



GENERAL INFORMATION

8-245 HS Direct to Metal Primer Surfacer is a 2K isocyanate-free, multi-use DTM primer surfacer for the Automotive Refinish Market. It has been designed to provide the highest performance in productivity, versatility, adhesion, durability and moisture and corrosion resistance. 8-245 HS Direct to Metal Primer Surfacer has superior sanding and sealing characteristics and may be used both as a high build sanding surfacer and as a direct to e-coat wet-on-wet non-sanding primer.

This TDS is about the non-sanding version.

MIXING RATIO



4 : 1 DTM Surfacer : DTM Hardener + 25% Uni Thinner

GUN SET UP



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

APPLICATION



1 coat 20 - 35 µm (0,8-1,6 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	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

SUBSTRATES



Properly cleaned and sanded aluminium, steel, galvanised steel. Properly cleaned ridged OEM E-Coat panels. Properly cleaned and sanded OEM paint system. Properly cleaned and sanded SMC /GRP Glass Fibre Reinforced Polyester Laminates and Bare Metal.

If the gelcoat of the GRP is broken through so the polyester fibres are exposed, do NOT use 8-245 HS Direct to Metal Primer Surfacer. Use Valspar 6080 Spray Filler (Polyester). 8-245 HS Direct to Metal Primer Surfacer is not suitable for plastic substrates.

POT LIFE AT 20°C / 68°F



30 - 45 minutes

COMPONENTS



8-45 Direct to Metal Hardener
1-141 Uni Thinner Fast
1-151 Uni Thinner Medium
1-161 Uni Thinner Slow
1-171 Uni Thinner Very Slow
47-91 Spot Repair Thinner
1-231 Fade-Out Thinner

ADDITIVES



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SURFACE PREPARATION



Wash surface with mild detergent and water. Rinse with water and dry the surface. Wipe surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product evaporates. Sand entire area to be coated with P320-P400. Spot repairs / local priming; final sanding with P500. Wipe surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product evaporates.



Mask entire vehicle to eliminate unwanted overspray. Aluminium substrates need to be sanded with P180-P240 and thorough cleaned. After drying off the 1-851 Antistatic Degreaser the rag should NOT show any traces of sanding residue. (black contamination)

NEXT LAYER



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

PHYSICAL DATA

EU REGULATIONS		
VOC Code	2004/42/IB(c)(540)(480)	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IB/c. Primer - Surface/filler and general (metal) primer. EU limit values: 540g/l.(2007)This product contains a maximum of 480 g/l VOC.	
Chemical Base	2-Component aceto-acetate resins	
Physical Properties	Viscosity (RTS)	16 - 19 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1,22
	Flash Point Closed Cup	30°C / 87°F
	Volume % Solids	35,2
	Economy	12 m ² /L/30 µm 490 ft ² /Gal/1,2 mil
	Gloss	Matt
Colour	Grey	



DEBEER
REFINISH

8-245

HS Direct to Metal Primer Surfacer

PROTECTION

Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).



For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.de-beer.com/en/debeer/choose_localization

CLEAN UP



1-051 Gun Cleaner

STORAGE/SHELF LIFE

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



NOTES

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This TDS is about the sanding version.

MIXING RATIO



4 : 1 DTM Surfacer : DTM Hardener + 10% Uni Thinner

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1.5-1.8	2/29
HE	1.5-1.8	2/29

APPLICATION



3 coat 150 µm (6 mil)

Allow 10-15 minutes between coats or until the surface is completely mat.

FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	10 - 15 minutes	Flash off	10 - 15 minutes	
Dust free	-	Dust free	-	
Dry to handle	1 - 1½ hours	Dry to handle	30 minutes	
Dry to tape	1 - 1½ hours	Dry to tape	30 minutes	
Dry to sand	1 - 1½ hours	Dry to sand	30 minutes	
Dry to polish	-	Dry to polish	-	



SUBSTRATES



Properly cleaned and sanded aluminium, steel, galvanised steel. Properly cleaned ridged OEM E-Coat panels. Properly cleaned and sanded OEM paint system. Properly cleaned and sanded SMC /GRP Glass Fibre Reinforced Polyester laminates and Bare Metal.

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30 - 45 minutes

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ADDITIVES



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Wash surface with mild detergent and water. Rinse with water and dry the surface. Wipe surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product evaporates. Sand entire area to be coated with P180-P240. Spot repairs / Local priming; final sanding with P400. Wipe surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product evaporates.



Mask entire vehicle to eliminate unwanted overspray. Aluminium substrates need to be sanded with P120-P180 and thorough cleaned. After drying off the 1-851 Antistatic Degreaser the rag should NOT show any traces of sanding residue. (black contamination)

NEXT LAYER



- MM 900 - 9999 WaterBase 900⁺ Series
- MM 500 - 5999 BeroBase 500 Series
- MM 2000 - 2099 BeroMix 2000 Series
- MM 3000 - 3046 BeroThane HS420 3000 Series

PHYSICAL DATA

EU REGULATIONS		
VOC Code	2004/42/IB(c)(540)(480)	
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Chemical Base	2-Component aceto-acetate resins	
Physical Properties	Viscosity (RTS)	20 - 25 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1.263
	Flash Point Closed Cup	30°C / 87°F
	Volume % Solids	40
	Economy	7 m ² /L/60 µm 285 ft ² /Gal/2.4 mil
	Gloss	Matt
	Colour	Grey



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