



GENERAL INFORMATION:

Multi use polyurethane high solid (wet on wet) primer. This primer can be used as a general non sanding primer or for properly cleaned ridged unsanded OEM e-Coated panels. For the automotive refinish market, small and larger repairs. Available in white, mid grey and black, white and black can be combined to produce all six grey shades, these formulas are accessed on our ICRIS system. 8-746 can be directly applied to properly prepared automotive plastic parts when DeBeer Refinish 1-60 1K Plastic Primer is mixed in place of the thinners



COMPONENTS:

8-746	High Production Non Sanding Primer
47-55	MS Hardener Medium
47-65	MS Hardener Slow
8-150	HS Hardener Medium
8-160	HS Hardener Slow
8-450	HS420 Hardener Medium
8-460	HS420 Hardener Slow
1-151	Uni Thinner Medium
1-161	Uni Thinner Slow
8-181	HS420 Special Thinner (Recommended for temperatures above 25°C)



AUTOMOTIVE SUBSTRATES:

Properly cleaned unsanded ridged OEM e-Coat panels
 Properly cleaned and sanded original OEM paint system
 Properly cleaned and sanded SMC /GRP Glass Fibre Reinforced Polyester laminates*
 1-15 Washprimer
 Bare metal not exceeding 10 cm² (1-15 washprimer recommended)

Painting Plastic Parts: 8-746 can be applied directly to properly cleaned and prepared automotive plastic parts as follows using DeBeer Refinish 1-60 1K Plastic Primer as a plastic adhesion promoter added to the mixture of 8-746 in place of thinners. PP-EPDM, TPO, ABS, PUR,PP & PA. if unsure of the correct plastic code, test adhesion prior to refinishing, see appendix for location of plastics recommended. This mixture can also be used on Properly cleaned unsanded ridged OEM e-Coat panels

Substrates Notes:

* If the gelcoat of the GRP is broken through to the fibres, do NOT use 8-746. 8-746 is not recommended to apply directly over polyester filler.



SURFACE PREPARATION:

Wash surface with 9-851 waterbase degreaser or mild detergent and water, rinse with water and dry the surface



Wipe surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product flashes off

Final sanding, **if needed**, P400 if the complete panel will be primed

Spot repairs / local priming; final sanding with P500

Wipe surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product evaporates



MIXING RATIO:

3 : 1	Sealer: MS Hardener + 10% Uni Thinner
3 : 1	Sealer: HS Hardener + 10% Uni Thinner
5 : 1	Sealer: HS420 Hardener + 25% Uni Thinner

Note: Replace the thinners with DeBeer Refinish 1-60 1K Plastic Primer for use on recommended plastics



ADDITIVES:

47-39 2K Elastic (add 5-35% volume)

1-60 1K Plastic Primer (add in place of thinners when painting plastic automotive parts)



GUN SET UP:

	Nozzle (mm)	air pressure (bar/psi)
HE	1.3 - 1.4	2 / 29
HVLP	1.3 - 1.4	2 / 29



APPLICATION:

1 coat



POT LIFE at 20°C / 68°F

1 hour



FLASH OFF at 20°C / 68°F

Min: 12 minutes
 Max: 48 hours to be recoated*

*** After 48 hrs thorough sanding with P 400 - P500 is needed before the topcoat system can be applied.**



DRY TIMES:

Not applicable



CLEAN UP:

1-051 Gun Cleaner

NEXT LAYER:

WaterBase 900* Series
 BeroThane HS420 3000 Series

BeroBase 500 Series
 BeroMix 2000 Series

Non-EU product
Non-EU product

EU regulations			
VOC code	2004/42/IIIB(c)(540)480		
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540g/l. (2007) This product contains a maximum of 480 g/l VOC.		
Chemical base	2-Component hydroxyl acrylic resins		
Physical properties	Viscosity (RTS)	15-17 sec / Din4 /20°C	
	Specific gravity (g/l)	Grey	1,518
		White	1,530
		Black	1,466
	Flash point closed cup	28°C / 82°F	
	Vol. % solids	49	
	Film thickness	30 - 35 µm	
		1.2 - 1.4 mils.	
Economy; Theoretical coverage ready to spray	16.3 m ² /L/30µm 881.9ft ² /Gal/1.2mil		
Gloss	Low gloss		
Colour	Grey / White / Black		

STORAGE / SHELF LIFE:

Under normal storage conditions 10 - 30°C (50 - 90°F) up to two years in unopened container.



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).



NOTES:

8-74640 High Production Non Sanding Primer Black **GS901**
 8-74610 High Production Non Sanding Primer White **GS903**
 8-746 High Production Non Sanding Primer Mid Grey **GS907**

Re-cleaning: If batch priming, when the coated object is exposed to an open environment (e.g. outside of a spray booth) the object it must be re-cleaned before top-coating with 1-951 silicon remover, after 1 hour from application and up to 48h. Wipe on wipe dry method!

Appendix

Code	Name	Typical use in a vehicle
PP-EPDM	Polypropylene/Ethylene propylene diene monomer	Front and rear bumper face;
TPO	Thermoplastic olefin	Bumper impact absorber Interior trim
ABS	Acrylonitrile Butadiene Styrene	Door mirror (color); Roof spoiler Bumper, seating
PUR	Polyurethane	Upholstery
PP	Polypropylene	Front bumper core; Rear bumper core Delta cover inner; Inside rear view mirror; Tailgate trims (lower, upper, side) Rear end trim; Luggage floor box, centre; Rear and front scuff plate Cowl side trim;
PA	Polyamide (Nylon)	Under bonnet (hood) components Exterior trim