

GENERAL INFORMATION

MM 900 - 9999 WaterBase 900+ Series is a waterbased base-coat layer in a clear-over-base system. Suitable for passenger cars, touring cars and commercial vehicles. With a complete range of toners which provide you the option to mix the most common OEM colours in the market.

MIXING RATIO



Thinner is implemented in the colour formulation.

Custom made formulas add 10-20% 9-151 WaterBase 900+ Series Thinner.

Shake lightly.

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3	Please see appendix attached
HE	1,3	Please see appendix attached

APPLICATION



Re-coat with suitable clear coat within 8 hours. After 8 hours scuff and reply base coat.

Please see appendix attached.

FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	Until dry	Flash off	-	
Dust free	-	Dust free	-	
Dry to handle	-	Dry to handle	-	
Dry to tape	-	Dry to tape	-	
Dry to sand	-	Dry to sand	-	
Dry to polish	-	Dry to polish	-	

Please see appendix attached.

SUBSTRATES



MM 900 - 9999 WaterBase 900+ 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



6 month

Potlife mentioned is only for ready to spray colours.

FINISHING MATERIALS



All DeBeer applicable clear coats.

COMPONENTS



9-151 WaterBase 900+ Series Thinner

ADDITIVES



9-819 WaterBase Underhood Additive
59-11 /.../ 59-22 Mysterious Colours

When adding 59-11 /.../ 59-22 Mysterious Colours shake the small bottle intensively for 2 minutes before use.

SURFACE PREPARATION



Pre clean the surface with 9-851 WaterBase 900+ Series Degreaser 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 9-851 WaterBase 900+ Series Degreaser wipe on and wipe dry.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



INFRARED DRYING



AFTER FULL FLASH OFF AND AT PROPER DISTANCE

Half-bake	5 min 60°C
Full-bake	
See IR Manufacturer information	

PHYSICAL DATA

EU REGULATIONS	
VOC Code	2004/42/IIIB(d)(420)(418)
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	
11B/d. Topcoat -All types. EU limit values: 420 g/L (2007) This product contains a maximum of 418 g/L VOC.	
Chemical Base	Acrylic Dispersion
Physical Properties	
Viscosity (RT5)	-
Specific Gravity (kg/l)	1,008
Flash Point Closed Cup	61°C / 141,8°F
Volume % Solids	14
Economy	7 m ² /L/20 m
	280 ft ² /Gal/0,8 mil
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



9-852 WaterBase 900+ Series Gun Cleaner

After cleaning the spray gun thoroughly blow dry the spray gun with compressed air.

STORAGE/SHELF LIFE

Minimum 1 - 2 years; (Under normal storage conditions 5°C - 30°C / 50°F - 90°F) (unopened container).

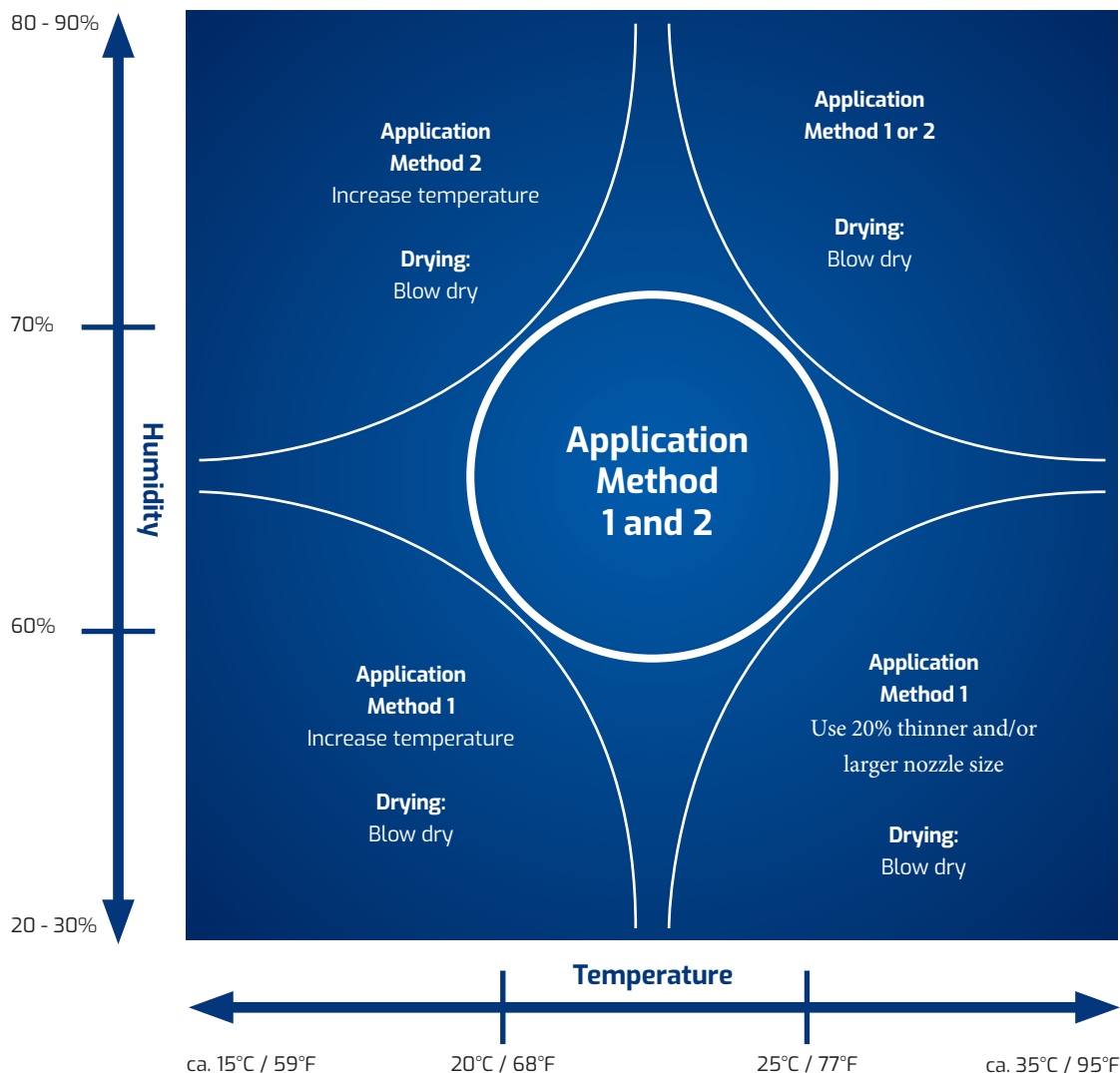
To prevent freezing, do not expose the product to temperatures below 5°C / 41°F during transportation and storage.

Please see appendix attached.



NOTES

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APPLICATION METHOD 1:

	DESCRIPTION	AIR PRESSURE (BAR / PSI)
STEP 1	Two singles wet coats, wet on wet to cover	2 bar / 29 psi
STEP 2	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
STEP 3	Drop coat (effect colours only)	1 bar / 14,5 psi
STEP 4	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-



NOTE:

Surface must be carefully cleaned.
If necessary, first apply a mist coat and blow dry.

APPLICATION METHOD 2: **

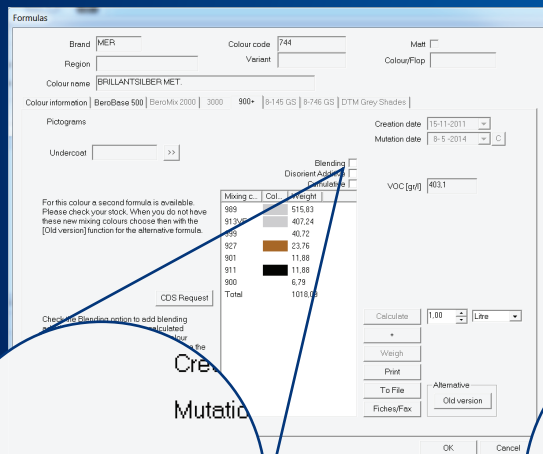
	DESCRIPTION	AIR PRESSURE (BAR / PSI)
STEP 1	First single wet coat	2 bar / 29 psi
STEP 2	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
STEP 3	Second single wet coat	2 Bar / 29 PSI
STEP 4	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
STEP 5	Drop coat (effect colours only)	1 Bar / 14,5 PSI
STEP 6	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-

At temperatures between 20 - 25°C and a relative humidity between 60 - 70%, both Application Methods 1 and 2 are recommended.

** Application 2 is preferred for deep black solid colours to achieve the darkest shade.

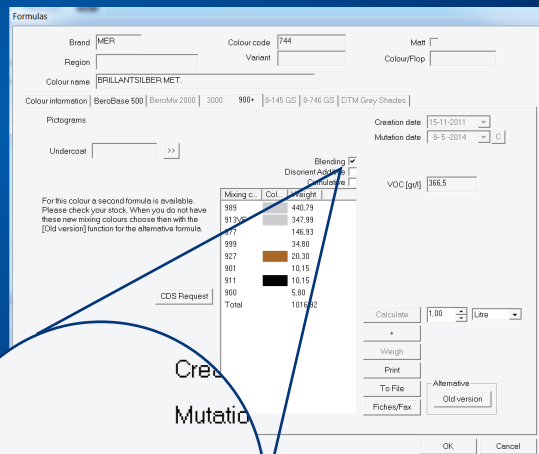
GENERAL INFORMATION

Recommendations for blending a challenging aluminium effect colour in to an adjacent part with DeBeer Refinish 900+ Series. Blending high covering effect colours with a greater than 60% of aluminium toner content can be a challenge. Especially when blending these colours in a spot repair or into the adjacent panel depending on the type of colour. To help with blending we now have two formulas on the ICRIS system.



Formula screen showing the 'Blending' checkbox unchecked. The 'VOC [g/l]' value is 403.1.

When viewing the formula screen, the formula *without* the [Blending] box ticked will give fast full coverage.



Formula screen showing the 'Blending' checkbox checked. The 'VOC [g/l]' value is 365.5.

When viewing the formula screen, the formula *with* the [Blending] box ticked provides an altered formula for less coverage and better blending qualities.

RECOMMEND PROCESS TO FOLLOW INVISIBLE EFFECT COLOUR BLENDING

PREPARATION



Colour check

Always determine the right colour and/or colour variant. This should be done at the earliest stage possible, preferably when estimation of the repair is done. Creating a spray-out at this stage is best practice.



Cleaning

Clean with 1-951 Silicone Remover and/or 9-851 WaterBase 900+ Series Degreaser.



Protection

Use suitable respiratory protection (fresh air supply respirator is strongly recommended).

STEP 1 *PREPARE BLEND AREA*



Dry sanding

Prepare the blending area by dry sanding with DA sander orbit 3-5 grit P1500.

Avoid sand through edges.



Wet sanding

Prepare the blending area by wet sanding using grit P2000/P3000.



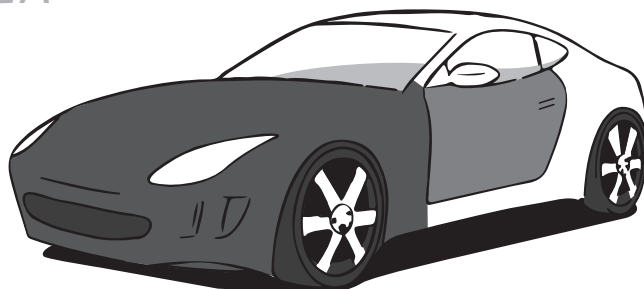
Scuffing

Prepare the blending area by using scuffing pad fine and ultra fine.



Cleaning

Clean with 1-951 Silicone Remover and/or 9-851 WaterBase 900+ Series Degreaser.



STEP 2 *MIX & APPLICATION 977*



Blending additive

Mix 977 blending additive with 9-151 WaterBase 900+ Series Thinner. Mixing ratio: 977+ 10-20% 9-151.



Application

Apply one flowing coat off 977 on 2/3 off the blending area.



Gun setup

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



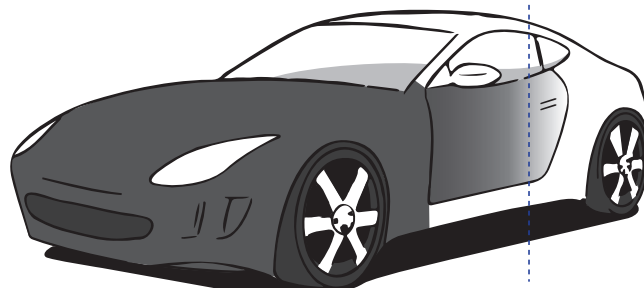
Flash-off

Until a uniform matt surface.



Note

It is also possible to do this process in reverse, apply WaterBase 900+ Series to full coverage on the repair area, dry the WaterBase 900+ Series then apply the 977 mix to the blend area dry and finish the blending process as described.



STEP 3 APPLICATION OF WATERBASE



Application Color

900+ Blending color formula + 10% 9-151.

See option in ICRIS.



Application

Apply 2-3 coats or till covered arcing into blending area. Do not apply color beyond area 3 (See picture).



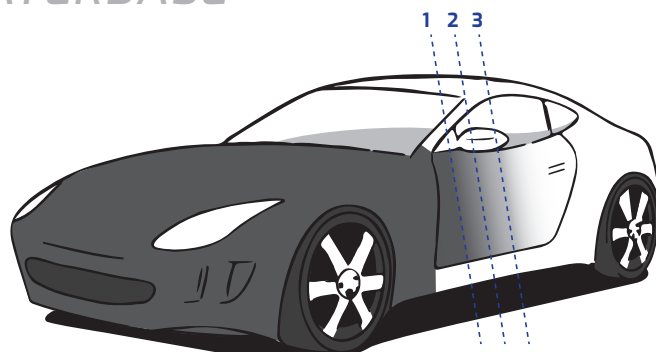
Gun setup

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



Flash-off

Until a uniform matt surface.



STEP 4 APPLICATION WATERBASE DROP COAT



Application dropcoat

Apply dropcoat at dubble distance at 1 bar.

stay with in the blending area.

Do not apply color beyond area 3 (See picture).



Gun setup

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,3	1/14,5
HE	1,2-1,3	1/14,5

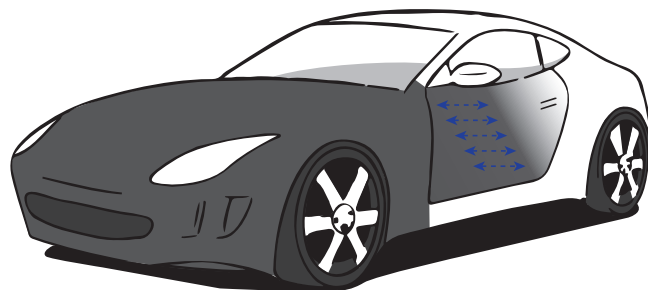


Flash-off

Until a uniform matt surface.



The drop coat must be applied for colour and effect, this will also assist colour blending.



STEP 5 APPLICATION CLEAR COAT



Select a suitable De Beer Refinish clear coat and follow the technical information on the TDS.

