MM 900 - 9999
WaterBase 900+ Series

GENERAL INFORMATION

MM 900 - 9999 WaterBase 900+ Series is a waterbased base-coat layer in a clear-over-base system. Suitable for passenger cars, touring cars and commercial vehicles. With a complete range of toners which provide you the option to mix the most common OEM colours in the market.

MIXING RATIO

Thinner is implemented in the colour formulation.

Custom made formulas add 10-20% 9-151 WaterBase 900+ Series Thinner.

Shake lightly.

GUN SET UP

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3	Please see appendix attached
HE	1,3	Please see appendix attached

APPLICATION

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

Please see attached Best Practice on page 3.

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	-	**Dust free**	-
Dry to handle	-	**Dry to handle**	-
Dry to tape	-	**Dry to tape**	-
Dry to sand	-	**Dry to sand**	-
Dry to polish	-	**Dry to polish**	-

Please see appendix attached.

SUBSTRATES

MM 900 - 9999 WaterBase 900+ 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.

POT LIFE AT 20°C / 68°F

6 month

Potlife mentioned is only for ready to spray colours that are not activated with 9-910 WaterBase 900+ Hardener. Potlife for activated colours is 30 - 60 minutes.

COMPONENTS

9-151 WaterBase 900+ Series Thinner

9-910 WaterBase 900+ Hardener

Please refer to best practice on the next pages, this hardener is only suitable in combination with HS420 clear coats.

ADDITIVES

9-819 WaterBase Underhood Additive
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 9-851 WaterBase 900+ Series Degreaser 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 9-851 WaterBase 900+ Series Degreaser wipe on and wipe dry.

Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER

All DeBeer applicable clear coats.

INFRARED DRYING

AFTER FULL FLASH OFF AND AT PROPER DISTANCE	
Half-bake	5 min 60°C
Full-bake	
See IR Manufacturer information	

PHYSICAL DATA

EU REGULATIONS		
VOC Code		2004/42/IIB(d)420)(418)
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		118/d. Topcoat -All types. EU limit values: 420 g/l. (2007) This product contains a maximum of 418 g/1 VOC.
Chemical Base	Acrylic Dispersion	
Physical Properties	**Viscosity (RTS)**	-
	Specific Gravity (kg/l)	1.008
	Flash Point Closed Cup	61°C / 141,8°F
	Volume % Solids	14
	Economy	7 m²/L/20 µm
		280 ft²/Gal/0,8 mil
	Gloss	-
	Colour	-

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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

CLEAN UP

9-852 WaterBase 900+ Series Gun Cleaner

After cleaning the spray gun thoroughly blow dry the spray gun with compressed air.

STORAGE/SHELF LIFE

Minimum 1 - 2 years; (Under normal storage conditions 5°C - 30°C / 50°F - 90°F) (unopened container).

To prevent freezing, do not expose the product to temperatures below 5°C / 41°F during transportation and storage.

Please see appendix attached.

NOTES

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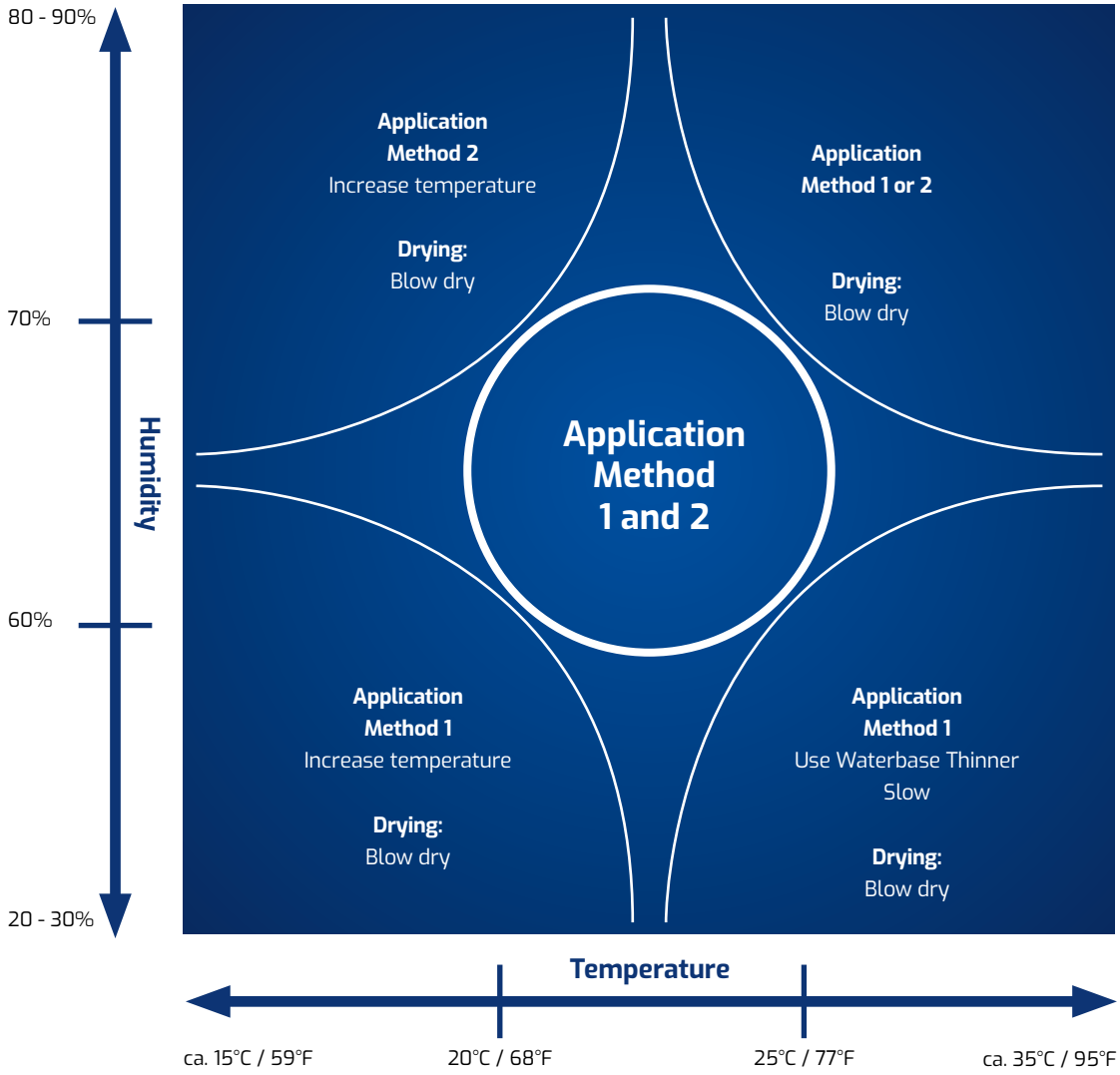
DEBEER REFINISH

BEST PRACTICES

Water basecoat application



APPLICATION METHOD 1:

	DESCRIPTION	AIR PRESSURE (BAR / PSI)
STEP 1	Two singles wet coats, wet on wet to cover	2 bar / 29 psi
STEP 2	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
STEP 3	Drop coat (effect colours only)	1 bar / 14,5 psi
STEP 4	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-

NOTE:
Surface must be carefully cleaned.
If necessary, first apply a mist coat and blow dry.

APPLICATION METHOD 2: **

	DESCRIPTION	AIR PRESSURE (BAR / PSI)
STEP 1	First single wet coat	2 bar / 29 psi
STEP 2	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
STEP 3	Second single wet coat	2 Bar / 29 PSI
STEP 4	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
STEP 5	Drop coat (effect colours only)	1 Bar / 14,5 PSI
STEP 6	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-

At temperatures between 20 - 25°C and a relative humidity between 60 - 70%, both Application Methods 1 and 2 are recommended.
** Application 2 is preferred for deep black solid colours to achieve the darkest shade.

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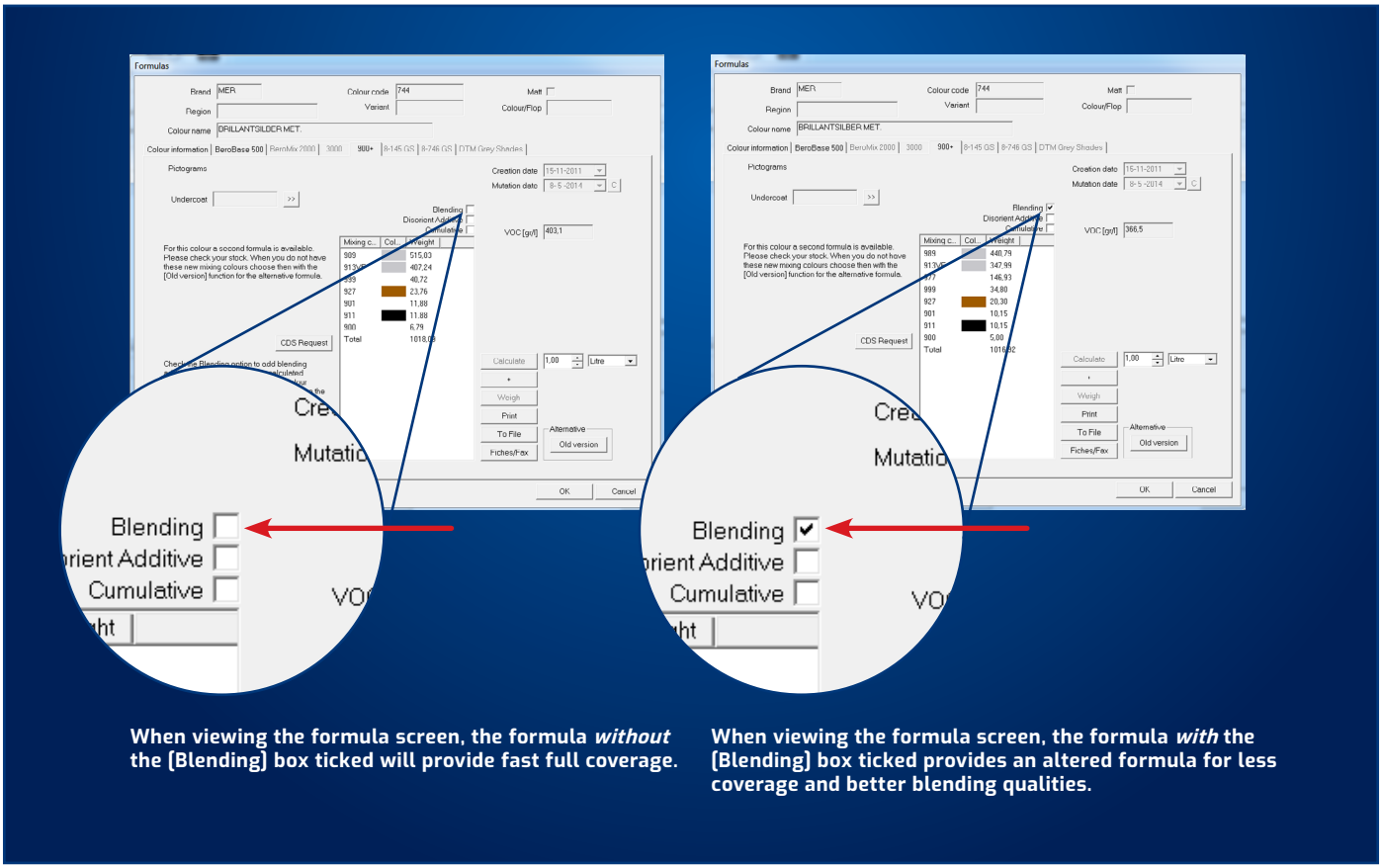
BEST PRACTICES

BLENDING PROCESS

GENERAL INFORMATION

Recommendations for blending a challenging aluminium effect color to an adjacent part with DeBeer Refinish 900⁺ Series. Blending high covering effect colors with greater than 60% of aluminium toner content can be a challenge. Especially when blending these colors for spot repair or onto the adjacent panel depending on the type of color. To help with blending we now have two formulas on the ICRIS system.



When viewing the formula screen, the formula *without* the (Blending) box ticked will provide fast full coverage.

When viewing the formula screen, the formula *with* the (Blending) box ticked provides an altered formula for less coverage and better blending qualities.

RECOMMENDED PROCESS TO FOLLOW FOR INVISIBLE EFFECT COLOUR BLENDING

PREPARATION

Color check
Always determine the right color and/or color variant. This should be performed at the earliest stage possible, preferably when estimation of the repair is carried out. Creating a spray-out at this stage is best practice.

Cleaning
Clean with 1-951 Silicone Remover and/or 9-851 WaterBase 900⁺ Series Degreaser.

Protection
Use suitable respiratory protection (fresh air supply respirator is strongly recommended).

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DEBEER REFINISH

BEST PRACTICES

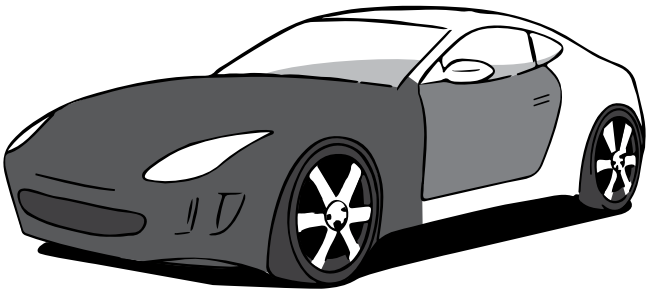
STEP 1 *PREPARE BLENDING AREA*

Dry sanding
Prepare the blending erea by dry sanding with DA sander orbit 3-5 grit P1500.
Prevent sand from entering through edges.

Wet sanding
Prepare the blending area by wet sanding using grit P2000/P3000.

Scuffing
Prepare the blending area by using an ultra-fine scuffing pad.

Cleaning
Clean with 1-951 Silicone Remover
and/or 9-851 WaterBase 900⁺ Series Degreaser.



STEP 2 *MIXING & APPLICATION OF 977*

Blending additive
Mix 977 blending additive with 9-151 waterbase thinner.
Mixing ratio: 977 + 10% 9-151.

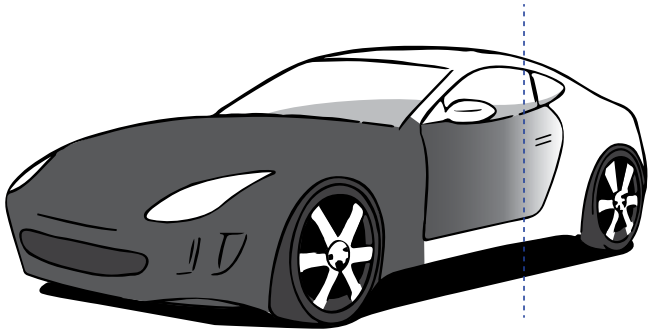
Application
Apply one flowing coat of 977 on 2/3 of the blending erea.

Gun setup

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

Flash-off
Until achieving a uniform matt surface.

Note
It is also possible to carry out this process in reverse order. Apply WaterBase 900⁺ Series for full coverage on the repair area. Dry the WaterBase 900⁺ Series then apply the 977 mix to the blending area dry and finish the blending process as described.



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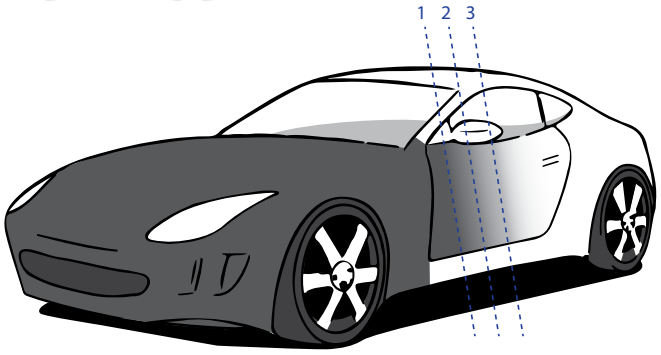
DEBEER REFINISH

BEST PRACTICES

STEP 3 APPLICATION OF WATERBASE



Application Color
900+ Blending color formula + 10% 9-151.
See option in ICRIS.

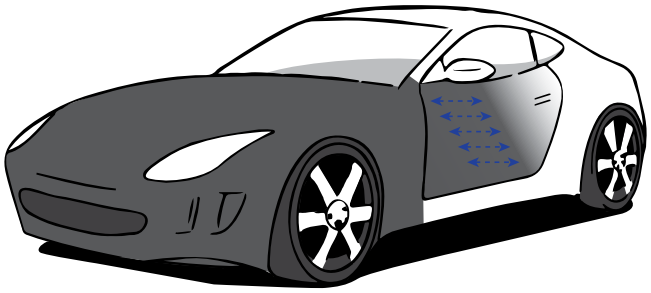
Application
Apply 2-3 coats or until covered arcing into blending area. Do not apply color beyond area 3 (See picture).

Gun setup

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

Flash-off
Until achieving a uniform matt surface.

STEP 4 APPLICATION OF WATERBASE DROP COAT



Application of dropcoat
Apply dropcoat at double distance at 1 bar.
stay within the blending area.
Do not apply color beyond area 3 (See picture).

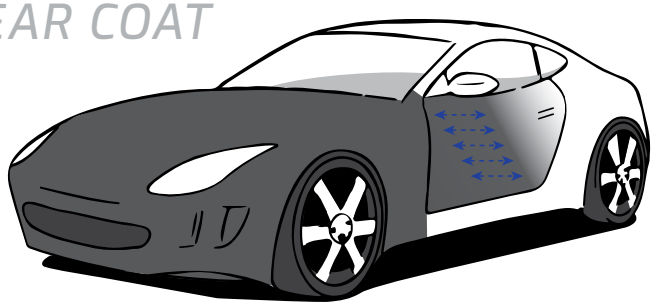
Gun setup

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2 - 1,3	1 / 14,5
HE	1,2 - 1,3	1 / 14,5

Flash-off
Until achieving a uniform matt surface.

The drop coat must be applied for color and effect, this will also assist color blending.

STEP 5 APPLICATION OF CLEAR COAT



Select a suitable De Beer Refinish clear coat and follow the technical information on the TDS.

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BEST PRACTICES

9-910 WaterBase 900⁺ Hardener

PREPARATION

Colour check
Always determine the right colour and/or colour variant. This should be performed at the earliest stage possible, preferably when estimation of the repair is performed. Creating a spray-out at this stage is best practice.

Protection
Use suitable respiratory protection
(fresh air supply respirator is strongly recommended).

Cleaning
Clean with 1-951 Silicone Remover
and/or 9-851 WaterBase 900⁺ Series Degreaser.

Surface preparation
Use sanding paper grit P500 or finer on repair area, and P1500 on blending area.

STEP 1

Mixing 900⁺ (step 1)
Add 2% of 9-910 WaterBase 900⁺ Hardener by weight to the mixed and thinned colour formula.

Mixing 900⁺ (step 2)
Add 15 - 20% of the 9-151 WaterBase 900⁺ Series Thinner, Mix thoroughly without incorporating air.

Note
After adding the hardener, the activated basecoat should be applied within:

30 minutes for effect colours
60 minutes for solid colours

Clean spray-gun immediately after use.

STEP 2

Application
Apply colour @ 2,0 bar, drop-coat @ 1 bar.
For gun set-up see table below.
Blend into the adjacent panel if needed.

	NOZZLE (MM)	AIR PRESSURE (PSI)
HVLP	1.2 - 1.3	2 / 29
HE	1.2 - 1.3	2 / 29

Flash-off
Until a uniform matt surface.

FINISHING PRODUCTS

1-951 Silicone Remover
8-615 HS420 High Production Clear
8-714 HS420 Supreme Clear Coat
8-774 Allround Clear
8-814 Fast Performance Clear
8-914 Super Clear
9-151 WaterBase 900⁺ Series Thinner
9-851 WaterBase 900⁺ Series Degreaser
9-910 WaterBase 900⁺ Hardener

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