

## GENERAL INFORMATION

8-867 Allround Surfacer Grey can be used for small to large repair work over multiple automotive substrates. It can be applied directly on e-Coat primed parts and does not require an additional guide coat due to its glossy appearance after drying.

This TDS is about the Sanding version.

## MIXING RATIO



3 : 1 Surfacer : MS Hardener + max 5% Uni Thinner  
 7 : 2 Surfacer : HS Hardener + max 5% Uni Thinner  
 6 : 1 Surfacer : HS420 Hardener + max 15% Uni Thinner

## GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,4-1,6	2/29
HE	1,4-1,6	1,6-2,0/23-29

## APPLICATION



2 - 3 coat 60-180 µm

## FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	FORCED DRY 40°C / 104°F	FORCED DRY 60°C / 140°F
Flash off	10 - 15 minutes	10 - 15 minutes	10 - 15 minutes
Dust free	-	-	-
Dry to handle	-	-	-
Dry to tape	-	-	-
Dry to sand	1,5 - 4 hours	45 - 60 minutes	20 - 30 minutes
Dry to polish	-	-	-

## SUBSTRATES



8-867 Allround Surfacer Grey should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium. Well sanded and degreased GRP, polyester fillers and old paint systems in good condition. Well cleaned and degreased non-sanded OEM primer.

On bare steel and aluminium use 1-15 Washprimer for maximum durability and rust protection.

## SUBSTRATES PLASTIC



Substrate	8-867 Sanding
ABS	It has good direct to ABS adhesion, no need to use the 1-60 1K Plastic Primer.
PP	It is possible to replace the thinner with the 1-60 1K Plastic Primer. It is also possible to spray the 1-60 1K Plastic Primer first.
PP/EPDM	It is possible to replace the thinner with the 1-60 1K Plastic Primer. It is also possible to spray the 1-60 1K Plastic Primer first.

## POTLIFE



POTLIFE (+3 SEC/ DIN CUP 4 @ 20C)	
MS hardeners	25 - 30 min
HS hardeners	20 - 25 min
HS420 hardeners	18 - 22 min

## COMPONENTS



47-35 MS Hardener Fast  
 47-55 MS Hardener Medium  
 47-65 MS Hardener Slow  
 8-130 HS Hardener Very Fast  
 8-140 HS Hardener Fast  
 8-150 HS Hardener Medium  
 8-160 HS Hardener Slow  
 8-430 HS420 Hardener Very Fast  
 8-440 HS420 Hardener Fast  
 8-450 HS420 Hardener Medium  
 8-460 HS420 Hardener Slow  
 1-141 Uni Thinner Fast  
 1-151 Uni Thinner Medium  
 1-161 Uni Thinner Slow

## ADDITIVES



47-39 2K Elastic

Check TDS of 47-39. Add before hardener.

## DRY TIMES AND DISTANCE IR



	FLASH TIME	Half-bake	Full-bake
Maximum 3 coats	5 minutes	8 minutes	7 minutes
ON PLASTIC	FLASH TIME	Half-bake	Full-bake
Maximum 3 coats	5 minutes	8 minutes	9 minutes

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

## 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 before application P280-P320 feather-edge and GPR P400. Plastic surface preparation refer to the 1-60 1K Plastic Primer TDS for full details on the recommended preparation for plastic parts.

Mask entire vehicle to eliminate unwanted overspray.

**NEXT LAYER**


MM 900 - 9999 WaterBase 900+ Series  
 MM 3000 - 3046 BeroThane H5420 3000 Series  
 MM 500 - 5999 BeroBase 500 Series  
 MM 2000 - 2099 BeroMix 2000 Series

**PHYSICAL DATA**

EU REGULATIONS		
<b>VOC Code</b>	2004/42/IB(c)(540)540	
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 - Surfacers/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 540 g/l VOC.	
<b>Chemical Base</b>	2K Polyurethane Primer	
<b>Physical Properties</b>	<b>Viscosity (RTS)</b>	15 - 19 Dincup 4 / 20°C
	<b>Specific Gravity (kg/l)</b>	With M5 hardeners: 1,39 (Grey) With H5 hardeners: 1,42 (Grey) With H5420 hardeners: 1,42 (Grey)
	<b>Flash Point Closed Cup</b>	33°C / 91,4°F
	<b>Volume % Solids</b>	With M5 hardeners: 42 (Grey) With H5 hardeners: 45 (Grey) With H5420 hardeners: 45 (Grey)
	<b>Economy</b>	With M5 hardeners: 7 m <sup>2</sup> (Grey) With H5 hardeners: 8 m <sup>2</sup> (Grey) With H5420 hardeners: 8 m <sup>2</sup> (Grey) (with 60 µm layer thickness)
	<b>Gloss</b>	Egg Gloss
	<b>Colour</b>	Grey

**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](https://sds.de-beer.com/en/debeer/choose_localization)

**CLEANUP**


1-051 Gun Cleaner

**STORAGE/SHELF LIFE**


Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

**NOTES**




## GENERAL INFORMATION

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This TDS is about the Non-Sanding version.

## MIXING RATIO



3 : 1 Surfacer : MS Hardener + max 10% Uni Thinner  
7 : 2 Surfacer : HS Hardener + max 10% Uni Thinner  
6 : 1 Surfacer : HS420 Hardener + max 25% Uni Thinner

## GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	2/29
HE	1,3-1,4	1,8-2,0/26-29

## APPLICATION



1 coat 25 - 40 µm

## FLASH OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	15 minutes	Flash off	-
Dust free	-	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	-

Overspray window 15 minutes till 48 hours

## SUBSTRATES



Properly cleaned un-sanded OEM e-Coat panels. Properly cleaned and sanded original OEM paint system. Properly cleaned and sanded Glass Fibre Reinforced Polyester laminates.

1-15 Washprimer. Bare metal not exceeding 10 cm<sup>2</sup> (1-15 Washprimer recommended).

**If the gelcoat of the Glass Fibre Reinforced Polyester is broken through to the fibres, do NOT use 8-867 Allround Surfacer Grey.**

## SUBSTRATES PLASTIC



Substrate	8-867 Non-Sanding
ABS	It has good direct to ABS adhesion, no need to use the 1-60 1K Plastic Primer.
PP	It has good direct to PP adhesion, no need to use the 1-60 1K Plastic Primer.
PP/EPDM	It is possible to replace the thinner with the 1-60 1K Plastic Primer. It is also possible to spray the 1-60 1K Plastic Primer first.

## POTLIFE



POTLIFE (+3 SEC/ DIN CUP 4 @ 20C)	
MS hardeners	40 - 45 min
HS hardeners	30 - 35 min
HS420 hardeners	37 - 45 min

## COMPONENTS



47-55 MS Hardener Medium  
47-65 MS Hardener Slow  
8-150 HS Hardener Medium  
8-160 HS Hardener Slow  
8-450 HS420 Hardener Medium  
8-460 HS420 Hardener Slow  
1-151 Uni Thinner Medium  
1-161 Uni Thinner Slow

## ADDITIVES



47-39 2K Elastic

**Check TDS of 47-39. Add before hardener.**

## SURFACE PREPARATION



Wash surface with 9-851 WaterBase 900+ Series Degreaser or mild detergent and water. Rinse with water and dry the surface. Wipe surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product flashes off. Final sanding if needed P400 if the complete panel will be primed. Spot repair/ local priming: final sanding with P500. Wipe surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product evaporates. Plastic surface preparation refer to the 1-60 1K Plastic Primer TDS for full details on the recommended preparation for plastic parts. Mask entire vehicle to eliminate unwanted overspray. After 48 hours thorough sanding with P400-500 is needed before the topcoat system can be applied.

**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

**In order to obtain the best result, we recommend the use of HS420 clears.**

**PHYSICAL DATA**

EU REGULATIONS		
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<b>Chemical Base</b>	2K Polyurethane Primer	
<b>Physical Properties</b>	<b>Viscosity (RTS)</b>	14 - 17 Dincup 4 / 20°C
	<b>Specific Gravity (kg/l)</b>	With M5 hardeners: 1.37 (Grey) With H5 hardeners: 1.39 (Grey) With H5420 hardeners: 1.38 (Grey)
	<b>Flash Point Closed Cup</b>	33°C / 91,4°F
	<b>Volume % Solids</b>	With M5 hardeners: 40 (Grey) With H5 hardeners: 43 (Grey) With H5420 hardeners: 42 (Grey)
	<b>Economy</b>	With M5 hardeners: 13 m <sup>2</sup> (Grey) With H5 hardeners: 14 m <sup>2</sup> (Grey) With H5420 hardeners: 14 m <sup>2</sup> (Grey) (with 30 µm layer thickness)
	<b>Gloss</b>	Egg Gloss
	<b>Colour</b>	Grey

**PROTECTION**


Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).

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