MM 500 - 5999
BeroBase 500 Series

GENERAL INFORMATION
MM 500 - 5999 BeroBase 500 Series is a clear-over-base system for passenger cars, commercial vehicles and coaches. The system provides an exceptional optical effect, high durability, resistance to chemicals and gloss retention.

MIXING RATIO
1 : 1 with Uni Thinner

When mixing an own formula with a metallic and/or pearl always use the wax calculation option ICRIS colour retrieval.

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 - 3 coats 15 - 25 µm (0,6-1,0 mil). For effect colours a mist coat is recommended at a lower pressure (1.2 - 1.5 BAR / 18 - 22 PSI). This mist coat is applied to semi-dry or dry base coat.

Re-coat with suitable clear coat within 8 hours.
After 8 hours scuff and reply base coat.

FLASH OFF AND DRY TIMES

AIR DRY 20 °C / 68 °F		FORCED DRY 60°C / 140°F	
Flash off	Until dry	**Flash off**	-
Dust-free	10 - 15 minutes	**Dust-free**	-
Dry-to-handle	15 - 20 minutes	**Dry-to-handle**	-
Dry-to-tape	15 - 20 minutes	**Dry-to-tape**	-
Dry-to-sand	-	**Dry-to-sand**	-
Dry-to-polish	-	**Dry-to-polish**	-

SUBSTRATES
MM 500 - 5999 BeroBase 500 Series should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium and primed plastic. Well sanded GRP, OEM primer and old paint systems in good condition.

Please make sure you choose a suitable primer/ surfacer by checking the TDS of the primer/surfacer.

POTLIFE
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FINISHING MATERIALS
All DeBeer applicable clear coats.

COMPONENTS
1-141 Uni Thinner Fast
1-151 Uni Thinner Medium
1-161 Uni Thinner Slow
1-1651 Uni Thinner Extra Slow
80-20 Standard Hardener

ADDITIVES
59-11 /.../ 59-22 Mysterious Colours

When adding 59-11 /.../ 59-22 Mysterious Colours shake the small bottle intensively for 2 minutes before use.

SURFACE PREPARATION
Pre clean the surface with 1-951 Silicon Remover wipe on and wipe dry. Sand surface with P400 or finer grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with 1-951 Silicon Remover wipe on and wipe dry.

Mask entire vehicle to eliminate unwanted overspray.

UNDER HOOD COLORS

MIX Step one
Activate the underhood color by mixing 10 parts 500 series + 1 part Harderner 80-20.

MIX Step two
Mix one part of the activated color with one part of reducer.

1-141 Uni Thinner Fast
1-151 Uni Thinner Medium
1-161 Uni Thinner Slow
1-1651 Uni Thinner Extra Slow

The addition of 80-20 hardener will help to improve chemical and impact resistance. Note: You do not need to apply clearcoat to underhood basecoat colors.

NEXT LAYER
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Revision Date: October 2024

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PHYSICAL DATA

RTS REGULATORY DATA:	1 : 1 Uni Thinner Series		10 : 1 : 11 Uni Thinner Series 80-20	
	lb./gal	g/L	lb./gal	g/L
Actual VOC	6.5 Max.	780 Max.	7.0 Max.	840 Max.
Regulatory VOC (less water and exempt solvents)	6.5 Max.	780 Max.	7.0 Max.	840 Max.
Density	7 – 10	840 – 1200	6.5 - 8.5	880 – 1020
	WT.%	VOL.%	WT.%	VOL.%
Total Solids Content	10 – 30	5 – 20	5 – 20	5 – 20
Total Volatile Content	70 – 90	80 – 95	80 – 95	80 – 95
Water	0	0	0	0
Exempt Compound Content	0 - 10	0 - 10	0 - 10	0 - 10
Coating Category	Color Coating		Specialty Coating Under Hood	

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

The up-to-date shelf life overview can be found by clicking on the following link:

Shelf life overview DeBeer

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.

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