

GENERAL INFORMATION

This high filling two-component polyester spray filler can be applied using a gravity feed spray gun. Suited for all-round bodywork, it's the perfect option for large repair surfaces. The excellent adhesive properties mean it is easy to apply and sand while drying quickly.

MIXING RATIO



Add 3 - 5 percent Hardener and 2 - 5% Uni Thinner

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	2.0 - 3.0	See info manufacturer
HE	-	See info manufacturer
Pressure tank	-	-
Airless / Airmix	-	3.5 - 4.5

APPLICATION



1 - 3 coat 100 - 300 µm (3,9-11,7 mil)

FLASH-OFF AND DRY TIMES



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

Dry times may vary based on humidity and temperature.

SUBSTRATES



Sanded bare steel, fully cured coatings / epoxyprimer and polyester bodyfillers.

Do not use on aluminium, galvanized steel, washprimer and thermoplastic acrylics (TPA).

POT LIFE



15 - 30 minutes

COMPONENTS



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ADDITIVES



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SURFACE PREPARATION



Pre clean the surface with 1-951 Silicone Remover wipe on and wipe dry. Sand surface with P80-P120 grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with 1-951 Silicone Remover wipe on and wipe dry. Block sand P80-P120. Sanding P80-P180 orbit 5-7. Final sanding P180-P240 feather-edge.



NEXT LAYER



All DeBeer 2K Surfacer and primers.

PHYSICAL DATA

EU REGULATIONS 1-902 Polyester Spray Filler		
VOC Code	2004/42/IIIB(c)(540)250	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 250 g/l VOC.	
Chemical Base		
Physical Properties	Viscosity (RTS)	-
	Specific Gravity (kg/l)	1.7
	Flash Point Closed Cup	31°C (87,8°F)
	Volume % Solids	-
	Economy	-
	Gloss	Matt
	Colour	Grey

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/en/debeer/choose_localization

CLEANUP

1-051 Gun Cleaner

STORAGE / SHELF LIFE

Minimum 1 year; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES