

GENERAL INFORMATION

8-74610 High Production Non-Sanding Primer White G5903 is a 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 refinishing 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. 8-74610 High Production Non-Sanding Primer White G5903 can be directly applied to properly prepared automotive plastic parts when DeBeer 1-60 1K Plastic Primer is mixed in stead of the thinners.

MIXING RATIO



3 : 1 Primer : MS Hardener + 10% Uni Thinner
 3 : 1 Primer : HS Hardener + 10% Uni Thinner

Add 1-171 Uni Thinner Very Slow for temperatures above 100 °F.

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 1,2-1,4 mil

FLASH OFF AND DRY TIMES



AIR DRY 20 °C / 68 °F		FORCED DRY 60°C / 140°F	
Flash off	12 minutes	Flash off	-
Dust-free	-	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	-

In case the 8-74610 High Production Non-Sanding Primer White G5903 is used in combination with 1-60 1K Plastic Primer, the adhesion on plastic substrates will develop in time. Optimal adhesion will be achieved after 2 days curing, when taking into account the specified layer thickness, flash-off times and drying times.

After 48 hrs thorough sanding with P400 - P500 is needed before the topcoat system can be applied.

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: 8-74610 High Production Non-Sanding Primer White G5903 can be applied directly to properly cleaned and prepared automotive plastic parts. Use the mixing ratios as above and replace the Uni Thinner % with DeBeer 1-60 1K Plastic Primer. Use over common automotive plastics, such as, PP-EDM, TPO, ABS, PUR & PA. If unsure of the correct plastic code, test adhesion prior to refinishing. This mixture combination can also be used over properly cleaned un-sanded ridged OEM e-Coat panels.

If the gelcoat of the GRP is broken through to the fibres, do NOT use 8-74610 High Production Non-Sanding Primer White G5903.

COMPONENTS



47-55 MS Hardener Standard
 47-65 MS Hardener Slow
 8-150 HS Hardener Medium
 8-160 HS Hardener Slow
 1-151 Uni Thinner Medium
 1-161 Uni Thinner Slow
 1-60 1K Plastic Primer
 1-171 Uni Thinner Very Slow
 47-91 Spot Repair Thinner
 1-231 Fade-Out Thinner

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60 minutes

ADDITIVES



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

SURFACE PREPARATION



Wash surface with 90-851 De Beer Waterbase Anti-Static Degreaser or mild detergent and water, rinse with water and dry the surface. Wipe surface with 1-951 Silicon 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 Silicon Remover and wipe dry with a clean cloth before the product evaporates. Plastic surface preparation, refer to the 1-60 1K Plastic Primer TDS for full details on the recommended preparation for plastic parts.

Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



MM 900 - 9999 WaterBase 900* Series
 MM 2000 - 2099 BeroMix 2000 Series

PHYSICAL DATA

RTS REGULATORY DATA:		3 : 1 : 10%
		Uni Thinner Series
	lb./gal	g/L
Actual VOC	4.5 Max.	537 Max.
Regulatory VOC (less water and exempt solvents)	4.6 Max.	550 Max.
Density	11 – 12	1320 – 1440
	WT.%	VOL.%
Total Solids Content	58 – 63	40 – 45
Total Volatile Content	37 – 42	55 – 60
Water	0	0
Exempt Compound Content	1 – 5	1 – 5
Coating Category	Primer Sealer	

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

NOTES



All reported product properties on the TDS are determined at a temperature of 77°F unless specified otherwise.

Re-cleaning: If batch priming, when the coated object is exposed to an open environment (e.g. outside of a spray booth) the object must be re-cleaned before top-coating with 1-951 Silicon Remover, after 1 hour from application and up to 48 hours. Wipe on wipe dry method. Jet washing freshly painted plastic parts is not recommended within one week of recommended paint application and curing process.

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.