

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 SETUP



	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

Air pressure mentioned in table is base on inlet air.

APPLICATION



2 coat 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.

POTLIFE



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
 1-231 Fade-Out Thinner
 47-91 Spot Repair Thinner

ADDITIVES



SURFACE PREPARATION



NEXT LAYER



PHYSICAL DATA

RTS REGULATORY DATA:			4 : 1 : 0 - 5%	
			Uni Thinner Series	
	lb./gal		g/L	
Actual VOC	3.3 Max.		400 Max.	
Regulatory VOC (less water and exempt solvents)	4.2 Max.		500 Max.	
Density	7 - 9		840 - 1080	
	WT%		VOL%	
Total Solids Content	35 - 40		30 - 35	
Total Volatile Content	60 - 65		65 - 70	
Water	0		0	
Exempt Compound Content	20 - 30		20 - 30	
Coating Category	Clearcoat			



DEBEER
REFINISH

1-404
Air Dry Clear Coat

PROTECTION



Use suitable respiratory protection (*we recommend the use of a fresh air supply respirator*).

For more detailed information please visit the following link for the Safety Data Sheet:

<https://sds.de-beer.com>

CLEANUP



Cleaning the Equipment / Per local regulations.

STORAGE/SHELF LIFE

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

NOTES



INFORMATION: If used as instructed, this product is designed to comply with the US National Volatile Organic Compound (VOC) Emission Standard for Automobile Refinish Coatings. Confirm compliance with state and local air quality rules before use.