1-60 1K Plastic Primer is an adhesion primer based on special resins, to improve adhesion on new un primed plastic parts for Automotive Refinish. Special Note: 1-60 1K Plastic Primer can be used as a Plastic adhesion additive in 8-746 High Production Non-Sanding Primer, saving you application and drying time. See 8-746 High Production Non-Sanding Primer TDS for Instructions. (This system is recommended with 8-746 High Production Non-Sanding Primer, no other De Beer primer/surfacer).

**GENERAL INFORMATION**

**ADDITIVES**

**GUN SET UP**

**APPLICATION**

1 coat 10 - 20 m (0.4-0.8 mil)

**FLASH OFF AND DRY TIMES**

**SUBSTRATES**

All common plastic types currently used to produce OEM exterior parts and used in automotive refinish industry. Do not use with Polyethylene (PE) and pure Polypropylene (PP). Do not use on pre-primed plastic parts. If you’re unsure of the plastic type, test the adhesion prior to refinishiing.

**NEXT LAYER**

DeBeer 2K Primer / Surfacer
MM 900 - 9999 WaterBase 900 Series
MM 500 - 5999 BeroBase 500 Series
MM 2000 - 2099 BeroMix 2000 Series
MM 3000 - 3046 BeroThane HS420 3000 Series

Except Epoxy Primers and Washprimers. For flexible and soft plastics add 10 - 30%, 47-39 2K Elastic to the 2K paint systems before adding the hardener and thinner if needed.

**PHYSICAL DATA**

<table>
<thead>
<tr>
<th>VOC Code</th>
<th>2004/42/IE (840)830</th>
</tr>
</thead>
<tbody>
<tr>
<td>Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product</td>
<td>18%: Special finishes - All types. EU limit values 840 g/l (2007). This product contains a maximum of 830 g/l VOC.</td>
</tr>
</tbody>
</table>

**EU REGULATIONS**

**PHYSICAL DATA**

**ADDITIVES**

<table>
<thead>
<tr>
<th>COMPONENTS</th>
<th>-</th>
</tr>
</thead>
<tbody>
<tr>
<td>MIXING RATIO</td>
<td>-</td>
</tr>
<tr>
<td>GUN SET UP</td>
<td>-</td>
</tr>
<tr>
<td>AIR PRESSURE (BAR / PSI)</td>
<td>-</td>
</tr>
<tr>
<td>NOZZLE (MM)</td>
<td>-</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>AIR DRY 20°C / 68°F</th>
<th>FORCED DRY 60°C / 140°F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flash off</td>
<td>Flash off</td>
</tr>
<tr>
<td>Dust free</td>
<td>Dust free</td>
</tr>
<tr>
<td>Dry to handle</td>
<td>Dry to handle</td>
</tr>
<tr>
<td>Dry to tape</td>
<td>Dry to tape</td>
</tr>
<tr>
<td>Dry to sand</td>
<td>Dry to sand</td>
</tr>
<tr>
<td>Dry to polish</td>
<td>Dry to polish</td>
</tr>
</tbody>
</table>

After more than 2 hours drying of the 1-60 1K Plastic Primer, scuff with scuff pad fine or equivalent and re-apply 1-60 1K Plastic Primer.

Mask entire vehicle to eliminate unwanted overspray.

Remove the release agent by washing down the substrate with hot soapy water and a scuff pad fine or equivalent. Rinse the substrate thoroughly with clean water. Blow dry the substrate, degrease with 1-951 Silicone Remover. Scuff the unprimed plastic parts with a fine scuff pad to prepare smooth substrates and medium-coarse scuff pad for textured substrates. Degrease again with 1-851 Antistatic Degreaser.

**SUBSTRAITES**

- PP-EPDM: Flexible Plastic
- TPO: Flexible Plastic
- ABS: Medium Plastic
- PUR: Flexible-Soft/Hard Plastic
- PA: Hard Plastic

**POT LIFE AT 20°C / 68°F**

- 6 hours drying of the 1-60 1K Plastic Primer, scuff with scuff pad fine or equivalent and re-apply 1-60 1K Plastic Primer.

The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligations or liability for use of this information. Unless Valspar agrees otherwise in writing, Valspar makes no warranties, express or implied, and disclaims all implied warranties including warranties of merchantability or fitness for a particular use or freedom from patent infringement. Valspar will not be liable for any special, incidental or consequential damages. Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option. © 2012 The Valspar Corporation. All rights reserved.

Revision Date: June 2019
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 3 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES
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