

GENERAL INFORMATION

8-347 Fast Surfacers Grey 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 Surfacers : 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



8-347 Fast Surfacers Grey 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.

POTLIFE



15 minutes

SUBSTRATES PLASTIC



Substrate	8-347 Fast Surfacers
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 Surfacers Thinner
8-355 Fast Surfacers 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⁺ 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 8-347 Fast Surfacers Grey	
VOC Code	2004/42/11B(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.	11B/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 Urethane Primer
Physical Properties	Viscosity (RTS)
	12 - 14 Dincup 4 / 20°C
	Specific Gravity (kg/l)
	1,21
	Flash Point Closed Cup
	28°C / 82,4°F
	Volume % Solids
Physical Properties	46,3
	Economy
	185 ft ² /Gal @ 4 mil
	18,5 m ² /L/100 µm
Physical Properties	Gloss
	Egg Gloss
Physical Properties	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:

[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

