

GENERAL INFORMATION

8-347 Fast Surfacer 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 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



8-347 Fast Surfacer 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.

Use 1-15 Washprimer for maximum durability and rust protection.

POTLIFE



15 minutes

SUBSTRATES PLASTIC



Substrate	8-347 Fast Surfacer
ABS	It has good direct to ABS adhesion, no need to use the 1-60 1K Plastic Primer.
PP	Spray 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.

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 Surfacer Grey		
VOC Code	2004/42/11B(c)(540)510	
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 540 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	46,3
	Economy	185 ft ² /Gal @ 4 mil 18,5 m ² /L/100 µm
	Gloss	Egg Gloss
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



8-347 FAST SURFACER GREY

*CUMULATIVE WEIGHT**
MIX ACTIVATION CHART

Litres	Primer 1 st	Thinner 2 nd	Hardener 3 rd
	8-347 Fast Surfacers Grey	8-351 Fast Surfacers Thinner	8-355 Fast Surfacers Hardener
0.1	65,2	99,8	121,4
0.2	130,4	199,5	242,8
0.3	195,6	299,3	364,2
0.4	260,8	399,0	485,6
0.5	326,0	498,8	607,0
0.6	391,2	598,6	728,4
0.7	456,4	698,3	849,8
0.8	521,6	798,1	971,2
0.9	586,8	897,8	1092,6
1.0	652,0	997,6	1214,0
1.2	782,4	1197,1	1456,8
1.4	912,8	1396,6	1699,6
1.6	1043,2	1596,2	1942,4
1.8	1173,6	1795,7	2185,2
2.0	1304,0	1995,2	2428,0

*Weight in grams

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