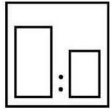


Serie 900+ WaterBase MM 900 - 9999

APPLICATION DATA



Mixing Ratio

(Only for USA 3.5 VOC Base Coat)
 Topple packaging before use for 10 sec.
 Use the Paint pusher.

Using Mysterious Colours 59-11 to 59-15,
 shake intensively for 2 minutes before use.
Custom made formulas: add 10% Thinner 9-151/ 9-161.



Application viscosity DINCUP 4mm/20°C(70°F)

Airspray (sec)
 Pressure tank (sec)
 Airless (sec)

(*) Application Method 1 and Application Method 2:
 See APPENDIX 1
 (**) Maximum 24 hrs drying (20-25°C) before clear coating



Gravity feed
 Suction feed
 Pressure tank
 Airless
 HVLP
 HE

Nozzle diameter (mm)

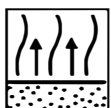
Spraying pressure (bar/psi)

1,3	See Info Manufacturer
1,3	See Info Manufacturer



Spray coats / Layer thickness (µm)

(*) / 15-20µm (0.6-0.8mil)



Flash-off (min) 20°C/70°F



Drying time (min) 20°C/70°F (**) 60°C/140°F Obj.



Potlife (min) 20°C/70°F 6 months

The technical data in these publications are based on our present knowledge and give you an idea of the various applications without obligations.



Serie 900+ WaterBase MM 900 - 9999



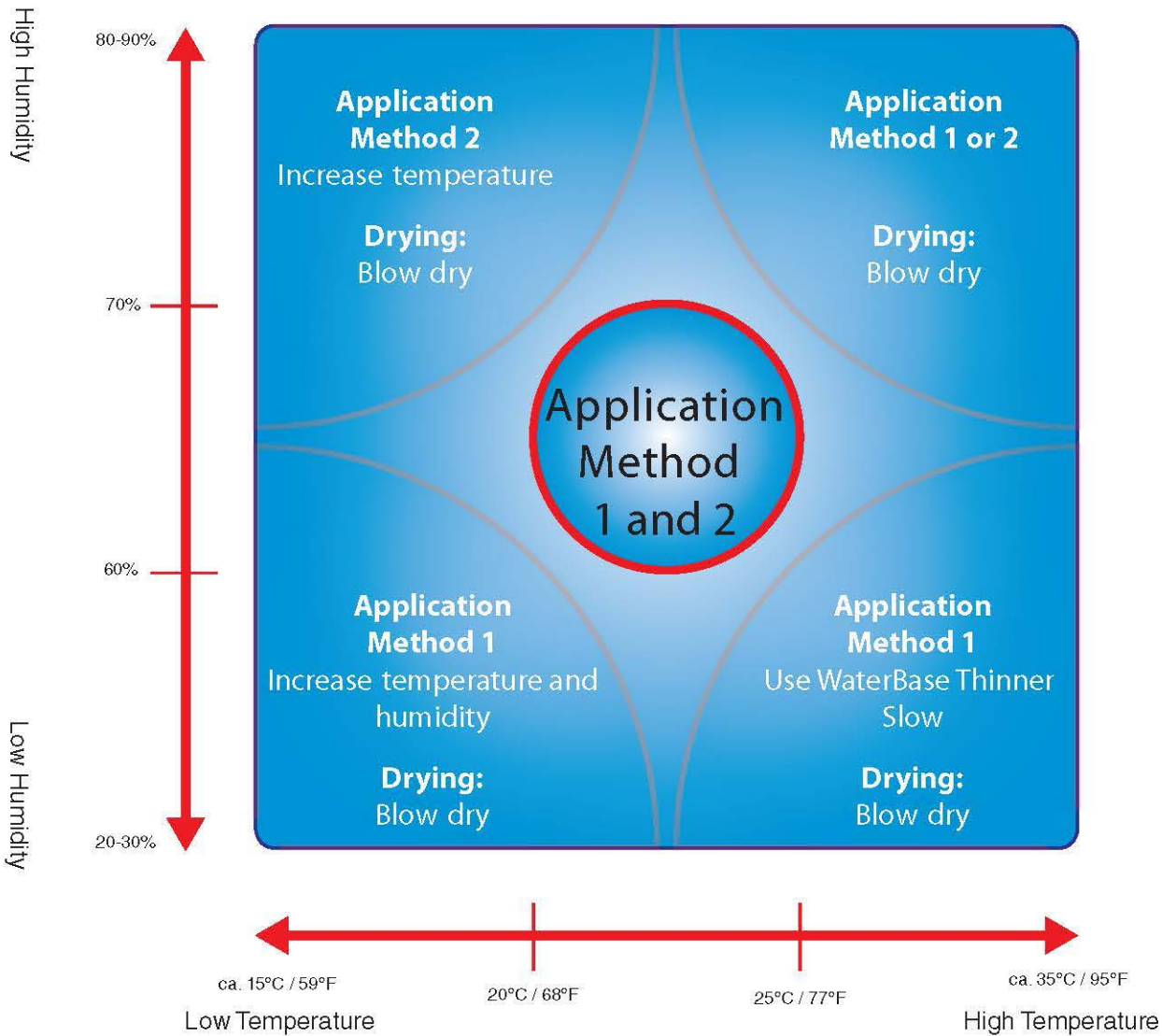
PRODUCT INFO

Area of application	Waterbased base-coat layer in a clear-over-base system. Suitable for passenger cars, touring cars, trucks etc.	
Chemical base	Acrylic dispersion.	
General qualities	Waterbase Serie is a base-coat which has to be finished with a recommended Clear Coat.	
Auxiliary materials	8-114, 9-151/ 9-161	
Physical properties	Specific gravity (kg/l)	0.992 to 1.103
	Flash point	Closed cup: >61°C (>141.8°F)
	Vol.% solids	15-35
	Economy	15 m ² /L/20 µm (0.8 mil)
	Gloss	
	Colour	Not available.
Substrates	See undercoats, Surface must be very carefully cleaned.	
Undercoats	8-145, 8-149 (Sanding), 30-746, 1-7510/1-7520, (80-221 only for USA)	
Finishing materials	1-204, 1-404, 8-104, 8-214, 8-414, 8-514, 8-614, 8-714, (80-121, 80-404 only for USA)	
Cleaning the equipment	9-852 WaterBase Gun Cleaner	
Storage life (years)	min. 1-2 (>5°C - <25°C) (see appendix) (Under normal storage conditions and unopened tins).	

The technical data in these publications are based on our present knowledge and give you an idea of the various applications without obligations.

APPENDIX 1

WATER BASECOAT APPLICATION FOR DIFFERENT HUMIDITY AND TEMPERATURE



Application Method 1:

- Two single wet coats, wet on wet to cover 2 Bar / 29 psi
- Blow dry *
- Drop coat (effect colours only) 1 Bar / 14.5 psi
- Blow dry *

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

Application Method 2: **

- First single wet coat 2 Bar / 29 PSI
- Blow dry *
- Second single wet coat 2 Bar / 29 PSI
- Blow dry *
- Drop coat (effect colours only) 1 Bar / 14.5 PSI
- Blow dry *

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

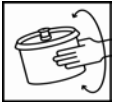
At temperatures between 20 -25 ° C and a relative humidity between 60-70%, both Application Methods 1 and 2 are recommended.

* Blow dry until matt at 30-35°C / 85-95°F

** Application 2 is preferred for deep black solid colours to achieve the darkest shade.

APPENDIX 2

11-3-2016



Topple packaging before use for 10 sec.
Use the Paint pusher.

Using Mysterious Colours; shake
intensively for 2 minutes before use.

Storage life / Shelf life Serie 900+ WaterBase MM 900 - 999/ Mysterious Colours

Under normal storage conditions, constant temperature and unopened packaging (>5°C-<25°C)=(>41°F-<77°F)

900+	
WaterBase	
MM	Storage life (years)
900	2
901	1½
902	1½
903	1½
904	2
905	2
906	2
911	1½
912	2
913	2
913B	2
913C	2
913VC	2
913VF	2
919	2
920	2
921	1½
922	1½
923	2
924	2
926	2
927	2
928	1½
929	2
930	2
934	2
938	1½
940	2
942	1½
943	1
944	2
946	2
947	2
948	2
950	2
951	2
952	2
953	2
954	2
955	2
956	2
957	2
959	2
960	2
961	2
962	2
963	2
964	2
965	2
966	2
967	2
969	2
971	2
972	2
973	2
974	2
975	2
976	2
977	1½
978	2
979	1½
986	2
987	2
989	2
990	2
997	2
998	2
999	2
9184	2

Mysterious Colours	Storage life (years)
59-11	2
59-12	2
59-13	2
59-14	2
59-15	2

APPENDIX 3 BLENDING PROCESS

Recommendations for blending a difficult aluminum effect color into an adjacent part using DeBeer Refinish 900+ Series

Blending high covering effect colors with greater than 60% of aluminum toner content can be a challenge. Especially when blending these colors in a spot repair or into the adjacent panel, depending on the type of color. To help with blending, we now have two formulas on the ICRIS system.

Formulas

Brand TOY Colour code 854 Variant

Region Colour name LIGHT SKY BLUE MET.

Colour information BeroBase 500 | BeroMix 2000 | 3000 900+ | 8-145 GS | 8-746 GS

Pictograms

Undercoat >>

Mutator date 16-11-2012

Blending Cumulative

VOC [g/l] 347,8

Lead content % 0,00

Mixing col.	Colour	Weight
989		380,3
913VF		231,4
977		151,8
999		103,0
987		75,0
900		37,7
934		28,5
911		7,1
906		2,3
Total		1017,6

Calculate 1,00 Liter

+ Weigh Print To File Fiches/Fax

OK Cancel

Formulas

Brand TOY Colour code 854 Variant

Region Colour name LIGHT SKY BLUE MET.

Colour information BeroBase 500 | BeroMix 2000 | 3000 900+ | 8-145 GS | 8-746 GS

Pictograms

Undercoat >>

Mutator date 16-11-2012

Blending Cumulative

VOC [g/l] 382,5

Lead content % 0,00

Mixing col.	Colour	Weight
989		447,5
913VF		272,3
999		121,2
987		88,3
900		44,3
934		33,6
911		8,4
906		3,4
Total		1018,9

Calculate 1,00 Liter

+ Weigh Print To File Fiches/Fax

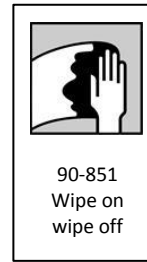
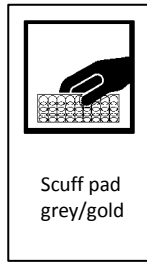
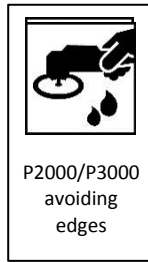
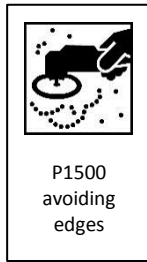
OK Cancel

Check the Blending option to add blending additive to the recipe. This is a calculated addition to the formula assisting with colour blending in to the adjacent areas. Reference the 900+ TDS for further details.

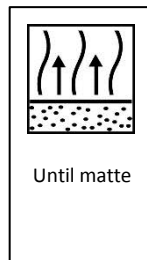
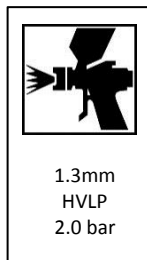
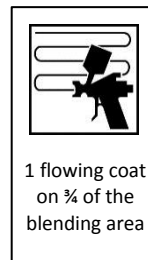
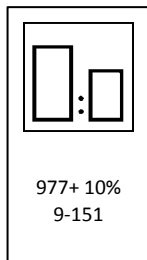
When viewing the formula screen, the formula without the [Blending] box selected will provide quick full coverage. When the [Blending] box is selected, this provides a modified formula for less coverage and better blending qualities.

The following steps comprise the DeBeer Refinish recommended process to follow for invisible effect color blending:

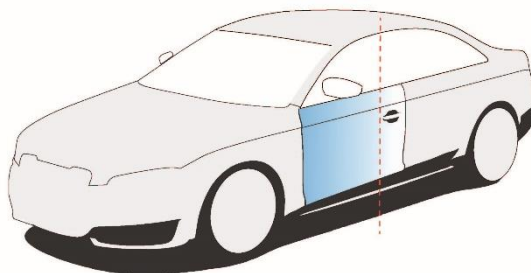
1. Prepare the blend area



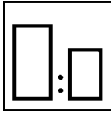


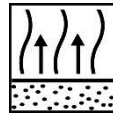

2. Mixing and application of 977 for the blending bed on blend area

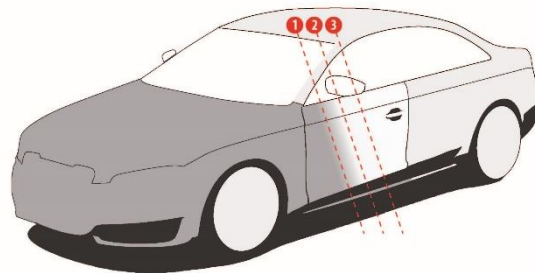


Note: It is also possible to carry out this process in reverse order; apply WaterBase 900* Series to full coverage on the repair area, dry the WaterBase 900* Series, then apply the 977 mix to the blend area dry and finish the blending process as described.



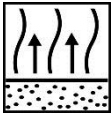



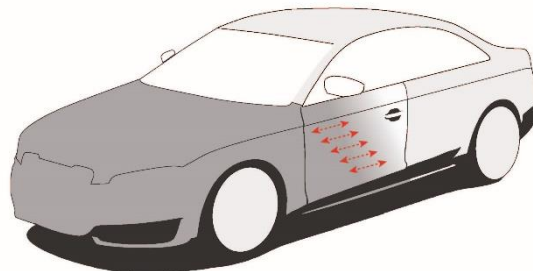
3. Application of WaterBase 900+ Series and blending

 <p>900+ Blending formula + 10% 9-151</p>	 <p>2-3 Arcing into blend area 1-2-3</p>	 <p>1.3mm HVLP 2.0 bar</p>	 <p>Until matte</p>	 <p>Arc spray technique</p>
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4. Application WaterBase 900+ Series drop coat

 <p>1-2 half normal speed and double the distance</p>	 <p>1.3mm HVLP 1.0 bar</p>	 <p>Until matte</p>	 <p>The drop coat must be applied for color and effect; this will also assist color blending</p>
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5. Application DeBeer Refinish clearcoat

To finish, select the required DeBeer Refinish clearcoat and follow the technical information

