

### GENERAL INFORMATION

8-867 Allround Surfacer Grey can be used for small to large repair work over multiple automotive substrates. It can be applied directly on e-Coat primed parts and does not require an additional guide coat due to its glossy appearance after drying.

This TDS is about the Sanding version.

### MIXING RATIO



- 3 : 1 Surfacer : MS Hardener + max 5% Uni Thinner
- 7 : 2 Surfacer : HS Hardener + max 5% Uni Thinner
- 6 : 1 Surfacer : HS420 Hardener + max 15% Uni Thinner

### GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,4 - 1,6	2/29
HE	1,4 - 1,6	1,6 - 2,0 / 23 - 29

### APPLICATION



2 - 3 coat 60 - 180 µm

### FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	FORCED DRY 40°C / 104°F	FORCED DRY 60°C / 140°F
Flash off	10 - 15 minutes	10 - 15 minutes	10 - 15 minutes
Dust free	-	-	-
Dry to handle	-	-	-
Dry to tape	-	-	-
Dry to sand	1,5 - 4 hours	45 - 60 minutes	20 - 30 minutes
Dry to polish	-	-	-



### SUBSTRATES



8-867 Allround Surfacer Grey should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium. Well sanded and degreased GRP, polyester fillers and old paint systems in good condition. Well cleaned and degreased non-sanded OEM primer.

Bare metal not exceeding 10 cm<sup>2</sup> (1-15 Washprimer recommended).

On bare steel and aluminium use 1-15 Washprimer for maximum durability and rust protection.

### SUBSTRATES PLASTIC



Substrate	8-867 Sanding
ABS	It has good direct to ABS adhesion, no need to use the 1-60 1K Plastic Primer.
PP	It is possible to replace the thinner with the 1-60 1K Plastic Primer. It is also possible to spray the 1-60 1K Plastic Primer first.
PP/EPDM	It is possible to replace the thinner with the 1-60 1K Plastic Primer. It is also possible to spray the 1-60 1K Plastic Primer first.

### COMPONENTS



- 47-35 MS Hardener Fast
- 47-55 MS Hardener Medium
- 47-65 MS Hardener Slow
- 8-130 HS Hardener Very Fast
- 8-140 HS Hardener Fast
- 8-150 HS Hardener Medium
- 8-160 HS Hardener Slow
- 8-430 HS420 Hardener Very Fast
- 8-440 HS420 Hardener Fast
- 8-450 HS420 Hardener Medium
- 8-460 HS420 Hardener Slow
- 1-141 Uni Thinner Fast
- 1-151 Uni Thinner Medium
- 1-161 Uni Thinner Slow

### ADDITIVES



47-39 2K Elastic

Check TDS of 47-39. Add before hardener.

### POTLIFE



POTLIFE (+3 SEC/ DIN CUP 4 @ 20C)	
MS hardeners	25 - 30 min
HS hardeners	20 - 25 min
HS420 hardeners	18 - 22 min

### DRY TIMES AND DISTANCE IR



	FLASH TIME	Half-bake	Full-bake
Maximum 3 coats	5 minutes	8 minutes	7 minutes
ON PLASTIC	FLASH TIME	Half-bake	Full-bake
Maximum 3 coats	5 minutes	8 minutes	9 minutes

Follow the IR equipment recommendations for optimal distance between object and IR-lamps.

### SURFACE PREPARATION



Preclean the surface with 1-951 Silicone Remover. Wipe on and wipe dry. Sand surface with P180-P240 grit abrasive. Remove all sanding debris with compressed air. Sanding vacuum and clean with 1-951 Silicone Remover. Wipe on and wipe dry. Final sanding before application P280-P320 feather-edge and GPR P400. 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.



## NEXT LAYER



MM 900 - 9999 WaterBase 900+ Series  
MM 3000 - 3046 BeroThane H5420 3000 Series  
MM 500 - 5999 BeroBase 500 Series  
MM 2000 - 2099 BeroMix 2000 Series

## PHYSICAL DATA

EU REGULATIONS 8-867 Allround Surfacer Grey		
<b>VOC Code</b>	2004/42/II(B)(c)(540)540	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	II(B)(c). Primer - Surfacers/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 540 g/l VOC.	
<b>Chemical Base</b>	2K Polyurethane Primer	
<b>Physical Properties</b>	<b>Viscosity (RTS)</b>	15 - 19 Dincup 4 / 20°C
	<b>Specific Gravity (kg/l)</b>	With M5 hardeners: 1.39 (Grey) With H5 hardeners: 1.42 (Grey) With H5420 hardeners: 1.42 (Grey)
	<b>Flash Point Closed Cup</b>	33°C / 91,4°F
	<b>Volume % Solids</b>	With M5 hardeners: 42 (Grey) With H5 hardeners: 45 (Grey) With H5420 hardeners: 45 (Grey)
	<b>Economy</b>	With M5 hardeners: 7 m <sup>2</sup> (Grey) With H5 hardeners: 8 m <sup>2</sup> (Grey) With H5420 hardeners: 8 m <sup>2</sup> (Grey) (with 60 µm Layer thickness)
	<b>Gloss</b>	Egg Gloss
<b>Colour</b>	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](https://sds.de-beer.com/en/debeer/choose_localization)

## CLEANUP



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

