

GENERAL INFORMATION

1-103 2K 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 : 2K / MS Hardener + 0 - 5% Uni Thinner

If required thin with Uni Thinner.

GUN SET UP



	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	1,0-1,2	3,5-4,5/51-65

APPLICATION



2 - 3 coat 40 - 50 μm (1,57-2,0 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	12 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	12 hours	Dry to polish	After cooling down



SUBSTRATES



MM 500 - 5999 BeroBase 500 Series. Sanded and degreased old layers.

Basecoat should be fully dry.

POT LIFE AT 20°C / 68°F



120 - 240 minutes

COMPONENTS



47-20 2K Hardener Air Dry
 47-30 2K Hardener Very Fast
 47-40 2K Hardener Fast
 47-50 2K Hardener Medium
 47-60 2K Hardener Slow
 47-35 MS Hardener Fast
 47-55 MS Hardener Medium
 47-65 MS Hardener Slow
 1-141 Uni Thinner Fast
 1-151 Uni Thinner Medium
 1-161 Uni Thinner Slow
 1-231 Fade-Out Thinner

Tip: Use 47-20 2K Hardener Air Dry only for spot-repairs at lower temperatures.

ADDITIVES



1-060 2K Structure Coat Fine
 1-065 2K Structure Coat Coarse
 47-39 2K Elastic

Add before hardener.

SURFACE PREPARATION



Mask entire vehicle to eliminate unwanted overspray.



NEXT LAYER



PHYSICAL DATA

PHYSICAL DATA 1-103 2K CLEAR COAT		
Chemical Base	2K Polyurethane Finish	
Physical Properties	Viscosity (RTS)	15 - 17 Dincup 4 / 20°C
	Specific Gravity (kg/l)	0,964
	Flash Point Closed Cup	29°C / 84,2°F
	Volume % Solids	33,2
	Economy	6,6 m ² /L/50 μm 270 ft ² /Gal/2 mil
	Gloss	High gloss
	Colour	-

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).



NOTES

Specific information for use in Europe (EU): This product (ready for use) is not VOC compliant. Please refer to VOC declaration (2004/42/EC).