



GENERAL INFORMATION

8-615 HS420 Air Dry Clear Coat HT 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 forced drying.

MIXING RATIO



3 : 1 Clear Coat : HS420 Hardener + 10% Uni Thinner

GUN SET UP



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

APPLICATION



1 1/2 - 2 coat 50 - 80 µm (2,0-3,2 mil)

1,5 coats: No flash off between coats 2 coats: 5-10 min. flash off between coats.

FLASH OFF AND 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)	8-440	2 - 5	x	30	after cooling down
	8-450	5 - 10	x	45	
	8-460	10 - 15	x	60	
Forced Dry 60°C (140°F)	8-440	2 - 5	x	20	after cooling down
	8-450	5 - 10	x	30	
	8-460	10 - 15	x	35	

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

SUBSTRATES



MM 900 - 9999 WaterBase 900* Series and MM 500 - 5999 BeroBase 500 Series. Sanded and degreased old layers.

Basecoat should be fully dry.

POT LIFE AT 20°C / 68°F



HARDENER	8-430	8-440	8-450	8-460
Potlife (min)	20	35	40	55

COMPONENTS



- 8-430 HS420 Hardener Very Fast
- 8-440 HS420 Hardener Fast
- 8-450 HS420 Hardener Medium
- 8-460 HS420 Hardener Slow
- 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

Use 1-231 Fade-Out Thinner for blending or fade-out area's.

SURFACE PREPARATION



Mask entire vehicle to eliminate unwanted overspray.



NEXT LAYER



PHYSICAL DATA

EU REGULATIONS		
VOC Code	2004/42/IB(d)(420)412	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IB/d. Topcoat - All types. EU limit values: 420 g/l (2007). This product contains a maximum of 412 g/l VOC.	
Chemical Base	Air Dry Clear 3:1 HT	
Physical Properties	Viscosity (RTS)	16 - 18 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1,004
	Flash Point Closed Cup	34°C / 93,2°F
	Volume % Solids	48
	Economy	9,6 m²/L/50 µm 390 ft²/Gal/2 mil
	Gloss	High gloss
	Colour	-

The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. Unless Valspar agrees otherwise in writing, Valspar makes no warranties, express or implied, and disclaims all implied warranties including warranties of merchantability or fitness for a particular use or freedom from patent infringement. Valspar will not be liable for any special, incidental or consequential damages. Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option. © 2012 The Valspar Corporation. All rights reserved.

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DEBEER
REFINISH

8-615

HS420 Air Dry Clear Coat HT

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

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).



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