DEBEER REFINISH

8-407 / 8-409

HS Low Gloss Clear Coat
HS Semi Gloss Clear Coat

GENERAL INFORMATION

This is a premium system that consists of 8-407 HS Low Gloss Clear Coat and 8-409 HS Semi Gloss Clear Coat, with a dedicated hardener and thinner. This versatile clear coat system was specially developed to reproduce a wide range of gloss levels through mixing of 8-407 HS Low Gloss Clear Coat and 8-409 HS Semi Gloss Clear Coat. This is a high-quality polyurethane clear coat system, with high durability, for application over MM 500 - 5999 BeroBase 500 Series and MM 900 - 9999 WaterBase 900⁺ Series. Suitable for panel or full body repairs with very good drying and application properties.

MIXING RATIO

3 : 1 + 25%

Once you have created your gloss level mixture, mix:

8-407 and 8-409 HS Gloss Level Mixture : 3 parts
8-455 HS Matt Hardener: 1 part
1-151 Uni Thinner Medium + 25%

GLOSS LEVELS

GLOSS LEVELS	8-407 LOW GLOSS (WT % OR VOL %)	8-409 SEMI GLOSS (WT % OR VOL %)	GLOSS UNITS (60°)
M1	70	30	0 - 10
M2	50	50	10 - 20
M3	30	70	20 - 30
M4	20	80	30 - 45
M5	0	100	45 - 60

See Color Focus for complete weight conversion.

To verify the gloss level and color match, it is recommended that a test panel is sprayed before the vehicle is repaired. Refer to the HS Matt level swatches for additional information.

GUN SETUP

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HE	1.3-1.4	1.8-2.0/26-30

Air pressure mentioned in table is base on inlet air.

APPLICATION

2½ coat 1.8-2.4 mil

Recommended application temperature is 15-30°C (59-86°F)

0.5 COAT (@ 20 CM /IN)	10 - 15 MINUTES FLASH OFF
2 medium-wet closed coats with cross layer application	15 - 20 minutes flash off between cross layers
Before Force Cure	30 minutes flash off

(1) Recommended application temperature is 15-30°C (59-86°F)

(2) The mist layer & flash-off period between coats and prior to baking is critical for the gloss level and even appearance.

(3) Cross layer application is important. The flash-off times may vary depending on application conditions. Film thickness and application technique are also important. Thin films and dry application will produce lower gloss, while thick films and heavy application will produce higher gloss.

NEXT LAYER

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FLASH OFF AND DRY TIMES

AIR DRY 20 °C / 68 °F		FORCED DRY 60°C / 140°F	
Flash off	-	Flash off	30 minutes
Dust-free	10 - 15 minutes	Dust-free	-
Dry-to-handle	2 - 3 hours	Dry-to-handle	40 minutes
Dry-to-tape	4 - 5 hours	Dry-to-tape	After cooling down
Dry-to-sand	-	Dry-to-sand	After cooling down
Dry-to-polish	-	Dry-to-polish	After cooling down

All times above depend on the layer thickness and temperature.

INFRARED DRYING

AFTER FULL FLASH OFF (30 MINUTES) AND AT PROPER DISTANCE	
MEDIUM WAVE	15 - 20 MINUTES
SHORT WAVE	10 - 15 MINUTES
SEE IR MANUFACTURES INFORMATION	

SUBSTRATES

MM 500 - 5999 BeroBase 500 Series and
MM 900 - 9999 WaterBase 900⁺ Series

POTLIFE

1 hour

COMPONENTS

8-455 HS Matt Clear Coat Hardener
1-151 Uni Thinner Medium

ADDITIVES

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RevisionDate:September2022

valspar AUTOMOTIVE

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SURFACE PREPARATION

Base coat should be fully dry. See the supplementary information or associated system technique.

PHYSICAL DATA

RTS REGULATORY DATA:	3 : 1 : 25% 2K Polyurethane Finish Matte	
	lb./gal	**g/L**
Actual VOC	4.7 Max.	565 Max.
Regulatory VOC (less water and exempt solvents)	4.8 Max.	575 Max.
Density	8- 9	960 - 1080
	WT.%	VOL.%
Total Solids Content	40 - 43	35 - 38
Total Volatile Content	57 - 60	62 - 65
Water	0	0
Exempt Compound Content	1 - 3	1 - 3
Coating Category	Clearcoat	

Check local regulations before use.

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

CLEANUP

Cleaning the Equipment / Per local regulations.

STORAGESHELFLIFE

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

NOTES

Confirm compliance with national, state, and local air quality rules before use.

RevisionDate:September2022