

GENERAL INFORMATION

MM 500 - 5999 BeroBase 500 Series is a clear-over-base system for passenger cars, commercial vehicles and coaches. The system provides an exceptional optical effect, high durability, resistance to chemicals and gloss retention.

MIXING RATIO



1:1 with Uni Thinner

When mixing an own formula with a metallic and/or pearl always use the wax calculation option ICRIS colour retrieval.

GUN SET UP



| | NOZZLE (MM) | AIR PRESSURE (BAR / PSI) |
|------|-------------|--------------------------|
| HVLP | 1,3-1,5 | 1,5-1,8/22-26 |
| HE | 1,3-1,5 | 1,5-1,8/22-26 |

APPLICATION



2 - 3 coats 15 - 25 µm (0,6-1,0 mil). For effect colours a mist coat is recommended at a lower pressure (1,2 - 1,5 BAR / 18 - 22 PSI). This mist coat is applied to semi-dry or dry base coat.

**Re-coat with suitable clear coat within 8 hours.
After 8 hours scuff and reply base coat.**

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 | 15 - 20 minutes | Dry to handle |
| Dry to tape | 15 - 20 minutes | Dry to tape |
| Dry to sand | - | Dry to sand |
| Dry to polish | - | Dry to polish |

SUBSTRATES



MM 500 - 5999 BeroBase 500 Series should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium and primed plastic. Well sanded GRP, OEM primer and old paint systems in good condition.

Please make sure you choose a suitable primer/surfacer by checking the TDS of the primer/surfacer.

POT LIFE AT 20°C / 68°F



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FINISHING MATERIALS



All DeBeer applicable clear coats.

COMPONENTS



- 1-141 Uni Thinner Fast
- 1-151 Uni Thinner Medium
- 1-161 Uni Thinner Slow
- 1-181 Uni Thinner Ultra Slow

ADDITIVES



59-11 /.../ 59-22 Mysterious Colours

When adding 59-11 /.../ 59-22 Mysterious Colours shake the small bottle intensively for 2 minutes before use.

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



PHYSICAL DATA

| PHYSICAL DATA MM 500 - 5999 BEROBASE 500 SERIES | |
|---|--|
| Chemical Base | Special physically drying binders. |
| Physical Properties | Viscosity (RTS) 15 - 17 Dincup 4 / 20°C |
| | Specific Gravity (kg/l) 0,926 |
| | Flash Point Closed Cup 23°C to 25°C / 73,4°F to 77°F |
| | Volume % Solids 12 |
| | Economy 6 m²/L/20 µm 240 ft²/Gal/0,8 mil |
| | 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

The up-to-date shelf life overview can be found by clicking on the following link:

[Shelf life overview DeBeer](#)



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).