5-2 coats 50-60 µm (2.0-2.4 mil)



1,5 coats: No flash off  
2 coats: 5 min. flash off between coats



**FLASH OFF & DRY TIMES:**

	Hardener	Flash off before bake (min.)	Dust free (min.)	Dry to handle (min.)	Dry to polish (h)
Air Dry 20°C (68°F)	8-430	x	25	90-110*	5
	8-440	x	35	120-140*	12
	8-450	x	45	130-150*	16
Low bake 40°C (104°F)	8-430	x	x	x	x
	8-440	2-5	x	30	after cooling down
	8-450	2-5	x	45	
Forced Dry 60°C (140°F)	8-430	x	x	x	x
	8-440	2-5	x	20	after cooling down
	8-450	2-5	x	30	

\* Depending on the layer thickness and temperature



**CLEAN UP:**

1-051 Gun Cleaner



**PHYSICAL DATA:**

<b>EU regulations</b>		
VOC code	2004/42/IB(d)(420)402	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product	IIB/d. Topcoat - All types. EU limit values: 420g/l. (2007). This product contains a maximum of 402 g/l VOC.	
<b>Physical properties</b>		
8-614	Chemical Base	Clear polyurethane finish
	Specific gravity	0,997 g/l
	Flash point closed cup	34°C
	Vol. % solids	48
Ready to spray	Viscosity	17-19 sec Din Cup4 20°C (68°F)
	Economy	10 m <sup>2</sup> /L/50 µm
	Gloss	High Gloss
	Colour	Clear

**STORAGE /SHELF LIFE:**

8-614 HS420 Air Dry Clear Coat min. 2 years  
(Under normal storage conditions and unopened tins)