

## GENERAL INFORMATION

8-614 HS420 Air Dry Clear Coat is a polyurethane high quality clear coat with high durability for application over MM 900 - 9999 WaterBase 900\* Series and MM 500 - 5999 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.

### MIXING RATIO



3 : 1 Clear Coat : HS420 Hardener + 5% Uni Thinner

### GUN SET UP



|      | NOZZLE (MM) | AIR PRESSURE (BAR / PSI) |
|------|-------------|--------------------------|
| HVLP | 1,2-1,4     | 2/29                     |
| HE   | 1,2-1,4     | 2,0-2,5/29-36            |

### APPLICATION



1½ - 2 coat 50 - 60 µm (2,0-2,4 mil)

### FLASH OFF AND DRY TIMES



|                               | HARDENER | FLASH OFF BEFORE BAKE (MIN.) | DUST FREE (MIN.) | DRY TO HANDLE (MIN.) | DRY TO POLISH (H)  |
|-------------------------------|----------|------------------------------|------------------|----------------------|--------------------|
| Air Dry<br>20°C<br>(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<br>40°C<br>(104°F)   | 8-430    | x                            | x                | x                    | after cooling down |
|                               | 8-440    | 2 - 5                        | x                | 30                   |                    |
|                               | 8-450    | 2 - 5                        | x                | 45                   |                    |
| Forced Dry<br>60°C<br>(140°F) | 8-430    | x                            | x                | x                    | after cooling down |
|                               | 8-440    | 2 - 5                        | x                | 20                   |                    |
|                               | 8-450    | 2 - 5                        | x                | 30                   |                    |

Depending on the layer thickness and temperature. Use matching thinners.

### SUBSTRATES



MM 900 - 9999 WaterBase 900\* Series and MM 500 - 5999 BeroBase 500 Series.

Basecoat should be fully dry.

### POT LIFE AT 20°C / 68°F



| HARDENER      | 8-430 | 8-440 | 8-450 |
|---------------|-------|-------|-------|
| Potlife (min) | 20    | 30    | 55    |

### COMPONENTS



8-430 HS420 Hardener Very Fast  
 8-440 HS420 Hardener Fast  
 8-450 HS420 Hardener Medium  
 1-141 Uni Thinner Fast  
 1-151 Uni Thinner Medium  
 1-161 Uni Thinner Slow  
 47-91 Spot Repair Thinner  
 1-231 Fade-Out Thinner

### ADDITIVES



47-39 2K Elastic  
 1-060 2K Structure Coat Fine  
 1-065 2K Structure Coat Coarse

Add before hardener.

### SURFACE PREPARATION



Mask entire vehicle to eliminate unwanted overspray.



### NEXT LAYER



### PHYSICAL DATA

| EU REGULATIONS   |   |                   |
|--|---|-------------------|
| VOC Code   | 2004/42/IIIB(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. | IIIB/d. Topcoat - All types. EU limit values: 420 g/L (2007). This product contains a maximum of 402 g/L VOC. |                   |
| Chemical Base  | 2K Polyurethane Finish  |                   |
| Viscosity (RTS)  | 17 - 19 sec Dincup 4 20°C   |                   |
| Specific Gravity (kg/l)  | 1,009   |                   |
| Flash Point Closed Cup   | 34°C / 93,2°F   |                   |
| Volume % Solids  | 50  |                   |
| Physical Properties  | 10 m²/L/50 µm   |                   |
|  | Economy   | 405 ft²/Gal/2 mil |
|  | Gloss   | High Gloss        |
| Colour   | -   |                   |



**DEBEER**  
REFINISH

**8-614**  
HS420 Air Dry Clear Coat

## PROTECTION

Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).



For more detailed information please visit the following link for the Safety Data Sheet:

[https://sds.de-beer.com/en/debeer/choose\\_localization](https://sds.de-beer.com/en/debeer/choose_localization)

## CLEAN UP



1-051 Gun Cleaner

## STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).



## NOTES

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