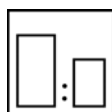


## Serie 3000 BeroThane HS420 MM 3000 - 3046

### APPLICATION DATA



**Mixing Ratio** : 2:1 with HS420 Hardener + 15% 8-181 (\*)



**Application viscosity** : Airspray (sec) : 17-19  
**DINCUP 4mm/20°C(70°F)** : Pressure tank (sec) : -  
 : Airless (sec) : -

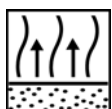
(\*) For information about Hardeners, Thinners and Measuring sticks see Matrix-overview (System Technique)



|               | <u>Nozzle diameter (mm)</u> | <u>Spraying pressure (bar/psi)</u> |
|---------------|-----------------------------|------------------------------------|
| Gravity feed  | 1,2-1,4                     | 3,5-4,5 / 51-65                    |
| Suction feed  | 1,4-1,5                     | 3,5-4,5 / 51-65                    |
| Pressure tank | 0,85-1,1                    | -                                  |
| Airless       | 0.009"- 0.011"/40°          | 180-200                            |
| HVLP          | -                           | 2,0-2,5 / 29-36                    |
| HE            | 1,2-1,4                     | 2,0 / 29                           |



**Spray coats / Layer thickness (µm)** : 2 / 50µm (2.0mil)



**Flash-off (min)** : 20°C/70°F : 5-10



**Drying time (min)** : 20°C/70°F : 15h  
 : 60°C/140°F : 20-40  
 Obj.



**Potlife (min)** : 20°C/70°F : 30-120

## Serie 3000 BeroThane HS420 MM 3000 - 3046



### PRODUCT INFO

- Area of application** : Passenger cars, commercial vehicles, coaches, equipment, etc.
- Chemical base** : High-quality two component polyurethane resin.
- General qualities** : High-gloss, non-yellowing 2-pack finish.
- Auxiliary materials** : 8-30/8-40/8-50/8-60, 8-430/8-440/8-450/8-460, 8-181, 1-060, 1-065, 30-09, 30-49, 30-69, 47-39 (for plastic parts).

|                            |                                |  |
|----------------------------|--------------------------------|--|
| <b>Physical properties</b> | <b>Specific gravity (kg/l)</b> | : 1.04 to 1.4                          |
|                            | <b>Flash point</b>             | : Closed cup: 28.5°C (83.3°F)          |
|                            | <b>Vol.% solids</b>            | : 58-68                                |
|                            | <b>Economy</b>                 | : 11 m <sup>2</sup> /L/50 µm (2.0 mil) |
|                            | <b>Gloss</b>                   | : High gloss                           |
|                            | <b>Colour</b>                  | : Not available.                       |

- Substrates** : Combined with suitable primer on: cured coatings, steel, galvanized steel, aluminium and polyester. On plastic parts: First Plastic Primer, followed by a layer of HS Primer/Surfacer with 2K Elastic.
- Undercoats** : 8-145, 8-149, 1-7510/1-7520, 30-746
- Finishing materials** : Non applicable.
- Cleaning the equipment** : 1-051 Gun Cleaner
- Storage life (years)** : min. 2  
(Under normal storage conditions and unopened tins).