



## GENERAL INFORMATION

1-404 Air Dry Clear Coat is a rapidly drying clear coat which can be sprayed in a wet on wet application without flash off between coats. It offers a fantastic appearance with superior flow and leveling.

### MIXING RATIO



4 : 1 Clear Coat : Hardener + 0 - 5% Uni Thinner

### 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 coat 45 - 55 µm (1,8-2,2 mil)

Apply two full wet coats, no flash off between coats.

### FLASH OFF AND DRY TIMES



	HARDENER	DUST FREE (MIN.)	DRY TO HANDLE (MIN.)	DRY TO POLISH (MIN.)
Air Dry 20°C (68°F)	47-440	10	30	30 - 60*
	47-460	10	40	60 - 120*

\*Depending on the layer thickness and temperature.



### SUBSTRATES



MM 900 - 9999 WaterBase 900\* Series and MM 500 - 5999 BeroBase 500 Series. Sanded and degreased old layers.

Basecoat should be fully dry.

### POT LIFE AT 20°C / 68°F



60 - 120 minutes

Potlife depends on chosen hardener.

### COMPONENTS



47-440 Air Dry Hardener Medium  
47-460 Air Dry Hardener Slow  
1-141 Uni Thinner Fast  
1-151 Uni Thinner Medium  
1-161 Uni Thinner Slow  
1-171 Uni Thinner Very Slow  
47-91 Spot Repair Thinner  
1-231 Fade-Out Thinner

### ADDITIVES



### SURFACE PREPARATION



### NEXT LAYER



### PHYSICAL DATA

PHYSICAL DATA 1-404 AIR DRY CLEAR COAT		
Chemical Base	2K Polyurethane Finish	
Physical Properties	Viscosity (RT5)	<15 sec DinCup4 20°C
	Specific Gravity (kg/l)	0,978
	Flash Point Closed Cup	-9°C / 15°F
	Volume % Solids	35,3
	Economy	7,1 m <sup>2</sup> /L/50 µm 385 ft <sup>2</sup> /Gal/2 mil
	Gloss	High Gloss
	Colour	-



**DEBEER**  
REFINISH

**1-404**  
Air Dry Clear Coat

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



## NOTES

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