

## GENERAL INFORMATION

1-092 Colour Additive Orange is an additive for (mixing colours in) MM 500 - 5999 BeroBase 500 Series in order to make special colours (motors, etc.). Strong concentrated ink-solutions in different colours. The 1-092 Colour Additive Orange acts as a thinner, it is not necessary to dilute the base coat with 100%. The percentage of thinner that needs to be added, depends upon the percentage of 1-092 Colour Additive Orange being used. e.g 20% 1-092 Colour Additive Orange is added in the formulation, the mixture has to be diluted with 60%. (if needed thin with 1-151 Uni Thinner Medium) Only store ready made MM 500 - 5999 BeroBase 500 Series in plastic paintcups.

## MIXING RATIO



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 Depends on the formula in motorcycle colours on ICRIS colour retrieval.

## GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,5	2/29
HE	1,3-1,5	1,6-1,8/23-26

## APPLICATION



2 - 3 coat 15 - 25 m (0,6-1,0 mil)

## 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	10 - 15 minutes	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	-



## SUBSTRATES



1-092 Colour Additive Orange should only be applied over well sanded/scuffed and degreased primed bare steel and primed aluminium. Well sanded GRP, polyester fillers, OEM primer and old paint systems in good condition.

## POT LIFE AT 20°C / 68°F



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 Mixed colours have a limited potlife.

## FINISHING MATERIALS



All DeBeer applicable clear coats.

## COMPONENTS



MM 500 - 5999 BeroBase 500 Series  
 1-151 Uni Thinner Medium

## ADDITIVES



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## SURFACE PREPARATION



Pre clean the surface with 1-951 Silicone Remover 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 1-951 Silicone Remover wipe on and wipe dry.



Mask entire vehicle to eliminate unwanted overspray.

## NEXT LAYER



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## PHYSICAL DATA

PHYSICAL DATA 1-092 COLOUR ADDITIVE ORANGE			
Chemical Base	Ink solution		
Physical Properties	Viscosity (RTS)	-	
	Specific Gravity (kg/l)	0.911	
	Flash Point Closed Cup	33,5°C / 82,3°F	
	Volume % Solids	12	
	Economy	6m <sup>2</sup> /L/20 m	
		240 ft <sup>2</sup> /qt/0,8 mil	
	Gloss	-	
Colour	-		



**DEBEER**  
REFINISH

**1-092**  
Colour Additive Orange

### 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](https://sds.de-beer.com/en/debeer/choose_localization)

### CLEAN UP



1-051 Gun Cleaner

### STORAGE/SHELF LIFE

Minimum 4 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).



### NOTES

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