

## GENERAL INFORMATION

8-945 Super Surfacer DTM Grey is a polyurethane high-solid surfacer designed to air dry at room temperature with good adhesion and corrosion protection properties. The surfacer can be used for small to large repair work over multiple automotive substrates. It can be applied directly on degreased and well-sanded steel and aluminium.

## MIXING RATIO



5 : 1 Surfacer : 8-910 Super Hardener + 25% Uni Thinner

## COMPONENTS



8-910 Super Hardener  
 1-141 Uni Thinner Fast  
 1-151 Uni Thinner Medium  
 1-161 Uni Thinner Slow  
 1-171 Uni Thinner Very Slow  
 1-181 Uni Thinner Ultra Slow

## GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,4 - 1,6	1,8 - 2,2 / 26 - 32
HE	1,4 - 1,6	1,8 - 2,0 / 26 - 29

## ADDITIVES



## APPLICATION



2 - 3 coats, 80 - 150 µm

**No flash off or 1 minute flash off between coats.**

## POTLIFE



15 - 20 minutes

## FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	LOW BAKE 40°C / 104°F	FORCED DRY 60°C / 140°F
Flash off	0 - 1 minute	0 - 1 minute	0 - 1 minute
Flash off before bake	-	5 minutes	5 minutes
Dry to handle	-	-	-
Dry to tape	-	-	-
Dry to sand	30 - 60 minutes	25 - 30 minutes	10 minutes
Dry to polish	-	-	-

**Drying times based on 2 coat application, times may increase depending on layer thickness and conditions. Please refer to the next page for additional drying times and thinner selection guidance.**

## DRY TIMES AND DISTANCE IR



	Maximum 3 coats	Half-bake	Full-bake
Flash Time	5 minutes	3 minutes	4 minutes

**Follow the IR equipment recommendations for optimal distance between object and IR-lamps.**

## SUBSTRATES



8-945 Super Surfacer DTM Grey could be applied directly on degreased and well sanded/scuffed metal/steel, aluminium, old OEM system and body filler. Degreased e-coat - light-sanding is recommended.

## 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 P400 and P500 before application of Basecoat.

**Mask entire vehicle to eliminate unwanted overspray.**

## NEXT LAYER



MM 900 - 9999 WaterBase 900\* Series  
 MM 3000 - 3046 BeroThane HS420 3000 Series  
 MM 500 - 5999 BeroBase 500 Series

## SUBSTRATES PLASTIC



Substrate	8-945
ABS	Spray the 1-60 1K Plastic Primer
PP/EPDM	Spray the 1-60 1K Plastic Primer

## PHYSICAL DATA

EU REGULATIONS 8-945 Super Surfacer DTM Grey		
VOC Code	2004/42/IIIB(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.	IIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 510 g/l VOC.	
Chemical Base	2K Polyurethane Primer	
Physical Properties	Viscosity (RTS)	19 - 21 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1.41
	Flash Point Closed Cup	10°C / 50°F
	Volume % Solids	42
	Economy	7 m²
	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



All reported product properties on the TDS are determined at a temperature of 20°C unless specified otherwise.



### Additional drying information

REPAIR SIZE	AIR DRY	AIR DRY	AIR DRY	AIR DRY	AIR DRY	AIR DRY	LOW BAKE	FORCE DRY	IR DRY
Application temperature	< 20°C	20 - 23°C	23 - 26°C	27 - 29°C	30 - 34°C	> 35°C	40°C	60°C	60°C
Spot repair	1-141	1-141	1-141	1-151	1-161	1-161	1-161	1-171	1-171
1 panel	1-141	1-141	1-151	1-151	1-161	1-171	1-171	1-171	1-171
Multi panels	1-141	1-151	1-151	1-161	1-171	1-181	1-171	1-171	1-171