

## 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



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

**Please see appendix attached.**

### 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.**

### FINISHING MATERIALS



All DeBeer applicable clear coats.

### COMPONENTS



9-151 WaterBase 900+ Series Thinner

### ADDITIVES



9-819 WaterBase Underhood Additive  
59-11 /.../ 59-15 Mysterious Colours

**When adding 59-11 /.../ 59-15 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.**

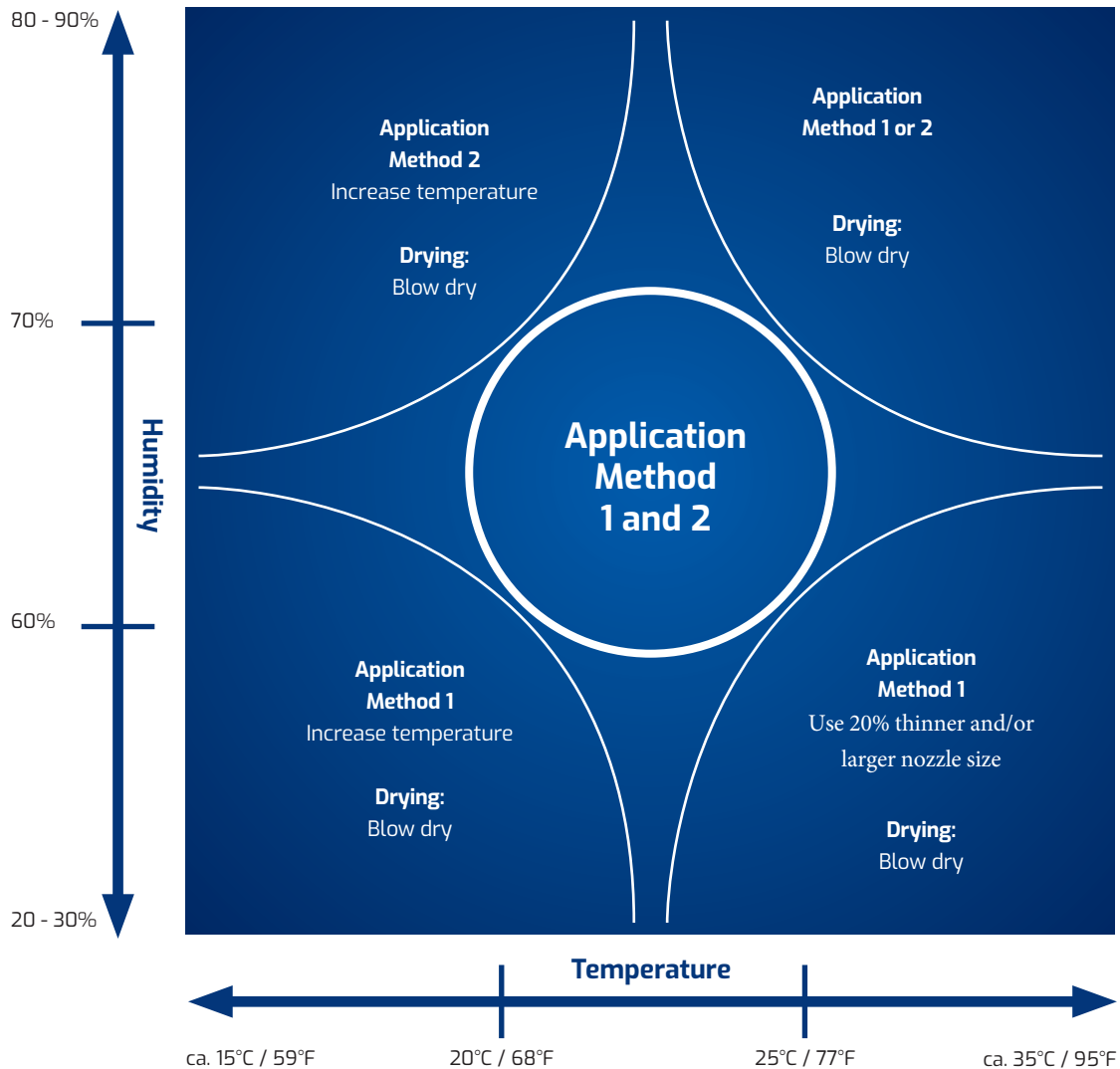
### NEXT LAYER



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### PHYSICAL DATA

EU REGULATIONS		
VOC Code	2004/42/11B(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.	11B/d. Topcoat - All types. EU limit values: 420 g/L (2007) This product contains a maximum of 418 g/l VOC.	
Chemical Base	Acrylic Dispersion	
Physical Properties	Viscosity (RT5)	-
	Specific Gravity (kg/l)	1,008
	Flash Point Closed Cup	61°C / 141,8°F
	Volume % Solids	14
	Economy	7 m <sup>2</sup> /L/20 m 280 ft <sup>2</sup> /Gal/0,8 mil
	Gloss	-
	Colour	-



## APPLICATION METHOD 1:

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

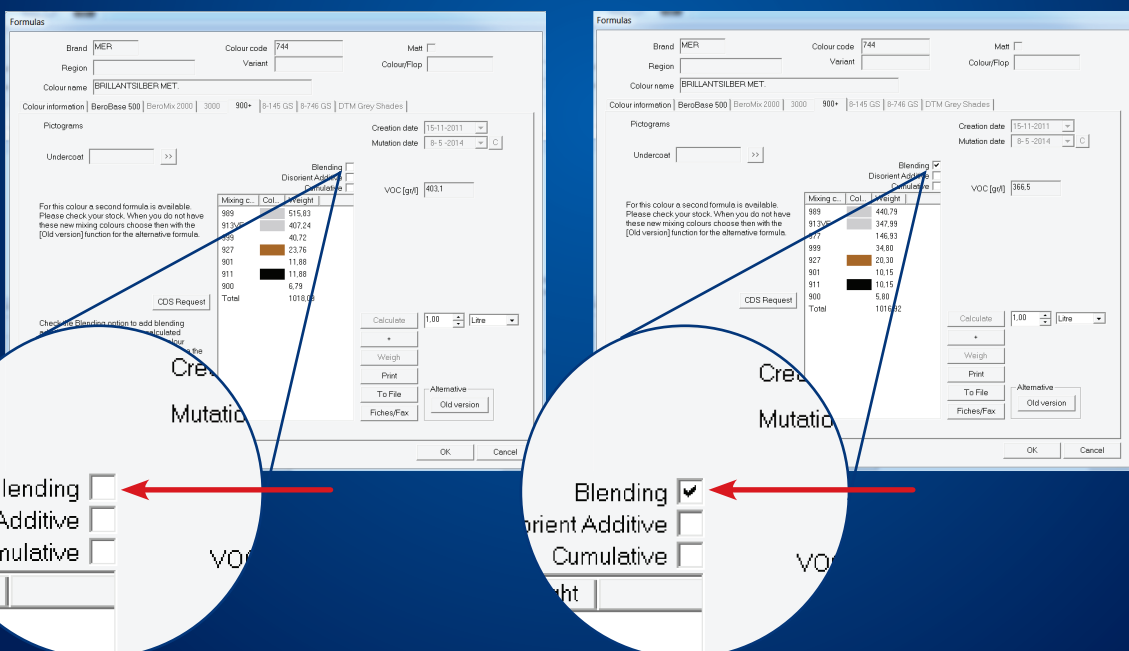
	DESCRIPTION	AIR PRESSURE (BAR / PSI)
<b>STEP 1</b>	First single wet coat	2 bar / 29 psi
<b>STEP 2</b>	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
<b>STEP 3</b>	Second single wet coat	2 Bar / 29 PSI
<b>STEP 4</b>	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
<b>STEP 5</b>	Drop coat (effect colours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

### GENERAL INFORMATION

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



**When viewing the formula screen, the formula *without* the [Blending] box ticked will give 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.**

## RECOMMEND PROCESS TO FOLLOW INVISIBLE EFFECT COLOUR BLENDING

### PREPARATION



#### Colour check

Always determine the right colour and/or colour variant. This should be done at the earliest stage possible, preferably when estimation of the repair is done. 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).



## STEP 1 *PREPARE BLEND AREA*



**Dry sanding**

Prepare the blending area by dry sanding with DA sander orbit 3-5 grit P1500.

**Avoid sand through edges.**



**Wet sanding**

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



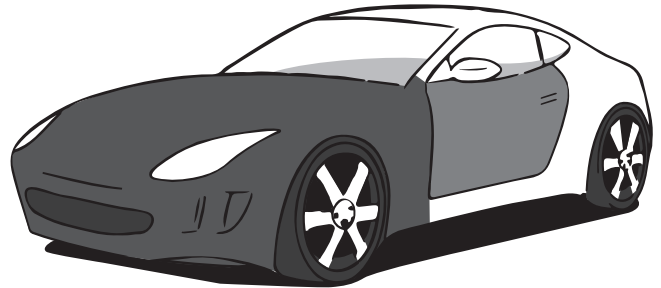
**Scuffing**

Prepare the blending area by using scuffing pad fine and ultra fine.



**Cleaning**

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



## STEP 2 *MIX & APPLICATION 977*



**Blending additive**

Mix 977 blending additive with 9-151 WaterBase 900+ Series Thinner. Mixing ratio: 977+ 10-20% 9-151.



**Application**

Apply one flowing coat off 977 on 2/3 off the blending area.



**Gun setup**

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



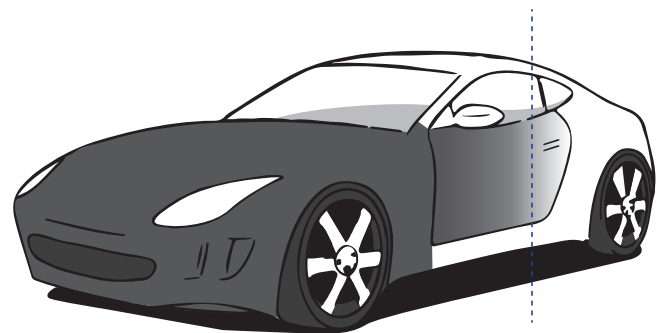
**Flash-off**

Until a uniform matt surface.



**Note**

It is also possible to do this process in reverse, 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.





## STEP 3 APPLICATION OF WATERBASE



**Application Color**

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



**Application**

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



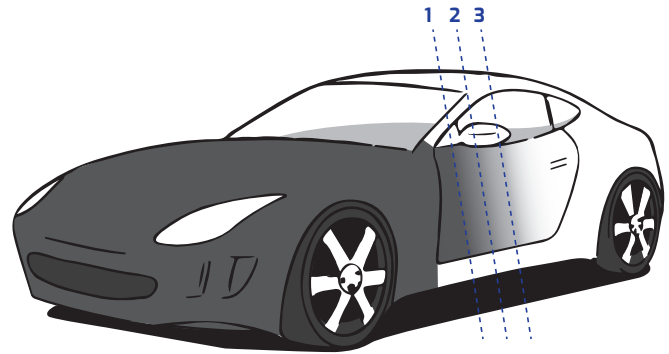
**Gun setup**

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



**Flash-off**

Until a uniform matt surface.



## STEP 4 APPLICATION WATERBASE DROP COAT



**Application dropcoat**

Apply dropcoat at double distance at 1 bar. stay with in 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 a uniform matt surface.



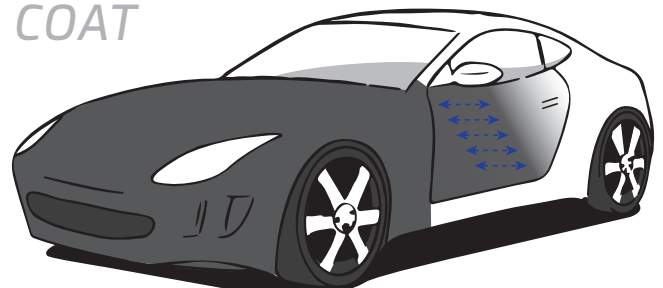
The drop coat must be applied for colour and effect, this will also assist colour blending.



## STEP 5 APPLICATION CLEAR COAT



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



## 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](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.



## NOTES

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