DEBEER REFINISH 1-231
Fade-Out Thinner

GENERAL INFORMATION

1-231 Fade-Out Thinner is designed to fade out 2K top coats, clear coats and 2K wet on wet primer filler on a fade-out area, when partially priming a panel. It creates a smooth transition into the existing finish, so polishing is minimized with top coats. As the ratio between pressure and material inside the canister is adjusted optimally, the product's fast flash off allows for excellent edge wetting during the fade-out process.

This TDS is about the aerosol and the liquid version.

MIXING RATIO

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COMPONENTS

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GUN SET UP

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	-	-
HE	-	-

ADDITIVES

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APPLICATION

Please see page 2.

SURFACE PREPARATION

Prepare blending area by intensive cleaning with 1-951 Silicone Remover. Polish the entire area to remove all imperfection & machine sand around the blend area with P2000-3000. Degrease throughly with 1-951 Silicone Remover. After pretreatment do not touch with bare hands.

Mask entire vehicle to eliminate unwanted overspray.

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	-	Dry to sand	-
Dry to polish	-	Dry to polish	-

NEXT LAYER

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SUBSTRATES

All correctly prepared and applied top coats and clear coats.

POT LIFE AT 20°C / 68°F

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PHYSICAL DATA

PHYSICAL DATA 1-231 Fade-Out Thinner		
Chemical Base	Mix of organic solvents	
Physical Properties	Viscosity (RTS)	-
	Specific Gravity (kg/l)	0,714
	Flash Point Closed Cup	-41 °C / -41,8°F
	Volume % Solids	0,2
	Economy	-
		-
	Gloss	High Gloss
	Colour	-

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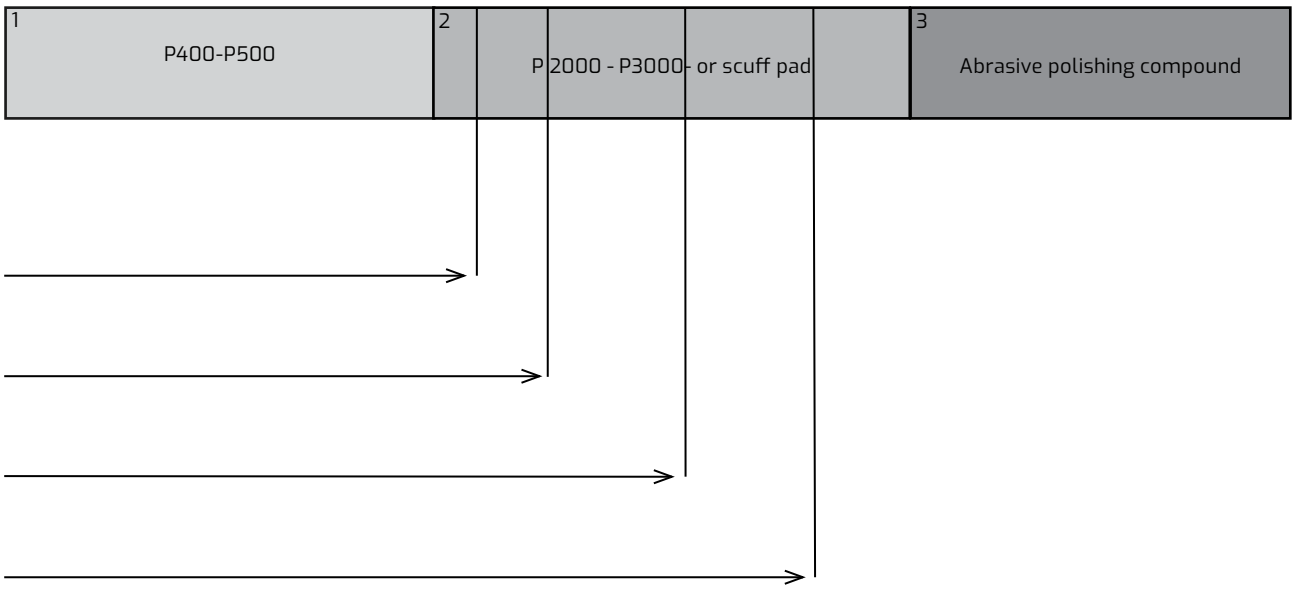
The below process discribes a tipical fading of the edge of clearcoat where the clearcoat can not be painted to a hard edge and clearcoat edge blending is requred, this discribes the part of the process directly after appling and drying the basecoat.

Process for blending clearcoat with 1-231 Aerosol Fade-Out Thinner



As you will see in the above diagram, there are three areas:
Area 1. treated with P400-P500,
Area 2. P2000 or P3000 or Scuff pad and
Area 3. a coarse abrasive compounded area (all sanded or scuffed areas) must well sanded and a matt appearance)

Step one: Clearcoat is applied over basecoated area to finish slightly beyond P400 and or P500 scratch pattern.

Step two: Without flash off of the second application of clearcoat, fully wet the entire clearcoat edge with the 1-231 aerosol fade out carrying part way into P2000/ P3000/ scuff pad scratch pattern.

Step three: Repeat step two slightly further into P2000/ P3000/ scuff pad scratch pattern.

Step four: Repeat step three (if needed) slightly further into P2000/ P3000/ scuff pad scratch pattern to finish.

Step five: Drying, ensure the clearcoat is fully cured and cooled down before the next step.

Step six: Polishing, if working in a small area, normally a hand polish with compound and polishing cloth will be all that is needed, on lager areas a machine polish with compound maybe needed.

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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:

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

CLEAN UP


1-051 Gun Cleaner

STORAGE/SHELF LIFE
Minimum 5 years (liquid), 10 years (aerosol); (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES
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