

### 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		✓	✓

### 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

### GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HE	1,2-1,4	2,0-2,5/29-36

### 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.

### APPLICATION



1½ - 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.

### SURFACE PREPARATION



Mask entire vehicle to eliminate unwanted overspray.



### 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.

### 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	

### SUBSTRATES



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

Basecoat should be fully dry.

### 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 amaximum of 412 g/l VOC.	
Chemical Base	Solventborne 2K Polyurethane	
Physical Properties	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
	Economy	9.6 m²/L/50 µm
		390 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](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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