



SPRAY POLYESTER BARE STEEL/ALUMINIUM



PRODUCT

MIXING

APPLICATION

FLASH-OFF

BAKE

SURFACE PREPARATION



1-951 Silicone Remover

RFU

Wipe on Wipe off

N/A

N/A

Clean substrate with 1-951 Silicone Remover



Dry sand paper

Sand bare aluminium with P180
Sand bare steel with P120-P150



1-951 Silicone Remover

RFU

Wipe on Wipe off

N/A

N/A

Clean substrate with 1-951 Silicone Remover



1-17 Wash Primer

1:1 with 1-12
Activator

1-2 coats

15-20 minutes

N/A

Apply wash primer to bare substrate



8-145 HS Surfacer

3:1 MS / 2K Hardener
4:1 HS Hardener

2 coats

5-10 minutes

Apply 2 coats making sure surfacer is fully cured prior to sanding



Dry sand paper

Sand surfacer with P220-P240



1-951 Silicone Remover

RFU

Wipe on Wipe Off

N/A

Clean substrate with 1-951 Silicone Remover



1-980 Spray Polyester

Add 2% Hardener
by weight

1-3 coats

5-10 minutes

30 minutes

Add 0-5 % Thinner if necessary
2.0-2.5 gun required



Dry sand paper

Final sand spray polyester with P240



1-951 Silicone Remover

RFU

Wipe on Wipe Off

N/A

N/A

Clean Substrate with 1-951 Silicone Remover prior to application of HS Surfacer



8-145 HS Surfacer

2:1 MS Hardener
3:1 HS Hardener

1-3 coats

5-10 minutes

30 minutes

Apply surfacer: add required amount of thinner



Dry sand paper

Sand HS surfacer with P220 >P320 >P400 for 2000 Series 2K BeroMix
Sand Surfacer with P220 > P320 > P500 for 500 Series BeroBase



1-951 Silicone Remover

RFU

Wipe on Wipe Off

N/A

N/A

Clean substrate with 1-951 Silicone Remover



2000 Series 2K BeroMix

2:1 MS Hardener
3:1 HS Hardener

2-3 coats

10-12 minutes

30 minutes

High gloss 2 Pac Finish



500 Series BeroBase

1:1

2-3 coats
Achieve colour

15 minutes

N/A

Recoat with De Beer clear coat
Use ground coat if recommended



1-204 MS Clearcoat

2:1
MS Hardener

2 coats

8-10 minutes

30 minutes

Apply 2 full closed coats



8-104 HS Clear coat

2:1
HS Hardener

1.5-2 coats

5-10

20-40 minutes

1 coat application apply one tac coat followed by a finishing closed coat
2 coat application add thinner