

GENERAL INFORMATION

8-145 HS Surfacer Grey is a 2K polyurethane high filling surfacer with excellent sanding properties, which can also be used as a non-sanding surfacer. It is very easy to apply and gives high durability and appearance.

This TDS is about the Sanding version.

MIXING RATIO



3 : 1 Surfacer : 2K/MS Hardener + max 10% Uni Thinner
4 : 1 Surfacer : HS Hardener + max 15% Uni Thinner

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,8	2/29
HE	1,3-1,8	1,6-1,8/23-26

Air pressure mentioned in table is base on inlet air.

APPLICATION



1 - 3 coat 2,4-7,2 mil

FLASH OFF AND DRY TIMES



	AIR DRY 20 °C / 68 °F		FORCED DRY 60 °C / 140 °F	
Flash off	5 - 10 minutes	Flash off	5 - 10 minutes	
Dust-free	20 - 30 minutes	Dust-free	-	
Dry-to-handle	3 - 6 hours	Dry-to-handle	20 - 30 minutes	
Dry-to-tape	3 - 6 hours	Dry-to-tape	20 - 30 minutes	
Dry-to-sand	3 - 6 hours	Dry-to-sand	20 - 30 minutes	
Dry-to-polish	-	Dry-to-polish	-	



Air pressure mentioned in table is base on inlet air.

SUBSTRATES



8-145 HS Surfacer Grey should only be applied over well sanded/scuffed and degreased primed bare steel and primed aluminium. Well sanded GRP, polyester fillers, OEM primer and old paint systems in good condition. (Use 1-15 Washprimer for maximum durability and rust protection.)

POTLIFE



20 - 30 minutes

COMPONENTS



47-20 2K Hardener Air Dry
47-35 MS Hardener Fast
47-55 MS Hardener Standard
47-65 MS Hardener Slow
8-130 HS Hardener Very Fast
8-140 HS Hardener Fast
8-150 HS Hardener Medium
8-160 HS Hardener Slow
1-141 Uni Thinner Fast
1-151 Uni Thinner Medium
1-161 Uni Thinner Slow
1-231 Fade-Out Thinner

ADDITIVES



47-39 2K Elastic
Add before hardener.

SURFACE PREPARATION



Pre clean the surface with 1-951 Silicon Remover wipe on and wipe dry. Sand surface with P180-P240 grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with 1-951 Silicon Remover wipe on and wipe dry. Final sanding before application P280-P320 feather-edge and GRP P400.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



MM 900 - 9999 WaterBase 900* Series
MM 500 - 5999 BeroBase 500 Series
MM 2000 - 2099 BeroMix 2000 Series

INFRARED DRYING



AFTER FULL FLASH OFF AND AT PROPER DISTANCE	
Half-bake	3 min 50°C
Full-bake	10 min 65°C
See IR Manufacturer information	

PHYSICAL DATA

RTS REGULATORY DATA:	3 : 1 : 0 - 10%		4 : 1 : 0 - 15%	
	Uni Thinner Series		Uni Thinner Series	
	lb./gal	g/L	lb./gal	g/L
Actual VOC	4.8 Max.	575 Max.	4.8 Max.	575 Max.
Regulatory VOC (less water and exempt solvents)	4.8 Max.	580 Max.	4.8 Max.	580 Max.
Density	11 – 12	1320 – 1440	11 – 12	1320 – 1440
	WT.%	VOL%	WT.%	VOL%
Total Solids Content	62 – 67	40 – 45	62 – 67	40 – 45
Total Volatile Content	33 – 38	55 – 60	33 – 38	55 – 60
Water Content	0	0	0	0
Exempt Compound Content	1 – 5	1 – 5	1 – 5	1 – 5
Coating Category	Primer Surfacer			

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



STORAGE/SHELF LIFE

Minimum 2 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 National Volatile Organic Compound (VOC) Emission Standard for Automobile Refinish Coatings. Confirm compliance with state and local air quality rules before use.