

## GENERAL INFORMATION

1-60 1K Plastic Primer - Aerosol is an adhesion primer based on special resins, to improve adhesion on new un-primed plastic parts for Automotive Refinish.

This TDS is about the aerosol version.

## MIXING RATIO



Shake well after you hear the marble inside the can is starting to make noise. It can take some time before the material loosens and starts to mix.

## GUN SETUP



Aerosol distance 20 - 25 cm (8 - 10")

## APPLICATION



1 coat 5 - 10 µm (0,2 - 0,4 mil)

## FLASH OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	15 - 20 minutes	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	-



If drying time of the 1-60 1K Plastic Primer - Aerosol exceeds 2 hours, scuff with scuff pad fine or equivalent and re - apply 1-60 1K Plastic Primer - Aerosol.

## SUBSTRATES



PLASTIC SUBSTRATE CODE	TYPE
PP-EPDM	Flexible Plastic
TPO	Flexible Plastic
ABS	Medium Plastic

All common plastic types currently used to produce OEM exterior parts and used in the automotive refinish industry. Do not use with Polyethylene (PE) and pure Polypropylene (PP). Do not use on pre - primed plastic parts. If you're unsure of the plastic type, test the adhesion prior to refinishing.

## POT LIFE AT 20°C (68°F)



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## COMPONENTS



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## ADDITIVES



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## SURFACE PREPARATION



Remove the release agent by washing down the substrate with hot soapy water and a scuff pad fine or equivalent. Rinse the substrate thoroughly with clean water. Blow dry the substrate, degrease with 1-951 Silicone Remover. Scuff the unprimed plastic parts with a fine scuff pad to prepare smooth substrates and medium - coarse scuff pad for textured substrates. Degrease again with 1-951 Silicone Remover.



Mask entire vehicle to eliminate unwanted overspray.

## NEXT LAYER



DeBeer 2K Primer / Surfacer  
 MM 900 - 9999 WaterBase 900\* Series  
 MM 500 - 5999 BeroBase 500 Series  
 MM 2000 - 2099 BeroMix 2000 Series  
 MM 3000 - 3046 BeroThane HS420 3000 Series

## PHYSICAL DATA

EU REGULATIONS		
VOC Code	2004/42/IIIB(e)(B40)755	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIIB/e. Special finishes - All types. EU limit values: 840 g/l (2007). This product contains a maximum of 755 g/l VOC.	
Chemical Base	Special resins	
Physical Properties	Viscosity (RTS)	-
	Density (kg/l)	0,770
	Flash Point Closed Cup	24°C / 75,2°F
	Volume % Solids	-
	Economy	400 ml/1 m <sup>2</sup> /25 µm
	Gloss	Matt
	Colour	-



**DEBEER**  
REFINISH

**1-60**

1K Plastic Primer - Aerosol

## 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:  
[SDS DeBeer](#)

## CLEANUP



After use, invert aerosol and press nozzle for 2 - 3 seconds

## STORAGE/SHELF LIFE



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

[Shelf life overview DeBeer](#)

## NOTES



All reported product properties on the TDS are determined at a temperature of 20°C / 68°F unless specified otherwise.