

GENERAL INFORMATION

8-746 High Production Non-Sanding Primer White G5903 is a multi use polyurethane High Solid (wet on wet) primer. This primer can be used as a general non sanding primer or for properly cleaned ridged unsanded OEM e-Coated panels. For the automotive refinishing market, small and larger repairs. Available in White, Mid Grey and Black. White and black can be combined to produce all six Grey Shades, these formulas are accessed on our ICRIS system. 8-746 High Production Non-Sanding Primer White G5903 can be directly applied to properly prepared automotive plastic parts such as, PP-EDM, TPO, ABS, PUR & PA when DeBeer 1-60 1K Plastic Primer is mixed instead of the thinners.

MIXING RATIO



3 : 1 Primer : M5 Hardener + 10% Uni Thinner
3 : 1 Primer : H5 Hardener + 10% Uni Thinner
5 : 1 Primer : H5420 Hardener + 25% Uni Thinner

GUN SET UP



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

APPLICATION



1 coat 30 - 35 µm (1,2-1,4 mil)

FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F
Flash off	12 minutes	Flash off	Do not forced dry
Dust free	-	Dust free	Do not forced dry
Dry to handle	-	Dry to handle	Do not forced dry
Dry to tape	-	Dry to tape	Do not forced dry
Dry to sand	-	Dry to sand	Do not forced dry
Dry to polish	-	Dry to polish	Do not forced dry

In case the 8-74610 High production Non Sanding primer is used in combination with 1-60 1K Plastic primer, the adhesion on plastic substrates will develop in time. Optimal adhesion will be achieved after 48 hrs curing, when taking into account the specified layer thickness, flash-off times and drying times.

SUBSTRATES



Properly cleaned unsanded ridged OEM e-Coat panels. Properly cleaned and sanded original OEM paint system. Properly cleaned and sanded GRP Glass Fibre Reinforced Polyester laminates 1-15 Washprimer. Bare metal not exceeding 10 cm² (1-15 Washprimer recommended).

Painting Plastic Parts: 8-746 High Production Non-Sanding Primer White G5903 can be applied directly to properly cleaned and prepared automotive plastic parts. Use the mixing ratios as above and replace the Uni Thinner % with DeBeer 1-60 1K Plastic Primer. Use over common automotive plastics. This mixture combination can also be used over properly cleaned un-sanded ridged OEM e-Coat panel.

If the gelcoat of the GRP is broken through to the fibres, do NOT use 8-746 High Production Non-Sanding Primer White G5903

COMPONENTS



47-55 M5 Hardener Medium
47-65 M5 Hardener Slow
8-150 H5 Hardener Medium
8-160 H5 Hardener Slow
8-450 H5420 Hardener Medium
8-460 H5420 Hardener Slow
1-151 Uni Thinner Medium
1-161 Uni Thinner Slow
1-171 Uni Thinner Very Slow
8-181 H5420 Special Thinner
1-60 1K Plastic Primer
47-91 Spot Repair Thinner
1-231 Fade-Out Thinner

8-181 H5420 Special Thinner (Recommended for temperatures above 25°C).

POT LIFE AT 20°C / 68°F



60 minutes

ADDITIVES



47-39 2K Elastic (add 5-35% volume)

SURFACE PREPARATION



Wash surface with 9-851 WaterBase 900+ Series Degreaser or 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 flashes off. Final sanding, if needed, P400 if the complete panel will be primed, 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. Plastic surface preparation, refer to the 1-60 1K Plastic Primer TDS for full details on the recommended preparation for plastic parts.

Mask entire vehicle to eliminate unwanted overspray.

After 48 hrs thorough sanding with P 400 - P500 is needed before the topcoat system can be applied.

NEXT LAYER



MM 900 - 9999 WaterBase 900+ Series
MM 3000 - 3046 BeroThane H5420 3000 Series
MM 2000 - 2099 BeroMix 2000 Series

In order to obtain the best result we recommend the use of H5420 clears.

PHYSICAL DATA

EU REGULATIONS		
VOC Code		2004/42/IIIB(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.		IIIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/L (2007) This product contains a maximum of 480 g/L VOC.
Chemical Base	2K Polyurethane Primer	
Physical Properties	Viscosity (RTS)	15 - 17 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1.325
	Flash Point Closed Cup	28°C / 82°F
	Volume % Solids	41.88
	Film Thickness	30 - 35 µm
		1.2 - 1.4 mil
	Theoretical Coverage Ready To Spray	14 m²/L/30 µm
		570 ft²/Gal/1.2 mil
	Gloss	Low gloss
	Colour	Grey

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

All reported product properties on the TDS are determined at a temperature of 20°C unless specified otherwise.

Re-cleaning: If batch priming, when the coated object is exposed to an open environment (e.g. outside of a spray booth) the object must be re-cleaned before top-coating with 1-951 Silicone Remover, after 1 hour from application and up to 48 hours. Wipe on wipe dry method. Jet washing freshly painted plastic parts is not recommended within one week of recommended paint application and curing process.