



GENERAL INFORMATION

80-121 HS Production Clear Coat is a high-gloss clearcoat with baking and air-dry capabilities. One activator with adjustment of reducers for size of job and spray temperature.

MIXING RATIO



	80-121	80-190	80-131	80-132
Small areas	3 parts	1 part	-	5 - 10%
Small and large areas	3 parts	1 part	10%	-

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	2/29
HE	-	-

Air pressure mentioned in table is base on inlet air.

APPLICATION



There are 4 different types of applications. Select the applicable option.

Small and large areas can be done with this application:

FIRST COAT	FLASH TIME	SECOND COAT	FLASH TIME	AIR DRY 20 °C / 68 °F	CURE TIME 65-71°C / 140°F	TIME TO POLISH
1/2 coat	-	1 wet coat	5 minutes	-	15-20 minutes	after cooling down
1 coat	not stringing	1 wet coat	5 minutes	-	15-20 minutes	after cooling down
1/2 coat	-	1 wet coat	-	4-5 hours	-	4-5 hours
1 coat	not stringing	1 wet coat	-	4-5 hours	-	4-5 hours

Small areas can be done with this application:

FIRST COAT	FLASH TIME	SECOND COAT	FLASH TIME	AIR DRY 20 °C / 68 °F	CURE TIME 65-71°C / 140°F	TIME TO POLISH
1/2 coat	-	1 wet coat	-	2-3 hours	-	2-3 hours
1 coat	5 minutes	1 wet coat	-	2-3 hours	-	2-3 hours

FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68 °F	FORCED DRY 60°C / 140°F
Flash off	-	Flash off
Dust-free	-	Dust-free
Dry-to-handle	8 hours overnight	Dry-to-handle
Dry-to-tape	-	Dry-to-tape
Dry-to-sand	-	Dry-to-sand
Dry-to-polish	8 hours overnight	Dry-to-polish



SUBSTRATES



MM 900 - 9999 WaterBase 900[®] Series and MM 500 - 5999 BeroBase 500 Series. Sanded and degreased old layers.

Basecoat should be fully dry.

COMPONENTS



80-190 Low Voc Hardener
1-141 Uni Thinner Fast
1-161 Uni Thinner Slow
1-171 Uni Thinner Very Slow

To shorten application and drying times replace reducers with 80-131 Production Additive or 80-132 Production Additive (Air Dry).

POTLIFE



20 minutes - 1,5 hours

The potlife may vary by the choice of the reducer and/or production additive.

ADDITIVES



80-131 Production Additive
80-132 Production Additive (Air Dry)

SURFACE PREPARATION



NEXT LAYER



PHYSICAL DATA

RTS REGULATORY DATA:		3 : 1 : 0 - 10%
Uni Thinner Series		
	lb./gal	g/L
Actual VOC	1.1 Max.	132 Max.
Regulatory VOC (less water and exempt solvents)	2.1 Max.	250 Max.
Density	8 - 10	960 - 1200
	WT%	VOL%
Total Solids Content	42 - 45	43 - 46
Total Volatile Content	55 - 58	54 - 57
Water	0	0
Exempt Compound Content	43 - 53	47 - 57
Coating Category	Clearcoat	

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 VOC standards in low-VOC jurisdictions. Refer to the Color Focus Formula Retrieval software for compliant color formula and thinner selection instruction. Confirm compliance with state and local air quality rules before use.