



DEBEER
REFINISH

1-60 1K Plastic Primer

GENERAL INFORMATION

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).

MIXING RATIO



GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	2/29
HE	1,3-1,4	2/29

APPLICATION



1 coat 10 - 20 m (0,4-0,8 mil)

FLASH OFF AND DRY TIMES



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



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.

SUBSTRATES



PLASTIC SUBSTRATE CODE	TYPE
PP-EPDM	Flexible Plastic
TPO	Flexible Plastic
ABS	Medium Plastic
PUR	Flexible- Soft/Hard Plastic
PA	Hard Plastic

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 refinishing.

POT LIFE AT 20°C / 68°F



COMPONENTS



ADDITIVES



SURFACE PREPARATION



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.

Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



DeBeer 2K Primer / Surfacers
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

EU REGULATIONS															
VOC Code	2004/42/IIIB(e)(840)830														
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product	IIIB/e. Special finishes - All types. EU limit values: 840 g/l. (2007). This product contains a maximum of 830 g/l VOC.														
Chemical Base	Special resins														
Physical Properties	<table> <tr> <td>Viscosity (RTS)</td><td>< 12 sec / Dincup 4 / 20°C</td></tr> <tr> <td>Specific Gravity (kg/l)</td><td>0,874</td></tr> <tr> <td>Flash Point Closed Cup</td><td>24°C / 75,2°F</td></tr> <tr> <td>Volume % Solids</td><td>4,4</td></tr> <tr> <td>Economy</td><td>9 m²/L/5 m</td></tr> <tr> <td>Gloss</td><td>365 ft²/Gal/0,2 mil</td></tr> <tr> <td>Colour</td><td>Matt</td></tr> </table>	Viscosity (RTS)	< 12 sec / Dincup 4 / 20°C	Specific Gravity (kg/l)	0,874	Flash Point Closed Cup	24°C / 75,2°F	Volume % Solids	4,4	Economy	9 m ² /L/5 m	Gloss	365 ft ² /Gal/0,2 mil	Colour	Matt
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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).



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