GENERAL INFORMATION

A multipurpose clear that is highly durable and can be used on a wide range of repairs due to its excellent processing properties. The clear can be mixed at a 2:1 mixing ratio with a choice of three hardeners. It can be air dried, low baked and forced dried.

MIXING RATIO



2:1 Clear: Allround Clear Hardener

	HARDENER	SMALL REPAIR	MEDIUM REPAIR	LARGE REPAIR
20°C - 25°C (68°F - 77°F)	8-74	✓	✓	
	8-75		✓	✓
	8-76			✓
25°C - 30°C (77°F - 86°F)	8-74	✓	✓	
	8-75	✓	✓	✓
	8-76		✓	✓
>30°C (>86°F)	8-74	✓		
	8-75	1	1	
	8-76		1	✓

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 coats 50 - 80 μm (2,0-3,2 mil) 2 coats: 5 - 10 min flash off between coats.

FLASH OFF AND DRY TIMES





	HARDENER	FLASH OFF BEFORE BAKE	DUST FREE TIME	DRY TO HANDLE	DRY TO POLISH
Air Dry 20°C	8-74	-	25 - 30 minutes	90 - 120 minutes	5 hours
	8-75	-	45 - 60 minutes	120 - 180 minutes	Overnight
Low bake 40°C	8-74	3 - 7 minutes	-	20 minutes	
	8-75	5 - 8 minutes	-	40 minutes	After cooling down
	8-76	8 - 10 minutes	-	60 minutes	
Forced Dry 60°C	8-75	8 - 10 minutes	-	20 minutes	After cooling
	8-76	11 - 15 minutes	-	30 minutes	down

SUBSTRATES



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

Basecoat should be fully dry.

POT LIFE AT 20°C / 68°F



25 - 40 minutes

Depending on the chosen hardener and temperature.

COMPONENTS



8-74 Allround Clear Hardener Fast 8-75 Allround Clear Hardener Medium 8-76 Allround Clear Hardener Slow 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 areas.

SURFACE PREPARATION



Mask entire vehicle to eliminate unwanted overspray.



NEXT LAYER



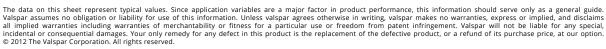
INFRARED DRYING



AFTER FULL FLASH OFF AND AT PROPER DISTANCE			
Half-bake	4 min 50°C		
Full-bake	10 min 65°C		
See IR Manufacturer information			

PHYSICAL DATA

EU REGULATIONS				
VOC Code		2004/42/IIB(d)(420)410		
Product sub category (according directive 2004/42/ EC) and max VOC content (ISO 11980-1/2) of the ready to use product.		IIB/d. Topcoat – All types. EU limit values: 420g/L. (2007) This product contains a maximum of 410 g/l VOC.		
Chemical Base	Polyurethane clear coat.			
	Viscosity (RTS)	17 - 19 Dincup 4 / 20°C		
	Specific Gravity (kg/l)	1,009		
	Flash Point Closed Cup	34°C (93.2°F)		
Phonical Properties	Volume % Solids	49		
Physical Properties	Economy	9,8 m²/L/50 μm		
		395 ft²/Gal/2 mil		
	Gloss	High gloss		
	Colour	-		







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 $10^{\circ}C$ - $30^{\circ}C$ / $50^{\circ}F$ - $90^{\circ}F$) (unopened container).



NOTES

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