

GENERAL INFORMATION

1-204 MS Clear Coat is a high gloss clear finish that is very easy to use. Can be both air-dried and forced-dried.

MIXING RATIO



2 : 1 Clear Coat : MS Hardener + 0 - 10% Uni Thinner

If required, thin with Uni Thinner.

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	2/29
HE	1,2-1,4	1,8-2,0/26-29
Pressure tank	0,85-1,2	3,5-4,5/51-65

Air pressure mentioned in table is base on inlet air.

APPLICATION



2 coat 2,0-2,5 mil

FLASH OFF AND DRY TIMES



	AIR DRY 20 °C / 68 °F	FORCED DRY 60 °C / 140 °F
Flash off	5 - 10 minutes	Flash off 5 - 10 minutes
Dust-free	20 - 30 minutes	Dust-free -
Dry-to-handle	8 hours	Dry-to-handle 25 - 35 minutes
Dry-to-tape	-	Dry-to-tape After cooling down
Dry-to-sand	-	Dry-to-sand After cooling down
Dry-to-polish	8 hours	Dry-to-polish After cooling down



SUBSTRATES



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

Basecoat should be fully dry.

POTLIFE



2 hours - 4 hours

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	

COMPONENTS



47-35 MS Hardener Fast
 47-55 MS Hardener Standard
 47-65 MS Hardener Slow

ADDITIVES



47-39 2K Elastic

Add before hardener.

SURFACE PREPARATION



Mask entire vehicle to eliminate unwanted overspray.



NEXT LAYER



PHYSICAL DATA

RTS REGULATORY DATA:	2 : 1 : 0 - 10%	
	Uni Thinner Series	
	lb./gal	g/L
Actual VOC	4.0 Max.	482 Max.
Regulatory VOC (less water and exempt solvents)	4.6 Max.	560 Max.
Density	8 - 9	960 - 1080
	WT%	VOL%
Total Solids Content	35 - 40	33 - 38
Total Volatile Content	60 - 65	62 - 67
Water	0	0
Exempt Compound Content	14 - 20	14 - 20
Coating Category	Clearcoat	

PROTECTION



Use suitable respiratory protection (*we recommend the use of a fresh air supply respirator*).

For more detailed information please visit the following link for the Safety Data Sheet:

<https://sds.de-beer.com>



DEBEER
REFINISH

1-204
MS Clear Coat

CLEANUP



Cleaning the Equipment / Per local regulations.

STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions
10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES



INFORMATION: If used as instructed, this product is designed to comply with the US National Volatile Organic Compound (VOC) Emission Standard for Automobile Refinish Coatings. Confirm compliance with state and local air quality rules before use.