

Wall chart description

1. Select required system 1 or 2.
2. Choose products and follow instructions as described in required system.
3. Read instructions from left to right and follow step 1 to 7.

DE BEER REFINISH PRODUCT OVERVIEW



		System 1	System 2	Hardeners	Thinners	Mixing ratio	Viscosity Din cup 4 (20°C)	Substrates	Preparation before application	Spray guns / Set-ups	Application	Drying times 20°C		60°C	Extra information	
		Car Refinish VOC compliant	Commercial vehicles VOC compliant													
Colour check	Colour matching															
		Check colour before application - Find the latest information in ICRIS - Update your ICRIS frequently														
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Degreasers	Silicon remover	1-951	1-951	Ready to use	Ready to use	Ready to use	-	Bare steel, old and new paint systems.	-	-	-	-	-	-	-	-
	WaterBase degreaser	9-851	9-851	Ready to use	Ready to use	Ready to use	-	Fillers, old and new paint systems.	-	-	-	-	-	-	-	-
	Antistatic degreaser	1-851	1-851	Ready to use	Ready to use	Ready to use	-	Plastic parts.	-	-	-	-	-	-	-	-
Preparation	Putties	6010, 6040, 6070 (available as from March 2009)	6010, 6040, 6070 (available as from March 2009)	Special Hardener		add max. 2% (by weight) hardener. Never overdose!	-	Apply on degreased, sanded and dry bases.	-	-	-	-	-	-	sandable after 25 min dry sanding only	-
(Adhesion) Primers	Washprimer	1-15		1-10		1:1	18-20 sec.	Bare and galvanized steel and most types of aluminium. Do not use on thermoplastic (TPA) layers	-	Gravity feed: 1,3-1,5mm Suction feed: 1,6-1,8mm	1-2 coats 10-20 µm	10-15 min.	-	-	-	
	Washprimer CH	1-17	1-17	1-12		1:1	18-20 sec.	Bare and galvanized steel and most types of aluminium. Do not use on thermoplastic (TPA) layers	-	Gravity feed: 1,3-1,5mm Suction feed: 1,6-1,8mm	1-2 coats 10-20 µm	30-60 min.	-	-	-	
	Epoxy primer sanding	1-7510, 1-7520	1-7510, 1-7520	1-70, 1-7040	1-141, 1-151, 1-161	in volume 2:1 add 0-20% thinner	17-19 sec.	cured and sanded old coatings or undercoats in the mentioned systems on: metal (steel, zinc, aluminium) and sanded polyester	-	Gravity feed: 1,6-1,8mm Suction feed: 1,6-1,8mm	50-200 µm	16h 1h	-	-	-	
	Epoxy primer non sanding	1-7510, 1-7520	1-7510, 1-7520	1-70, 1-7040	1-141, 1-151, 1-161	in volume 2:1 add 0-20% thinner	15-17 sec.	cured and sanded old coatings or undercoats in the mentioned systems on: metal (steel, zinc, aluminium) and sanded polyester	-	Gravity feed: 1,6-1,8mm Suction feed: 1,6-1,8mm	1-4 coats 50-200 µm	45 min.	-	-	-	
	Plastic primer	1-60	1-60	Ready to spray	Ready to spray	Ready to use	-	Suitable for plastic substrates such as: pp Polypropylene (always test), ABS Acrylonitrile, Butadiene styrene, PA Polyamide (Nylon) EPDM Ethylene Propylene Diene Mixed Polymer, P Polyurethane	-	Gravity feed: 1,2-1,4mm Suction feed: 1,4-1,6mm	1 coat 5 µm	20 min.	-	-	-	
Surfacers/Fillers	HS Surfacersanding	8-145, 8-14510, 8-14540		2K Hardeners: 47-30/47-40/47-50/47-60, MS Hardeners: 47-35/47-55/47-65, HS420 Hardeners: 8-40/8-50	1-141, 1-151, 1-161, 8-171	3:1 (Surfacer: Hardener 2K/MS) add max 10 % Thinner 6:1 (Surfacer: Hardener HS420) add max 25% Thinner	20-22 sec.	On top of Washprimer, fully cured old coatings and certain plastics	-	Gravity feed: 1,3-1,8mm Suction feed: 1,4-1,8mm	1-3 coats 60-180 µm	16h	20-30 min.	-	Mix the right prep shade	
	HS Surfacers non sanding	8-145, 8-14510, 8-14540		MS Hardener: 47-55/47-65, HS420 Hardener: 8-50	1-141/1-151/1-161	3:1 (Surfacer: Hardener MS) add max 20 % Thinner 6:1 (Surfacer: Hardener HS420) add max 35% Thinner	16-17 sec.	On top of Washprimer, fully cured old coatings and certain plastics	-	Gravity feed: 1,3-1,5mm Suction feed: 1,4-1,6mm	1 coat 20-25µm	15-20 min.	-	-	Mix the right prep shade	
	HS Tinting surfacer sanding	8-149		8-40/8-50	1-141/1-151/1-161	4:1 with 3000 Series or HS420 Clear Coat 8-204, mix thoroughly. Then add 5:1 HS420 Hardener + 0-10% Uni Thinner	20-22 sec.	OEM finished, old paint, washprimers, epoxyprimer, bodyfillers	-	Gravity feed: 1,3-1,8mm Suction feed: 1,4-1,8mm	1-3 coats 60-180 µm	16h	20-30 min.	-	-	
	HS Tinting surfacer non-sanding	8-149		8-50	1-141/1-151/1-161	1:1 with HS420 3000 Series or HS420 Clear Coat 8-204, mix thoroughly. Then add 3:1 HS420 Hardener 8-50 + 0-25% Thinner	16-17 sec.	OEM finished, old paint, washprimers, epoxyprimer, bodyfillers	-	Gravity feed: 1,3-1,5mm Suction feed: 1,4-1,6mm	1 coat 20-25 µm	-	-	-	Can not be used with WaterBase 900 Series	
	Non sanding filler	30-746, 30-74640	30-746, 30-74640	8-50	1-141/1-151/1-161	5:1 (Primer:HS420 Hardener) + 20% Thinner	16 sec.	Old paintwork (sanded and degreased) on bare metal always use washprimer first	-	Gravity feed: 1,4-1,6mm Suction feed: 1,5-1,7mm	1-2 coats 30 µm	-	15h	-	-	
	Polyester Spray Filler	1-980		Special hardener	1-151	Add max. 2% (by weight) hardener; mix thoroughly. Add 0-5% Thinner	-	Degreased and sanded old paint coats, polyester filler and bare metal. Do not apply on thermoplastic acrylic paints and washprimers	-	Gravity feed: 2,0-2,5mm	1-3 coats 100-300 µm	3h	30 min.	-	-	
	Spot Repair	1-165		Ready to spray	Ready to spray	-	-	Make sure that the area has been degreased properly and the edges are sanded through	-	-	1-3 coats	5 min.	-	-	Shake well before use.	
Top Coats	WaterBase Basecoat	WaterBase 900 Series	WaterBase 900 Series		9-151/9-161	Ready to use. Own made formulas: add 10% thinner 9-151/9-161	-	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.	-	HVLP/LVLP: 1,3mm	1 dust coat followed by 2 wet-in-wet coats until object is covered. Metallic and mica colours: after drying apply a dropcoat at 1 bar air pressure. 15-20 µm	ventury/blow dry until matt at 30-35 °C	-	-	-	
	Colour coating	BeroThane HS420 3000 Series	BeroThane HS420 3000 Series	8-30/8-40/8-50/8-60	8-181	2:1 with HS420 Hardener +15% 8-181	17-19 sec.	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	-	HE: 1,2-1,4mm Gravity feed: 1,3-1,5mm Suction feed: 1,4-1,5mm	2 coats 50 µm	15h	20-40 min.	-	-	
Clear Coats	Clear Coat Matt	1-105	1-105	47-35/47-55/47-65	1-141/1-151/1-161	2:1 with MS Hardeners	17-18 sec.	WaterBase 900 Series	-	Gravity feed: 1,3-1,5mm Suction feed: 1,4-1,6mm	2 coats 50 µm	10h	30 min.	-	-	
	Clear Coat (HS420)	8-204	8-204	8-30/8-40/8-44/8-50	1-141/1-151/1-161	2:1 with HS420 Hardener 8-30/8-40/8-44/8-50+ 5% 8-171, 1-141/1-151/1-161	16-18 sec.	WaterBase 900 Series	-	HE: 1,2-1,3mm	2 coats 50-60 µm	15-20h	15-40 min.	-	-	
	Clear Coat (HS420)	8-214	8-214	8-140/8-150	1-141/1-151/1-161, 47-39	2:1 with 8-140/8-150 + 0-5% Thinner	16-18 sec.	Waterbase 900 Series	-	Gravity feed: 1,2-1,3 mm Suction feed: 1,4-1,6mm	1,5-2 coats 50-60 µm	8h-12h	20-40 min	-	-	
Gun cleaners	General	1-051	1-051	Ready to use	Ready to use	-	-	-	-	-	-	-	-	-	-	-
	WaterBase	9-852	9-852	Ready to use	Ready to use	-	-	-	-	-	-	-	-	-	-	-
Additives	2K Elastic	47-39	47-39			Add 5-30% vol. 2K Elastic to 2K products when applied on a flexible or semi-flexible substrate. The amount of adding is related to the substrate. The more flexible the substrate, the more 2K Elastic must be added	-	In combination with suitable primer and/or 2-pack finish on semi-flexible substrates	-	-	-	-	-	-	-	-
	DB Coating additive	30-09	30-09			-	-	in combination with suitable primer on steel, old coatings and polyester substrates See info HS420 3000 Series	-	Gravity feed: 2,0-2,5mm	1-2 coats 75-150 µm	10h	-	-	-	
	Structure coat	1-060/1-065	1-060/1-065			2:1 (paint: structure coat	18-20 sec.	See info HS420 3000 Series and HS420 Clear Coats	-	Gravity feed: 1,4-1,6mm Suction feed: 1,6-1,8mm	1-2 coats 20-30 µm	8h	45 min.	-	-	

Overview HS420 Hardeners

	>15°C**	20°C	25°C	30°C	35°C
Spotrepair	8-30	8-30	8-30/8-40	8-30/8-40/8-44	8-40/8-44/8-50
Panel Repair	8-30/8-40*/8-44	8-40*/8-44/8-50	8-40*/8-44/8-50	8-44*/8-50	8-44*/8-50
Total respray	8-44/8-50	8-44/8-50	8-44/8-50	8-50	8-50

* Note : Only on Vertical parts.
** For less optimal conditions. Contact your local Technical Representative

valspar
If it matters, we're on it.

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