8-34740

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/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. $\label{eq:proposed_prop_sand$

Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



MM 900 - 9999 WaterBase 900+ Series MM 500 - 5999 BeroBase 500 Series

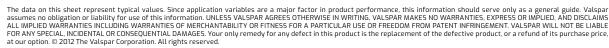
INFRARED DRYING



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/IIB(c)(540)463		
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		IIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 463 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 ft²/Gal @ 4 mil		
		18,5 m²/L/100 μm		
	Gloss	Egg Gloss		
	Colour	Black		







8-34740Fast Surfacer 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



