

GENERAL INFORMATION

A multipurpose clear that is highly durable and can be used on a wide range of repairs due to its excellent processing properties. The clear can be mixed at a 2 : 1 mixing ratio with a choice of three hardeners. It can be air dried, low baked and forced dried.

MIXING RATIO



2 : 1 Clear : Allround Clear Hardener

	HARDENER	SMALL REPAIR	MEDIUM REPAIR	LARGE REPAIR
20°C - 25°C (68°F - 77°F)	8-74	✓	✓	
	8-75		✓	✓
	8-76			✓
25°C - 30°C (77°F - 86°F)	8-74	✓	✓	
	8-75	✓	✓	✓
	8-76		✓	✓
>30°C (>86°F)	8-74	✓		
	8-75	✓	✓	
	8-76		✓	✓

GUN SET UP



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

APPLICATION



1½ - 2 coats 50 - 80 µm (2,0-3,2 mil)
2 coats: 5 - 10 min flash off between coats.

FLASH OFF AND DRY TIMES



	HARDENER	FLASH OFF BEFORE BAKE	DUST FREE TIME	DRY TO HANDLE	DRY TO POLISH
Air Dry 20°C	8-74	-	25 - 30 minutes	90 - 120 minutes	5 hours
	8-75	-	45 - 60 minutes	120 - 180 minutes	Overnight
Low bake 40°C	8-74	3 - 7 minutes	-	20 minutes	After cooling down
	8-75	5 - 8 minutes	-	40 minutes	
	8-76	8 - 10 minutes	-	60 minutes	
Forced Dry 60°C	8-75	8 - 10 minutes	-	20 minutes	After cooling down
	8-76	11 - 15 minutes	-	30 minutes	

SUBSTRATES



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

Basecoat should be fully dry.

POT LIFE AT 20°C / 68°F



25 - 40 minutes

Depending on the chosen hardener and temperature.

COMPONENTS



8-74 Allround Clear Hardener Fast
8-75 Allround Clear Hardener Medium
8-76 Allround Clear Hardener Slow
1-231 Fade-Out Thinner

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



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	

PHYSICAL DATA

EU REGULATIONS		
VOC Code	2004/42/11B(d)(420)410	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11980-1/2) of the ready to use product.	11B/d. Topcoat - All types. EU limit values: 420g/L (2007) This product contains a maximum of 410 g/L VOC.	
Chemical Base	Polyurethane clear coat.	
Physical Properties	Viscosity (RTS)	17 - 19 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1,009
	Flash Point Closed Cup	34°C (93,2°F)
	Volume % Solids	49
	Economy	9,8 m²/L/50 µm 395 ft²/Gal/2 mil
	Gloss	High gloss
	Colour	-



DEBEER
REFINISH

8-774
Allround 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

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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