

### GENERAL INFORMATION

80-414 Pro Glamour Clearcoat is a high-gloss versatile clear coat delivering a first class finish in half the time of traditional clear coats. With a fast application time and quick, low-temp bake cycle, 80-414 will help to improve through put and increase productivity.

### MIXING RATIO



4:1:1 Clear Coat : Hardener : Reducer

### GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (PSI)
HVLP	1.3 - 1.4	26-29 psi
HE	1.3 - 1.4	26-29 psi

Air pressure mentioned in table is based on inlet air.

### APPLICATION



2 coats 2.0 - 3.0 mills (dry)

### FLASH OFF AND DRY TIMES



- Apply 2 coats – Gun distance of 4 – 6 inches.
- Apply an even wet first coat, with consistent overlap. It is suggested to apply more of the recommended film build in the first coat, than in the second, to help with film wetting.
- Allow to flash for 4 - 7 minutes before applying second coat.
- Recommended film build is 2.0 - 3.0 mils (dry)

### COMPONENTS



- 47-99 Quick Cure Hardener
- 1-1061 Compliant Solvent - Slow
- 1-1071 Compliant Solvent - Extra Slow
- 1-141 Uni-Thinner Fast
- 1-151 Uni Thinner Medium
- 1-161 Uni Thinner Slow
- 1-171 Uni Thinner Very Slow

### ADDITIVES



80-414 is Pre-Flexed. Do not add 47-39 2K Elastic.

### SURFACE PREPARATION



- Mask entire vehicle to eliminate unwanted overspray.

**Do not exceed 150°F surface temp. while baking. Do not exceed 30 minute total bake time.**

	**AIR-DRY	*140° F Surface Temp	*135° F Surface Temp	*130° F Surface Temp
Flash Before Bake	N/A	No Flash Required	No Flash Required	No Flash Required
Dust Free	55 min.	N/A	N/A	N/A
Bake	N/A	10 min.	25 min.	30 min.
To Buff	90 min.	Allow to cool 20 min.	Allow to cool 20 min.	Allow to cool 20 min.
To Deliver	90 min.	Allow to cool 20 min.	Allow to cool 20 min.	Allow to cool 20 min.

\*\*Air-Dry times can be affected by temperature, reducer selection, film build, etc. and may feel soft to touch even when ready to sand/buff.

### SUBSTRATES



MM 900 - 9999 WaterBase 900+ Series  
MM500-5999 BeroBase 500 Series  
Sanded and degreased old layers.

Basecoat should be fully dry.

### POTLIFE



2 hours @ 70°.

### PHYSICAL DATA

RTS REGULATORY DATA: 80-414/47-99/1-1071 4:1:1		
	LBS./Gal	g/L
Actual VOC	1.1 Max	132 Max
Regulatory VOC (less water and exempt solvents)	2.1 Max	250 Max
Density	8.5-10.5	1020-1220
	WT%	VOL%
Total Solids Content	40-44	38-42
Total Volatile Content	56-60	58-62
Water	0	0
Exempt Compound Content	49-53	46-50
Coating Category	Clearcoat	

RTS REGULATORY DATA: 80-414/47-99/1-171 4:1:1		
	LBS./Gal	g/L
Actual VOC	2.04	244
Regulatory VOC (less water and exempt solvents)	3.06	367
Density	8.1 - 10.1	985-1185
	WT%	VOL%
Total Solids Content	39-43	38-42
Total Volatile Content	57-61	58-62
Water	0	0
Exempt Compound Content	34-38	31-35
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>

### 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

