



DEBEER
REFINISH

80-18540

HS primer sealer - Black

GENERAL INFORMATION

80-18540 HS primer sealer - Black is a high solids, VOC compliant, multi-use 2K urethane primer sealer. 80-18540 HS primer sealer - Black can be used as a standard high build primer, a 2K sealer with the addition of the DeBeer 80-120 2.1 VOC Sealer Converter for use in wet - on - wet application with DB500. 80-185 HS primer sealer - Gray can also be mixed as a quick dry, high production primer with the addition of the 47-99 Quick Cure Hardener and 1-199 Quick Cure Thinner to decrease the air-dry time to 15 - 20 minutes greatly improving cycle times. 80-185 HS primer sealer - Gray is pre-flexed for use in the repair of plastic parts. 80-18540 HS primer sealer - Black is also available in gray and white.

MIXING RATIO



H.S. Primer:

Primer: 4 parts 80-185
Hardener: 1 part 80-180
Thinner: 1 part 1-1051 / 1-1061

Sealer:

Primer: 4 parts 80-185
Converter: 2 parts 80-120 (For use with solventborne DB500) / 80-119 (For use with waterborne DB900)
Hardener: 2 parts 80-180
Thinner: 4 parts 1-1051 / 1-1061

Quick Cure Primer:

Primer: 2 parts 80-185
Quick Cure Hardener: 1 part 47-99
Quick Cure Thinner: 2 parts 1-199

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



H.S. Primer:

2 - 3 medium / wet coats

Sealer:

1 uniform coat (0,8-1,2 mil)

Quick Cure Primer: 2 - 3 medium back to back wet coats

No flash between coats. Recommended minimum dry film thickness after sanding - 2mils.

FLASH OFF AND DRY TIMES



	AIR DRY 25°C / 77°F		FORCED DRY 60°C / 140°F
Flash off	-	Flash off	-
Dust free	-	Dust free	-
Dry to handle	Overnight 1-1071	Dust Free	-
Dry to handle	< 1 hour 1-1011	Dry to handle	-
Dry to handle	2 - 3 hours 1-1051 / 1-1061	Dry to handle	25 - 30 min. 1-1071
Dry to tape	-	Dry to tape	-
Dry to sand	-	Dry to sand	-
Dry to polish	-	Dry to polish	-

High film builds and cool temperatures can increase dry times.

COMPONENTS



80-180 H.S. 2.1 VOC Hardener
47-99 Quick Cure Hardener
1-199 Quick Cure Thinner
1-1011 Accelerated Thinner
1-1051 Compliant Solvent - Medium
1-1061 Compliant Solvent - Slow
1-1071 Compliant Thinner - Very Slow
80-119 HS 2.1 VOC Sealer Converter
(For use with waterborne DB900)
80-120 2.1 VOC Sealer Converter
(For use with solventborne DB500)

SUBSTRATES



Treated Steel, treated Galvanized Steel, unsanded OEM E-coat, OEM Enamels, Refinish Enamel, treated Aluminum, fiberglass, body filler, etching primer and plastic primer.

POTLIFE



H.S. Primer:

1 hour

Sealer:

45 Minutes

Quick Cure Primer:

15 - 20 minutes

ADDITIVES



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SURFACE PREPARATION



Clean surface with 90-851 WaterBase Degreaser or mild detergent and water, rinse with water and dry the surface. Clean surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product evaporates. Final sanding, if needed, P400 if the complete panel will be primed. Spot repairs/local priming; final sanding with P500. Clean surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product evaporates.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



MM 500 - 5999 BeroBase 500 Series
MM 900 - 9999 WaterBase 900+ Series



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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 7 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.

PHYSICAL DATA

H.S. Primer:

RTS REGULATORY DATA	Primer: 4 parts Converter: 2 parts Hardener: 2 parts Thinner: 4 parts 1 part	
	LBS./Gal	g/L
Actual VOC	1.22	147
Regulatory VOC (less water and exempt solvents)	2.02	242
Density	11.71	1402
	WT%	VOL%
Total Solids Content	57.3	43.6
Total Volatile Content	42.7	56.4
Water	0.0	0.0
Exempt Compound Content	32.3	39.3
Coating Category	Sealer	

Sealer:

RTS REGULATORY DATA	Primer: 4 parts Converter: 2 parts Hardener: 2 parts Thinner: 4 parts 1 part	
	LBS./Gal	g/L
Actual VOC	0.95	114
Regulatory VOC (less water and exempt solvents)	2.00	240
Density	9.95	1192
	WT%	VOL%
Total Solids Content	45.7	34.4
Total Volatile Content	54.3	65.6
Water	0.0	0.0
Exempt Compound Content	44.7	52.4
Coating Category	Sealer	

Quick Cure Primer:

RTS REGULATORY DATA	Primer: 4 parts Converter: 2 parts Hardener: 2 parts Thinner: 4 parts 1 part	
	LBS./Gal	g/L
Actual VOC	0.73	88
Regulatory VOC (less water and exempt solvents)	1.3	156
Density	10.21	1223
	WT%	VOL%
Total Solids Content	56.0	46.2
Total Volatile Content	44.0	53.8
Water	0.0	0.0
Exempt Compound Content	36.8	43.6
Coating Category	Primer	