

GENERAL INFORMATION

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

MIXING RATIO



GUN SETUP



| | NOZZLE (MM) | AIR PRESSURE (BAR / PSI) |
|------|-------------|--------------------------|
| HVLP | 1,3-1,4 | 2/29 |
| HE | 1,3-1,4 | 2/29 |

Air pressure mentioned in table is base on inlet air.

APPLICATION



1 coat 0,2-0,4 mil

Spray one medium coat allowing flash of 15 -20 minutes before applying sealer of topcoat.

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 | 20 minutes | 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 | - |

After more than 2 hours drying of the 1-60 1K Plastic Primer, scuff with scuff pad fine or equivalent and re-apply 1-60 1K Plastic Primer.

SUBSTRATES



| PLASTIC SUBSTRATE CODE | TYPE |
|------------------------|-----------------------------|
| PP-EPDM | Flexible Plastic |
| TPO | Flexible Plastic |
| ABS | Medium Plastic |
| PUR | Flexible- Soft/Hard Plastic |
| PA | Hard Plastic |

All common plastic types currently used to produce OEM exterior parts and used in automotive refinishing. 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.

POTLIFE



COMPONENTS



ADDITIVES



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 a Low VOC surface cleaner. 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 1-851 Antistatic Degreaser.

Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



DeBeer 2K Primer / Surfacer
MM 900 - 9999 WaterBase 900* Series

Except Epoxy Primers and Washprimers. For flexible and soft plastics add 10 - 30%, 47-39 2K Elastic to the 2K paint systems before adding the hardener and thinner if needed.

PHYSICAL DATA

| 1-60 | | |
|---|-------------------|---------------|
| RTS REGULATORY DATA: | | Ready for Use |
| | lb./gal | g/L |
| Actual VOC | 6.93 Max. | 831 Max. |
| Regulatory VOC (less water and exempt solvents) | 6.93 Max. | 831 Max. |
| Density | 7 - 8 | 840 - 960 |
| | WT% | VOL% |
| Total Solids Content | 4.5 - 5.5 | 4.0 - 5.0 |
| Total Volatile Content | 94.5 - 95.5 | 94 - 95 |
| Water | 0 | 0 |
| Exempt Compound Content | 0 | 0 |
| Coating Category | Adhesion Promoter | |

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>

CLEANUP

Cleaning the Equipment / Per local regulations.

STORAGE SHELF LIFE

Minimum 3 years; (Under normal storage conditions
10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES

INFORMATION: If used as instructed, this product is designed to comply with the US and Canadian National Volatile Organic Compound (VOC) Emission Standards for Automobile Refinish Coatings. Confirm compliance with state and local air quality rules before use.