

GENERAL INFORMATION

This high filling two-component polyester spray filler can be applied using a gravity feed spray gun. Suited for all-round bodywork, it's the perfect option for large repair surfaces. The excellent adhesive properties mean it is easy to apply and sand while drying quickly.

MIXING RATIO



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Add 3 - 5 percent Hardener and 2 - 5% Uni Thinner

COMPONENTS



GUN SETUP

		NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
	HVLP	2,0-3,0	See info manufacturer
	HE	-	See info manufacturer
	Pressure tank	-	-
	Airless / Airmix	-	3,5-4,5

APPLICATION



1 - 3 coat 100 - 300 μm (3,9-11,7 mil)

FLASH-OFF AND DRY TIMES

AIR DRY 20°C / 68	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	-	Flash off	-	
Dust free	-	Dust free	-	
Dry to handle	-	Dry to handle	-	
Dry to tape	-	Dry to tape	-	
Dry to sand	3 - 5 hours	Dry to sand	30 minutes	
Dry to polish	-	Dry to polish		

Dry times may vary based on humidity and temperature. The values mentioned on the infrared dry times will vary depending on the chosen IR system.

SUBSTRATES



Sanded bare steel, fully cured coatings / epoxyprimer and polyester bodyfillers.

Do not use on aluminium, galvanized steel, washprimer and thermoplastic acrylics (TPA).

POT LIFE



15 - 30 minutes



SURFACE PREPARATION



Pre clean the surface with 1-951 Silicone Remover wipe on and wipe dry. Sand surface with P80-P120 grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with 1-951 Silicone Remover wipe on and wipe dry. Block sand P80-P120. Sanding P80-P180 orbit 5-7. Final sanding P180-P240 feather-edge.

NEXT LAYER



All DeBeer 2K Surfacers and primers.

PHYSICAL DATA

EU REGULATIONS					
VOC Code		2004/42/IIB(c)(540)250			
Product sub category (accordi 2004/42/EC) and max VOC cor 11890-1/2) of the ready to use	ntent (ISO	IIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 250 g/l VOC.			
Chemical Base					
	Viscosity (RTS)	-			
	Specific Gravity (kg/l)	1.7			
	Flash Point Closed Cup	31°C (87.8°F)			
Physical Properties	Volume % Solids	-			
	Economy	-			
	Gloss	Matt			
	Colour	Grey			

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PROTECTION



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator). For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.de-beer.com/en/debeer/choose_localization

CLEANUP



1-051 Gun Cleaner

STORAGE / SHELF LIFE



Minimum 1 year; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES



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