



BARE STEEL



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 P120-P150



1-951 Silicone Remover

RFU

Wipe on Wipe off

N/A

N/A

Clean sanded substrate with 1-951 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
0-10% Uni-Thinner
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 surfacer with 1-951 Silicone Remover



2000 Series BeroMix

2:1 MS/2K Hardener
3:1 HS Hardener
0-10% Uni-Thinner

2-3 coats

5-15 minutes

30 minutes

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



500 Series Basecoat

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 Clear1-204

2:1 MS Hardener
0-10% Thinner

2 coats

8-10 minutes

20-30 minutes

Apply two full closed coats
Note: Use only MS hard



Option #2
HS 8-104

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

1.5-2

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