

GENERAL INFORMATION

8-615 HS420 High Production Clear is a polyurethane high quality clear with high durability for application over MM 900 - 9999 WaterBase 900* Series and MM 500 - 5999 BeroBase 500 Series. Suitable for most repair work due to its good processing properties. Specially developed for air drying and also suitable for low bake and forced drying.

MIXING RATIO



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

	HARDENER	SMALL REPAIR	MEDIUM REPAIR	LARGE REPAIR
20°C - 25°C (68°F - 77°F)	8-430	✓		
	8-440	✓	✓	
	8-450		✓	✓
	8-460			✓
25°C - 30°C (77°F - 86°F)	8-430			
	8-440	✓	✓	
	8-450	✓	✓	✓
	8-460		✓	✓
>30°C >(86°F)	8-430			
	8-440	✓		
	8-450		✓	
	8-460		✓	✓

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	x	x	30	after cooling down
	8-450	x	x	45	
	8-460	x	x	60	
Forced Dry 50°C (122°F)	8-440	x	x	25	after cooling down
	8-450	x	x	35	
	8-460	x	x	40	

*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.

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

POT LIFE AT 20°C / 68°F



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

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



PHYSICAL DATA

EU REGULATIONS	
VOC Code	2004/42/IIIB(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.	IIIB/d, Topcoat - All types. EU limit values: 420 g/L (2007). This product contains a maximum of 412 g/L VOC.
Chemical Base	Solventborne 2K Polyurethane
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
Physical Properties	9,6 m ² /L/50 µm
	390 ft ² /Gal/2 mil
Economy	
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°C - 30°C / 50°F - 90°F) (unopened container).



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