

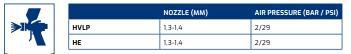
## **GENERAL INFORMATION**

1-60 1K Plastic Primer is an adhesion primer based on special resins, to improve adhesion on new un primed plastic parts for Automotive Refinish. Special Note: 1-60 1K Plastic Primer can be used as a Plastic adhesion additive in 8-746 High Production Non-Sanding Primer, saving you application and drying time. See 8-746 High Production Non-Sanding Primer TDS for Instructions. (This system is recommended with 8-746 High Production Non-Sanding Primer, no other De Beer primer/surfacer).

## **MIXING RATIO**



## **GUN SET UP**



## APPLICATION



1 coat 5 - 10 µm (0,2-0,4 mil)

## FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
	Flash off	15 - 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 2 hours drying of the 1-60 1K Plastic Primer, scuff with scuff pad fine or equivalent and re-apply 1-60 1K Plastic Primer.

### SUBSTRATES



	PLASTIC SUBSTRATE CODE	ТҮРЕ
	PP-EPDM	Flexible Plastic
J	ТРО	Flexible Plastic
	ABS	Medium Plastic
	PUR	Flexible- Soft/Hard Plastic
	PA	Hard Plastic

All common plastic types currently used to produce OEM exterior parts and used in automotive refinish industry. Do not use with Polyethylene (PE) and pure Polypropylene (PP). Do not use on pre-primed plastic parts.

If you're unsure of the plastic type, test the adhesion prior to refinishing.

## POT LIFE AT 20°C / 68°F



# 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 1-951 Silicone Remover. 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 1-851 Antistatic Degreaser.

Mask entire vehicle to eliminate unwanted overspray.

### **NEXT LAYER**



DeBeer 2K Primer / Surfacer MM 900 - 9999 WaterBase 900<sup>+</sup> Series MM 500 - 5999 BeroBase 500 Series MM 2000 - 2099 BeroMix 2000 Series MM 3000 - 3046 BeroThane HS420 3000 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**

EU REGULATIONS 1-60 1K Plastic Primer						
voc	Code	2004/42/IIB(e)(840)830				
Product sub category (acc directive 2004/42/EC) and content (ISO 11890-1/2) of to use product	d max VOC	IIB/e. Special finishes - All types. EU limit values: 840 g/l. (2007). This product contains a maxi- mum of 830 g/l VOC.				
Chemical Base	nical Base Special resins					
	Viscosity (RTS)	< 12 sec / Dincup 4 / 20°C				
	Specific Gravity (kg/l)	0,874				
	Flash Point Closed Cup	24°C / 75,2°F				
	Volume % Solids	4.4				
Physical Properties	Economy	9 m²/L/50 μm				
		365 ft²/Gal/0,2 mil				
	Gloss	Matt				
	Colour	-				

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## 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:

## **CLEAN UP**



1-051 Gun Cleaner

**SDS DeBeer** 

## STORAGE/SHELF LIFE

The up-to-date shelf life overview can be found by clicking on the following link: **Shelf life overview DeBeer** 



## NOTES

All reported product properties on the TDS are determined at a temperature of  $20^{\circ}$ C /  $68^{\circ}$ F unless specified otherwise.

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