DEBEER REFINISH

MM 2000 - 2099

BeroMix 2000 Series

GENERAL INFORMATION

MM 2000 - 2099 BeroMix 2000 Series is a high gloss 2-pack polyurethane finish, both air drying and force drying. MM2099 Fleet Additive can be used for commercial vehicles or bigger objects.

MIXING RATIO

2 : 1 Top Coat : 2K/MS Hardener + 0 - 10 % Uni Thinner
3 : 1 Top Coat : HS Hardener + 0 - 10 % Uni Thinner

GUN SET UP

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,4	2/29
HE	1,2-1,4	1,8-2,0/26-29
Pressure tank	0,85-1,2	4,0-5,0/58-73
Airless/ Airmix	0,007-0,009"/40°	160-200

APPLICATION

2 coat 40 - 60 µm (1,6-2,4)

FLASH OFF AND DRY TIMES

AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	5 - 15 minutes	**Flash off**	5 - 15 minutes
Dust free	20 - 30 minutes	**Dust free**	-
Dry to handle	8 - 12 hours	**Dry to handle**	20 - 45 minutes
Dry to tape	8 - 12 hours	**Dry to tape**	After cooling down
Dry to sand	8 - 12 hours	**Dry to sand**	After cooling down
Dry to polish	24 hours	**Dry to polish**	After cooling down

INFRARED DRYING

AFTER FULL FLASH OFF AND AT PROPER DISTANCE	
Half-bake	4 min 60°C
Full-bake	8 min 80°C
See IR Manufacturer information	

SUBSTRATES

MM 2000 - 2099 BeroMix 2000 Series should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium and primed plastic. Well sanded GRP, OEM primer and old paint systems in good condition.

Please make sure you choose a suitable primer/surfacer by checking the TDS of the primer/surfacer.

POT LIFE AT 20°C / 68°F

20 minutes - 30 minutes

COMPONENTS

47-20 2K Hardener Air Dry
47-30 2K Hardener Very Fast
47-40 2K Hardener Fast
47-50 2K Hardener Medium
47-60 2K Hardener Slow
47-35 MS Hardener Fast
47-55 MS Hardener Medium
47-65 MS Hardener Slow
8-130 HS Hardener Very Fast
8-140 HS Hardener Fast
8-150 HS Hardener Medium
8-160 HS Hardener Slow
1-141 Uni Thinner Fast
1-151 Uni Thinner Medium
1-161 Uni Thinner Slow
1-171 Uni Thinner Very Slow
1-231 Fade-Out Thinner

ADDITIVES

1-060 2K Structure Coat Fine
1-065 2K Structure Coat Coarse
47-09 2K DB Coating Additive
47-39 2K Elastic
47-49 2K Matting Agent
MM2099 Fleet Additive

Add before hardener. In ICRIS is a option button to choose for a colour formulation with or with out MM2099 Fleet Additive.

SURFACE PREPARATION

Pre clean the surface with 1-951 Silicone Remover wipe on and wipe dry. Sand surface with P400 or finer grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with 1-951 Silicone Remover wipe on and wipe dry.

Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER

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PHYSICAL DATA

PHYSICAL DATA MM 2000 - 2099 BEROMIX 2000 SERIES		
Chemical Base	2K Polyurethane Topcoat	
Physical Properties	**Viscosity (RTS)**	18 - 20 Dincup 4 / 20°C
	Specific Gravity (kg/l)	0,987
	Flash Point Closed Cup	29C° / 84,2°F
	Volume % Solids	35
	Economy	7 m²/L/50 µm
		240 ft²/Gal/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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