DEBEER REFINISH 1-204
MS Clear Coat

GENERAL INFORMATION

1-204 MS Clear Coat is a high gloss clear finish that is very easy to use. Can be both air-dried and forced-dried.

MIXING RATIO



2 : 1 Clear Coat : MS Hardener + 0 - 10% Uni Thinner

If required, thin with Uni Thinner

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	2/29
HE	1,2-1,4	1,8-2,0/26-29
Pressure tank	0,85-1,2	3,5-4,5 /51-65

APPLICATION



2 coat 50 - 60 m (2,0-2,4 mil)

FLASH OFF AND DRY TIMES





AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	5 - 10 minutes	**Flash off**	5 - 10 minutes
Dust free	20 - 30 minutes	**Dust free**	-
Dry to handle	8 hours	**Dry to handle**	25 - 35 minutes
Dry to tape	-	**Dry to tape**	After cooling down
Dry to sand	-	**Dry to sand**	After cooling down
Dry to polish	8 hours	**Dry to polish**	After cooling down

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	

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



120 - 240 minutes

COMPONENTS



47-20 2K Hardener Air Dry
47-35 MS Hardener Fast
47-55 MS Hardener Medium
47-65 MS 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

Add before hardener.

SURFACE PREPARATION





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Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



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PHYSICAL DATA

PHYSICAL DATA 1-204 MS CLEAR COAT		
Chemical Base	2K Polyurethane Finish	
Physical Properties	**Viscosity (RTS)**	17 - 18 Dincup 4 / 20°C
	Specific Gravity (kg/l)	0,981
	Flash Point Closed Cup	29°C / 84,2°F
	Volume % Solids	36,9
	Economy	7,4 m²/L/50 m
		300 ft²/Gal/1,2 mil
	Gloss	High gloss
	Colour	-

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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).



NOTES

Specific information for use in Europe (EU): This product (ready for use) is not VOC compliant. Please refer to VOC declaration (2004/42/EC).

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