

## GENERAL INFORMATION

80-60 Low VOC 1K Plastic Adhesion Promoter is a Low VOC adhesion primer based on special resins to promote adhesion on new un-primed plastic parts for the Automotive Refinish Industry.

## MIXING RATIO



## GUN SETUP



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

## APPLICATION



1 coat 0,2-0,6 mil

**Spray one medium coat allowing minimum flash of 5 minutes, maximum flash of 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	5 - 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 20 minutes of drying of the 80-60 Low VOC 1K Plastic Adhesion Promoter scuff with scuff pad fine or equivalent and re-apply 80-60 Low VOC 1K Plastic Adhesion Promoter.**

## SUBSTRATES



Commonly used automotive interior and exterior plastics Thermopolyolefin (TPO), Polyvinyl Chloride (PVC), Reaction Injection Molded Polyurethane (RIM), and Polypropylene (PPO).

**Do not use with Polyethylene (PE) and pure Polypropylene (PP). Do not use on pre-primed plastic parts if unsure of the plastic type, test 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 90-851 WaterBase Degreaser. 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 90-851 WaterBase Degreaser.



**Tempering before cleaning will help to remove mould release.**

## NEXT LAYER



DeBeer 2K Primer / Surfacers  
 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:		80-60
		Ready for Use
	lb./gal	g/L
Actual VOC	0.45 Max.	54 Max.
Regulatory VOC (less water and exempt solvents)	4.5 Max.	540 Max.
Density	7 – 9	840 – 1080
	WT.%	VOL.%
Total Solids Content	3 – 7	3 – 7
Total Volatile Content	93 – 97	93 – 97
Water	0	0
Exempt Compound Content	90 – 95	90 – 95
Coating Category	Specialty Coating / 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 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 VOC standards in low-VOC jurisdictions. Refer to the Color Focus Formula Retrieval software for compliant color formula and thinner selection instruction. Confirm compliance with state and local air quality rules before use.