

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. Special Note: 1-60 1K Plastic Primer can be used as a Plastic adhesion additive in 8-746 High Production Non-Sanding Primer, saving you application and drying time. See 8-746 High Production Non-Sanding Primer TDS for Instructions. (This system is recommended with 8-746 High Production Non-Sanding Primer, no other DeBeer primer/surfacer).

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 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.

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
 MM 500 - 5999 BeroBase 500 Series
 MM 2000 - 2099 BeroMix 2000 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

RTS REGULATORY DATA:	1-60	
	Ready for Use	
	lb./gal	g/L
Actual VOC	7.0 Max	840
Regulatory VOC (less water and exempt solvents)	7.0 Max	840
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.