



## GENERAL INFORMATION

8-34740 Fast Surfacer Black can be used for small to medium repair work over multiple automotive substrates. The sanding surfacer can be applied directly on e-Coat primed parts and does not require an additional guide coat due to its glossy appearance after drying.

## MIXING RATIO



1 : 1 Surfacer : Thinner + 25% Hardener on volume

**Please note: The surfacer and thinner can be pre-mixed. The hardener needs to be added to the spray mixture just before application, due to the limited pot life.**

## GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	1,5 / 22
HE	1,3-1,4	1,8 / 26

## APPLICATION



2 - 3 coats, maximum around 100-120 µm

## FLASH OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	2 minutes	Flash off	-
Dust free	15 - 20 minutes	Dust free	-
Dry to handle	15 - 20 minutes	Dry to handle	-
Dry to tape	20 - 40 minutes	Dry to tape	-
Dry to sand	20 - 40 minutes	Dry to sand	-
Dry to polish	-	Dry to polish	-



**High film builds and low temperatures can increase dry times. Drying times may be slightly longer with temperatures below 20°C and low humidity.**

## SUBSTRATES



8-34740 Fast Surfacer Black should only be applied over well sanded/scuffed and degreased primed bare steel and primed aluminium.

Well sanded GRP, polyester fillers, OEM primer and old paint systems in good condition.

Use 1-15 Washprimer for maximum durability and rust protection.

## POTLIFE



15 minutes

## SUBSTRATES PLASTIC



Substrate	8-34740 Fast Surfacer
ABS	It has good direct to ABS adhesion, no need to use the 1-60 1K Plastic Primer
PP	Spray the 1-60 1K Plastic Primer
PP/EPDM	Spray the 1-60 1K Plastic Primer

## COMPONENTS



8-351 Fast Surfacer Thinner  
8-355 Fast Surfacer Hardener

## ADDITIVES



## 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 with P600 and P800 before application of Basecoat.

**Mask entire vehicle to eliminate unwanted overspray.**

## NEXT LAYER



MM 900 - 9999 WaterBase 900<sup>®</sup> Series  
MM 500 - 5999 BeroBase 500 Series

## INFRARED DRYING



AFTER FULL FLASH OFF AND AT PROPER DISTANCE	
Half-bake	2 min 60°C
Full-bake	1 min 70°C
See IR Manufacturer information	

## PHYSICAL DATA

EU REGULATIONS 8-34740 Fast Surfacer Black		
VOC Code	2004/42/11B(c)(540)511	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	11B/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.	
Chemical Base	2K Polyurethane Primer	
Physical Properties	Viscosity (RTS)	12 - 14 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1,19
	Flash Point Closed Cup	28°C / 82,4°F
	Volume % Solids	46,3
	Economy	185 ft <sup>2</sup> /Gal @ 4 mil 18,5 m <sup>2</sup> /L/100 µm
	Gloss	Egg Gloss
Colour	Black	

## 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:**

**[SDS DeBeer](#)**

## CLEANUP



1-051 Gun Cleaner

## STORAGE/SHELF LIFE



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

## NOTES



# 8-34740 FAST SURFACER BLACK

## CUMULATIVE WEIGHT\*

### MIX ACTIVATION CHART

Litres	Primer 1 <sup>st</sup>	Thinner 2 <sup>nd</sup>	Hardener 3 <sup>rd</sup>
	8-34740 Fast Surfacer Black	8-351 Fast Surfacer Thinner	8-355 Fast Surfacer Hardener
<b>0.1</b>	62,3	96,9	118,5
<b>0.2</b>	124,6	193,8	237,0
<b>0.3</b>	187,0	290,6	355,6
<b>0.4</b>	249,3	387,5	474,1
<b>0.5</b>	311,6	484,4	592,6
<b>0.6</b>	373,9	581,3	711,1
<b>0.7</b>	436,2	678,2	829,6
<b>0.8</b>	498,6	775,0	948,2
<b>0.9</b>	560,9	871,9	1066,7
<b>1.0</b>	623,2	968,8	1185,2
<b>1.2</b>	747,8	1162,6	1422,2
<b>1.4</b>	872,5	1356,3	1659,3
<b>1.6</b>	997,1	1550,1	1896,3
<b>1.8</b>	1121,8	1743,8	2133,4
<b>2.0</b>	1246,4	1937,6	2370,4

\*Weight in grams

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