DEBEER REFINISH

8-407 / 8-409

HS Low Gloss Clear Coat
HS Semi Gloss Clear Coat

GENERAL INFORMATION

8-409 HS Semi Gloss Clear Coat is a premium system that consists of 8-407 HS Low Gloss Clear Coat and 8-409 HS Semi Gloss Clear Coat, with a dedicated hardener and thinner. This versatile clear coat system was specially developed to reproduce a wide range of gloss levels through mixing of the 8-407 HS Low Gloss Clear Coat and 8-409 HS Semi Gloss Clear Coat. This is a high quality polyurethane clear coat system, with high durability, for application over MM 500 - 5999 BeroBase 500 Series and MM 900 - 9999 WaterBase 900⁺ Series. Suitable for panel or full body repairs with very good drying and application properties.

MIXING RATIO



3 : 1 + 25%

Once you have created your gloss level mixture, mix:

8-407 and 8-409 HS Gloss Level Mixture : 3 parts
8-455 HS Matt Hardener: 1 part
8-451 HS Matt Thinner + 25%

GLOSS LEVELS



GLOSS LEVELS	8-407 LOW GLOSS (WT % OR VOL %)	8-409 SEMI GLOSS (WT % OR VOL %)	GLOSS UNITS (60°)
M1	70	30	0 - 10
M2	50	50	10 - 20
M3	30	70	20 - 30
M4	20	80	30 - 45
M5	0	100	45 - 60

See ICRIS for complete weight conversion.

To verify the gloss level and color match, it is recommended that a test panel is sprayed before the vehicle is repaired. Refer to the HS Matt level swatches for additional information.

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HE	1.3-1.4	1.8-2.0/26-30

APPLICATION



2½ coat 45-60 µm (1.8-2.4 mil)

Recommended application temperature is 15-30°C (59-86°F)



0.5 COAT (@ 20 CM /IN)	10 - 15 MINUTES FLASH OFF
2 medium-wet closed coats with cross layer application	15 - 20 minutes flash off between cross layers
Before Force Cure	30 minutes flash off

(1) Recommended application temperature is 15-30°C (59-86°F)

(2) The mist layer & flash-off period between coats and prior to baking is critical for the gloss level and even appearance.

(3) Cross layer application is important. The flash-off times may vary depending on application conditions. Film thickness and application technique are also important. Thin films and dry application will give lower gloss, while thick films and heavy application will give higher gloss.

NEXT LAYER



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FLASH OFF AND DRY TIMES





AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	-	**Flash off**	30 minutes
Dust free	10 - 15 minutes	**Dust free**	-
Dry to handle	2 - 3 hours	**Dry to handle**	40 minutes
Dry to tape	4 - 5 hours	**Dry to tape**	After cooling down
Dry to sand	-	**Dry to sand**	After cooling down
Dry to polish	-	**Dry to polish**	-

All times above depend on the layer thickness and temperature.

INFRARED DRYING



AFTER FULL FLASH OFF (30 MINUTES) AND AT PROPER DISTANCE	
Medium Wave	15-20 minutes
Short Wave	10-15 minutes
See IR Manufacturer information	

SUBSTRATES



MM 500 - 5999 BeroBase 500 Series and MM 900 - 9999 WaterBase 900⁺ Series

POT LIFE AT 20°C / 68°F



60 minutes

COMPONENTS



8-455 HS Matt Clear Coat Hardener
8-451 HS Matt Clear Coat Thinner

ADDITIVES



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SURFACE PREPARATION





Base coat should be fully dry. See the supplementary information or associated system technique.

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valspar AUTOMOTIVE

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PHYSICAL DATA

EU REGULATIONS		
VOC Code		2004/42/IIB(e)(840)560
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		IIB/e. Special finishes - All types. EU limit values: 840 g/L (2007). This product contains a maximum of 560 g/L VOC.
Chemical Base	2K Polyurethane Finish Matt	
Physical Properties	**Viscosity (RTS)**	14 - 19 Dincup 4 / 20°C
	Specific Gravity (kg/l)	0,978
	Flash Point Closed Cup	27°C / 80,6°F
	Volume % Solids	36,3
	Economy	7,2 m²/L/50 µm
		290 ft²/Gal/2 mil
	Gloss	Variable Gloss
	Colour	Semi Opaque

Check local regulations before use.

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

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