

GENERAL INFORMATION

This high filling two-component polyester spray filler can be applied using a gravity feed spray gun. Suited for all-round bodywork, it's the perfect option for large repair surfaces. The excellent adhesive properties mean it is easy to apply and sand while drying quickly.

MIXING RATIO



Add 3 - 5 percent Hardener and 2 - 5% Uni Thinner

GUN SETUP



| | NOZZLE (MM) | AIR PRESSURE (BAR / PSI) |
|------------------|-------------|--------------------------|
| HVLP | 2.0-3.0 | See info manufacturer |
| HE | - | See info manufacturer |
| Pressure tank | - | - |
| Airless / Airmix | - | 3,5-4,5 |

APPLICATION



1 - 3 coat 100 - 300 µm (3,9-11,7 mil)

FLASH-OFF AND DRY TIMES



| | AIR DRY 20°C / 68°F | FORCED DRY 60°C / 140°F | |
|---------------|---------------------|-------------------------|------------|
| Flash off | - | Flash off | - |
| Dust free | - | Dust free | - |
| Dry to handle | - | Dry to handle | - |
| Dry to tape | - | Dry to tape | - |
| Dry to sand | 3 - 5 hours | Dry to sand | 30 minutes |
| Dry to polish | - | Dry to polish | - |



Dry times may vary based on humidity and temperature. The values mentioned on the infrared dry times will vary depending on the chosen IR system.

SUBSTRATES



Sanded bare steel, fully cured coatings / epoxyprimer and polyester bodyfillers.

Do not use on aluminium, galvanized steel, washprimer and thermoplastic acrylics (TPA).

POT LIFE



15 - 30 minutes

COMPONENTS



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ADDITIVES



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SURFACE PREPARATION



Pre clean the surface with 1-951 Silicone Remover wipe on and wipe dry. Sand surface with P80-P120 grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with 1-951 Silicone Remover wipe on and wipe dry. Block sand P80-P120. Sanding P80-P180 orbit 5-7. Final sanding P180-P240 feather-edge.



NEXT LAYER



All DeBeer 2K Surfacer and primers.

PHYSICAL DATA

| EU REGULATIONS | | |
|--|---|---------------|
| VOC Code | 2004/42/IB(c)(540)250 | |
| Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product. | IB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 250 g/l VOC. | |
| Chemical Base | | |
| Physical Properties | Viscosity (RTS) | - |
| | Specific Gravity (kg/l) | 1,7 |
| | Flash Point Closed Cup | 31°C (87,8°F) |
| | Volume % Solids | - |
| | Economy | - |
| | Gloss | Matt |
| Colour | Grey | |

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/en/debeer/choose_localization

CLEANUP



1-051 Gun Cleaner

STORAGE / SHELF LIFE



Minimum 1 year; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES



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