



BARE ALUMINIUM



PRODUCT

MIXING

APPLICATION

FLASH-OFF

BAKE

SURFACE PREPARATION



1-951 Silicone Remover

RFU

Wipe on Wipe off

N/A

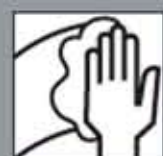
N/A

Clean substrate of all contaminates with 1-951 Silicone Remover.



Dry sand paper

Thoroughly sand substrate with P180



1-851 Anti-Static Degreaser

RFU

Wipe on Wipe off

N/A

N/A

Clean sanded substrate with 1-851 Anti-Static Degreaser prior to application of 1-17 Wash Primer



1-17 Wash Primer

1:1 with 1-12

1-2 coats

20 minutes

N/A

Recoat 1-17 wash primer with 8-145 HS Surfacer



8-145 HS Surfacer

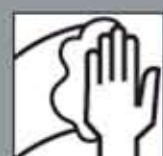
3:1 MS / 2K Hardener
4:1 HS Hardener
0-15% Uni-Thinner

2-3 coats

5-10 minutes

30 minutes

Sand surfacer with P220 > P320 > P400 for series 400
Sand surfacer with P220 > P320 > P500 for basecoat series 500



1-951 Silicone Remover

RFU

Wipe on Wipe Off

N/A

N/A

Clean sanded surface with 1-951 Silicone Remover



2000 Series BeroMix

2:1 MS Hardener
3:1 HS Hardener

2-3 coats

5-15 minutes

30 minutes

High gloss 2 Pac finish
Note: Use recommended ground colour if recommended in ICRIS



500 Series Berobase

1:1 with Uni-Thinner

2-3 coats
Achieve colour

10-15 minutes

N/A

Note: Use recommended ground colour if recommended in ICRIS



Option #1
MS Clearcoat 1-204

2:1 MS Hardener
0-10% Uni-Thinner

2 coats

8-10 minutes

20-30 minutes

Apply two full closed coats.
Note: Use only MS hardener



Option #2
HS Clearcoat 8-104

2:1 HS Hardener
0-5% Uni-Thinner

1.5-2 coats

5-10 minutes

20-40 minutes

2 coat application add thinner if required 5%
1 coat application apply 1 tack coat followed by full finish closed coat