



## GENERAL INFORMATION

8-514 HS420 Speed Clear is a polyurethane high quality clear coat with high durability for application over MM 900 - 9999 WaterBase 900+ Series suitable for repairs on passenger cars. This clear coat is specially developed for body-shops with a high production or where short drying times are required.

### MIXING RATIO



3 : 1 Clear Coat : Speed Clear Hardener + 10% Uni Thinner  
3 : 1 Clear Coat : Speed Clear Hardener + 10% 8-129 Speed Optimiser

### GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,4	2/29
HE	1,3-1,4	2,0-2,5/29-36

### APPLICATION



1<sup>1</sup>/<sub>2</sub> - 2 coat 40 - 70 m (1,6-2,8 mil)

### FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	FORCED DRY 60°C / 140°F	With Uni Thinner	With Additive
Flash off	-	Flash off	0 - 5 minutes	0 - 5 minutes
Dust free	-	Dust free	-	-
Dry to handle	-	Dry to handle	20 minutes	10 minutes
Dry to tape	-	Dry to tape	After cooling down	After cooling down
Dry to sand	-	Dry to sand	After cooling down	After cooling down
Dry to polish	-	Dry to polish	After cooling down	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.

**Basecoat should be fully dry.**

### POT LIFE AT 20°C / 68°F



	UNI THINNER	8-539
Potlife (minutes)	40	20

### COMPONENTS



8-550 HS420 Speed Clear Hardener  
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  
8-129 Speed Optimiser

### ADDITIVES



47-39 2K Elastic  
1-060 2K Structure Coat Fine  
1-065 2K Structure Coat Coarse

**Add before hardener.**

### SURFACE PREPARATION



**Mask entire vehicle to eliminate unwanted overspray.**



### NEXT LAYER



### PHYSICAL DATA

EU REGULATIONS	
VOC Code	2004/42/IB(d)(420)(360)
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IB/d, Topcoat - All types. EU limit values: 420 g/L (2007). This product contains a maximum of 360 g/L VOC.
Chemical Base	2K Polyurethane Finish
Viscosity (RTS)	18 Dincup 4 / 20°C
Specific Gravity (kg/l)	0,976
Flash Point Closed Cup	39°C / 102,2°F
Volume % Solids	50,8
Physical Properties	Economy
	10,2 m <sup>2</sup> /L/50 m 415 ft <sup>2</sup> /Gal/2 mil
Gloss	High gloss
Colour	-



**DEBEER**  
REFINISH

**8-514**  
HS420 Speed Clear

## 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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