



# BARE STEEL



Version 11.02

PRODUCT

MIXING

HARDENER

THINNER

SECONDS

SPRAY PRESSURE

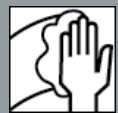
APPLICATION

FLASH OFF IN MINUTES

SURFACE PREPARATION

BAKE MIN @

REFINISH WITH



1-951 Silicone Remover	RFU	N/A	N/A	N/A	N/A	Wipe on wipe off	N/A	Clean Substrate with 1-951	N/A	N/A
P120 - P150 Sand	N/A	N/A	N/A	N/A	N/A	N/A	N/A	Sand Substrate with P120 - P150	N/A	1-17
1-951 Silicone Remover	RFU	N/A	N/A	N/A	N/A	Wipe on wipe off	N/A	Clean Substrate with 1-951	N/A	N/A
1-17 CF Wash Primer	1:1	1-12	N/A	18-20	2 Bar	1 Coat	20 Mins	N/A	N/A	8-145 8-149
Sanding Option 1 Tintable 8-149 HS	4 parts 3000 1 part 8-149	5:1 + 10% Use 8-40/8-50	1-141 1-151 1-161 1-171	20-22	2 Bar	1-3	5-10 Mins	Sand P400	30	3000/900
Sanding Option 2 HS Primer 8-145/10/40	4:1 up to 15% 6:1 up to 25%	8-140/8-150 8-40/8-50	1-141 1-151 1-161 1-171	20-22	2 Bar	1-3	15-20	Sand P400	30	3000/900
Non Sanding Option 1 Tintable 8-149	1 Part 8-149 1 Part 3000	3:1 + 25% Use 8-50/8-40	1-141 1-151 1-161 1-171	16-17	2 Bar	1 Coat	15-20	N/A	N/A	3000 Only Do not use under 900 Series
Non Sanding Option 2 HS Primer 8-145/10/40	4:1 + 30% 6:1 + 35%	8-150 8-50	1-141 1-151 1-161 1-171	16-17	2 Bar	1 Coat	15-20	N/A	N/A	3000/900
1-951 Silicone Remover	RFU	N/A	N/A	N/A	N/A	Wipe on wipe off	N/A	Clean Substrate with 1-951	N/A	3000
HS 3000 Series	2:1 + 15%	8-30 8-40 8-50	8-181 Special thinner	17-19	2-2.3 Bar	1-5 or 2 Coats 2 Coats	No Flash between coats 5-10 mins between coats	N/A	20-40	N/A
9-851 Water Cleaner	RFU	N/A	N/A	N/A	N/A	Wipe on wipe off	N/A	Clean substrate with 9-851	N/A	900
900 Series	Refer to Formula	N/A	9-151 Std 9-161 Slow	N/A	2 Bar 2 Bar 1 Bar	1 Dust coat 2 Wet on wet coats 1 Drop coat	Blowdry with Spray Gun Blowdry 6-10 mins 5 mins	P400 - P500	N/A	8-104 8-414 8-214
Option 1 8-104 HS Clear	2:1 + 0-10%	8-130 8-140 8-150 8-160	1-141 1-151 1-161 1-171	16-18	2-2.5 Bar	1.5 Coats 2 Coats	No flash between coats Flash 5-10 mins between coats	N/A	20-40	N/A
Option 2 8-414 HS 420 Clear Coat	3:1 up to 5%	8-430 8-440 8-450 8-460	1-141 1-151 1-161 1-171	19	2-2.5 Bar	1.5 Coats 2 Coats	No flash between coats Flash 5-10 mins between coats	N/A	20-35	N/A
Option 3 8-214 HS Scratch Resistant Clear Coat	2:1 + 0-10%	8-140 8-150 8-160	1-141 1-151 1-161 1-171	16-18	2-2.5 Bar	1.5 Coats 2 Coats	No flash between coats Flash 5-10 mins between coats	N/A	20-40	N/A



# ALUMINIUM



PRODUCT

MIXING



HARDENER



THINNER



SECONDS



PRESSURE



APPLICATION



FLASH OFF  
IN MINUTES



SURFACE  
PREPARATION



BAKE MIN @  
60 DEGREES



REFINISH WITH

Version 11.02



**1-951 Silicone Remover**

RFU

N/A

N/A

N/A

N/A

Wipe on wipe off

N/A

Clean Substrate  
with 1-951

N/A

N/A



**P180 Sand**

N/A

N/A

N/A

N/A

N/A

N/A

N/A

Sand Substrate  
with P180

N/A

1-17



**1-951 Silicone Remover**

RFU

N/A

N/A

N/A

N/A

Wipe on wipe off

N/A

Sand Substrate  
with P180

N/A

N/A



**9-851 WaterBase  
Degreaser**

RFU

N/A

N/A

N/A

N/A

Wipe on wipe off

N/A

Clean sanded  
substrate with  
1-951

N/A

N/A



**1-17 CF Wash Primer**

1:1

1-12

N/A

18-20

2 Bar

1 Coat

20 Mins

Do Not Sand

N/A

8-145  
8-149



*Sanding Option 1*  
**8-159 HS Tintable  
(Sanding)**

4 parts 3000  
1 part 8-149

5 parts mix  
1 part 8-40/8-50  
10% thinners

1-141  
1-151  
1-161  
1-171

20-22

2 Bar

1-3 Coats

5-10 Mins

Sand P400-P500

30

3000/900



*Sanding Option 2*  
**8-145 HS Primer  
(Sanding)**

4:1 up to 15%  
6:1 up to 25%

8-140/8-150  
8-40/8-50

1-141  
1-151  
1-161  
1-171

20-22

2 Bar

1-3 Coats

15-20

Sand use  
P400-P500

30

3000/900



*Non Sanding Option 1*  
**8-149 HS Tintable  
(Non Sanding)**

1 Part 8-149  
1 Part 3000

3:1 + 25%  
Use 8-50/8-40 Hards

1-141  
1-151  
1-161  
1-171

16-17

2 Bar

1 Coat

15-20

N/A

N/A

3000 Only  
Do not use under  
900 Series



*Non Sanding Option 2*  
**8-145/10/40 HS Primer  
(Non Sanding)**

4:1 + 30%  
6:1 + 35%

8-150  
8-50

1-141  
1-151  
1-161  
1-171

16-17

2 Bar

1 Coat

15-20

N/A

N/A

3000/900



**1-951  
Silicone Remover**

RFU

N/A

N/A

N/A

N/A

Wipe on wipe off

N/A

Clean Substrate  
with 1-951

N/A

3000



**3000 BeroThane  
HS 420**

2:1 + 15%

8-30  
8-40  
8-50

8-181  
Special  
thinner

17-19

2-2.3 Bar

1.5 Coats  
2 Coats

No Flash between coats  
5-10 mins between coats

N/A

20-40

N/A



**9-851 WaterBase**

RFU

N/A

N/A

N/A

N/A

Wipe on wipe off

N/A

Clean substrate  
with 9-851

N/A

N/A



**900 WaterBase**

Refer to  
Formula

N/A

9-151 Std  
9-161Slow

N/A

2 Bar  
2 Bar  
1 Bar

1 Dust coat  
2 Wet on wet coats  
1 Drop coat

Blowdry with Spray Gun  
Blowdry 6-10 mins  
5 mins (effect colours only)

Sand with  
P400 - P500

N/A

8-104  
8-414  
8-214



*Option 1*  
**8-104 HS Clear Coat**

2:1 up to 10%

8-130  
8-140  
8-150  
8-160

1-141  
1-151  
1-161  
1-171

16-18

2-2.5 Bar

1.5 Coats  
2 Coats

No flash between coats  
5-10 mins between coats

N/A

20-40

N/A



*Option 2*  
**8-414 HS 420 Clear Coat**

3:1 up to 5%

8-430  
8-440  
8-450  
8-460

1-141  
1-151  
1-161  
1-171

19

2-2.5 Bar

1.5 Coats  
2 Coats

No flash between coats  
5-10 mins between coats

N/A

20-35

N/A



*Option 3*  
**8-214 HS Scratch  
Resistant Clear Coat**

0 - 5%

8-140  
8-150  
8-160

1-141  
1-151  
1-161  
1-171

16-18

2-2.5 Bar

1.5 Coats  
2 Coats

No flash between coats  
5-10 mins between coats

N/A

20-40

N/A



# BARE STEEL / ALUMINIUM



Version 11.02

PRODUCT

MIXING

HARDENER

THINNER

PRESSURE

APPLICATION

FLASH-OFF

BAKE

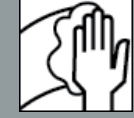
SURFACE PREPARATION



**1-951 Silicone Remover** RFU N/A N/A N/A Wipe on wipe off N/A N/A Clean Substrate with 1-951 Silicone Remover



**Dry Sand Paper** N/A N/A N/A N/A N/A Sand Bare Aluminum with P180  
Sand Bare Steel with P120-P150



**1-951 Silicone Remover** RFU N/A N/A N/A Wipe on wipe off N/A N/A Clean Substrate with 1-951 Silicone Remover



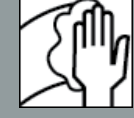
**1-17 CF Wash Primer** 1:1 1-12 N/A 2 Bar 1 Coat 20 Mins N/A Apply wash primer to bare substrate



**8-145 HS Surfacer (Sanding)** 4:1 up to 15% 8-140/8-150 1-141 2 Bar 2 Coats 5-10 Mins 30 Apply 2 coats making sure surfacer is fully cured prior to sanding  
6:1 up to 25% 8-40/8-50 1-151  
1-161  
1-171



**Dry Sand Paper** RFU N/A N/A N/A N/A Sand surfacer with P220-P240



**1-951 Silicone Remover** N/A N/A N/A N/A Wipe on wipe off N/A N/A Clean Substrate with 1-951 Silicone Remover



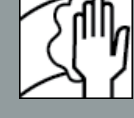
**8-145 HS Surfacer (Non Sanding)** 4:1 up to 30% 8-140/8-150 1-141 2 Bar 1 Coat 15-20 Mins N/A Add required amount of thinner  
6:1 up to 35% 8-40/8-50 1-151  
1-161  
1-171



**1-951 Silicone Remover** RFU N/A N/A N/A Wipe on wipe off N/A N/A Clean Substrate with 1-951 Silicone Remover



**3000 BeroThane HS 420** 2:1 + 15% 8-30 8-181 2-2.3 Bar 1-5 Coats No flash Between Coats 20-40 Mins High gloss finish  
8-40 8-50 Special Thinner 2 Coats 5-10 Between Coats



**9-851 Water Cleaner** RFU N/A N/A N/A N/A N/A N/A



**900 WaterBase** Refer to Formula N/A 9-151 Std 2 Bar 1 Dust Coat Blowdry with spray gun  
9-161 Slow 2 Bar 2 Wet on wet coats Blow dry 6-10 Mins  
1 Bar 1 Drop Coat 5 Mins N/A N/A



**8-104 HS Clear Coat** 2:1 up to 10% 8-130 1-141 2 Bar 1.5 Coats No flash between coats 20-40 Mins N/A  
8-140 1-151 2 Coats 5-10 mins between coats  
8-150 1-161  
1-171



**8-414 HS 420 Clear Coat** 3:1 up to 5% 8-130 1-141 2 Bar 1.5 Coats No flash between coats 20-35 Mins N/A  
8-140 1-151 2 Coats 5-10 mins between coats  
8-150 1-161  
1-171



# PRODUCT USE GUIDE



**PRODUCT**  
Version 11.02



MIXING



HARDENER



THINNER



SECONDS



PRESSURE



COATS



FLASH OFF  
IN MINUTES



BAKE MIN @  
60 DEGREES



REFINISH  
WITH

PRODUCT	MIXING	HARDENER	THINNER	SECONDS	PRESSURE	COATS	FLASH OFF IN MINUTES	BAKE MIN @ 60 DEGREES	REFINISH WITH
1-15 Washprimer	1:1	1-10	N/A	18-20	2 Bar	1-2	3-10	N/A	All primers except epoxy
1-17 Washprimer	1:1	1-12	N/A	18-20	2 Bar	1-2	5-10	N/A	All primers except epoxy
1-185 1K Primer	4:1	N/A	1-141 1-151 1-161 1-171	17-18	2 Bar	1-3	5-7	15-20	900/3000
Sanding Option 1-75 10/20 Epoxy	2:1 + 20%	1-7040 1-70	1-151 1-161 1-171	17-19	2 Bar	2-4	40	60	900/3000
Non Sanding Option 1-75 10/20 Epoxy	2:1 + 30%	1-7040 1-70	1-151 1-161 1-171	17-19	2 Bar	1	45	N/A	900/3000
1-60 Plastic Primer	RFU	N/A	N/A	15-17	2 Bar	1	5	N/A	900/3000
Sanding Option 1 High Build 8-145/10/40	4:1 up to 15% 6:1 up to 25%	8-150 8-50	1-141 1-151 1-161 1-171	20-22	2 Bar	1-3	5-10	20-30	900/3000
Sanding Option 2 Tintable 8-149	4 parts 8-149 1 part 3000	5 Parts mix 1 part 8-40/8-50 + 10%	1-141 1-151 1-161 1-171	20-22	2 Bar	1-3	5-10	20-30	900/3000
Non Sanding Option 2 High Build 8-145/10/40	4:1 + 30% 6:1 + 35%	8-150 8-50	1-141 1-151 1-161 1-171	16-17	2 Bar	1	15-20	N/A	900/3000
Non Sanding Option 2 Tintable 8-149	1 Part mixed 3000 1 Part 8-149	3:1 + 0-25% Use 8-50/8-40	1-141 1-151 1-161 1-171	16-17	2 Bar	1	15-20	N/A	3000 Do not use under 900 series
900 Series Waterbase	Refer to formula	N/A	9-151 Std 9-161 Slow	N/A	2 Bar 2 Bar 1 Bar	1 Dust Coat 2 Wet on wet coats 1 Drop coat (only effect colours)	Blow dry with spray gun Blowdry 6-10 mins 5 Mins	N/A	8-104 8-414 8-214
900 Series Engine Bay	Mixed Colour 200 Grams 200 Grams	Hardener 8-150 19.5 grams 8-450 12.5 grams	Co-binder 40 grams 40 grams	N/A	1.5-2 Bar	Medium coats	Blow dry as normal	N/A	N/A
3000 Series BeroThane	2:1 + 15%	8-30 8-40 8-50	8-181 Special Thinner	17-19	2-2.3 Bar	1.5 2	No Flash Between Coats Flash 5-10 mins between coats	20/40	N/A
8-414 HS 420 Clearcoat	3:1 up to 5%	8-430 8-440 8-450 8-460	1-141 1-151 1-161 1-171	19	2-2.5 Bar	1.5 2	No Flash Between Coats Flash 5-10 mins between coats	20-35	N/A
8-140 HS Clear Coat	2:1 + up to 10%	8-130 8-140 8-150 8-160	1-141 1-151 1-161 1-171	16-18	2-2.5 Bar	1.5 2	No Flash Between Coats Flash 5-10 mins between coats	20-40	N/A
8-214 HS Scratch Resistant Clear Coat	2:1 + 0-5%	8-130 8-140 8-150 8-160	1-141 1-151 1-161 1-171	16-18	2-2.5 Bar	1.5 2	No Flash Between Coats Flash 5-10 mins between coats	20-40	N/A
1-105 Matt Clear	2:1	47-35 47-55 47-65	N/A	16-18	2-2.5 Bar	2	20	30	N/A



# WET ON WET - 3000 SERIES



PRODUCT MIXING HARDENER THINNER SECONDS PRESSURE APPLICATION FLASH-OFF IN MINUTES SURFACE PREPARATION NOTES BAKE MIN@ 60 PANEL TEMP REFINISH WITH



<b>1-951 Silicone Remover</b>	RFU	N/A	N/A	N/A	N/A	N/A	Wipe on wipe off	N/A	Clean substrate with 1-951	N/A	N/A	N/A
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<b>P320-P400</b>	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	Sand substrate with P320-P400	N/A	N/A	1-185 8-145
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<b>1-951 Silicone Remover</b>	RFU	N/A	N/A	N/A	N/A	N/A	Wipe on wipe off	N/A	Clean substrate with 1-951	N/A	N/A	8-149 8-145 3000
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<b>Option 1 8-149 HS Tintable (Non Sanding)</b>	1 Part colour 3000 1 part 8-149	3:1 + 0-25% use 8-50	1-151 1-161 1-171	17-18	2 Bar	1 Coat	15-20	Sand P320	Any large bare metal areas use 1-15 or 1-17 first	N/A	N/A	3000
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<b>Option 2 8-145 HS Primer (Non Sanding)</b>	6:1 + 35%	8-50	1-151 1-161 1-171	16-17	2 Bar	1 Coat	15-20	Sand P320	Any large bare metal areas use 1-15 or 1-17 first	N/A	N/A	3000
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<b>HS 3000 Series</b>	2:1 + 15%	8-30 8-40 8-50	8-181 Special thinner	17-19	2-2.3 Bar	1.5 2	No Flash Between Coats Flash 10 mins between coats	N/A	N/A	20-40	N/A	N/A
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<b>HS Taping Additive 30-69</b>	2:1 + 15%	8-30 8-40 8-50	30-69 Taping additive	17-19	2-2.3 Bar	1.5 2	No Flash Between Coats Flash 5 mins	N/A	Air dry. Can be taped at 20°C after 8-30 2 Hours 8-40 5 hours 8-50 12 hours	10 Only	N/A	N/A
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Version 11.02



# WET ON WET - 900 SERIES



MIXING



HARDENER



THINNER



SPRAY PRESSURE



APPLICATION



FLASH OFF IN MINUTES



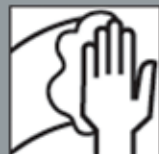
SURFACE PREPARATION



BAKE MIN @ 60 PANEL TEMP



REFINISH WITH



**1-951 Silicone Remover**

RFU

N/A

N/A

N/A

Wipe on wipe off

N/A

Clean substrate with 1-951

N/A

N/A

N/A



**P320-P400**

N/A

N/A

N/A

N/A

N/A

N/A

Sand substrate with P320-P400

N/A

N/A

8-145  
1-145



**1-951 Silicone Remover**

RFU

N/A

N/A

N/A

Wipe on wipe off

N/A

Clean substrate with 1-951

N/A

N/A

N/A



**Option 1  
8-185 1K Primer**

4:1

N/A

1-141  
1-151  
1-161  
1-171

2 Bar

1-3 Coats

5-7

Sand P320 use on new oem panels

Any large bare metal areas use 1-15 or 1-17 first

N/A

900



**Option 2  
Non sanding  
HS Primer  
8-145/10/40**

4:1 + 30%  
6:1 + 35%

8-150  
8-50

1-141  
1-151  
1-161  
1-171

2 Bar

1 Coat

15-20

Sand use P320

Any large bare metal areas use 1-15 or 1-17 first

N/A

900



**900 Series**

Refer to formula

N/A

9-151 Std  
9-161 Slow

2 Bar  
2 Bar  
1 Bar

1 Dust Coat  
2 Wet on wet coats  
1 Drop coat (only effect colours)

Blow dry with spray gun  
Blowdry 6-10 mins  
5 Mins

N/A

Increased temp will speed up drying  
Apply even not too wet  
Only Apply dropcoat to effect colours

N/A

8-104  
8-414  
8-214



**Option 1  
8-104  
HS Clear**

2:1 up to 10%

8-130  
8-140  
8-150  
8-160

1-141  
1-151  
1-161  
1-171

2-2.5

1.5

No Flash  
Between Coats

Flash 5-10 mins  
between coats

N/A

N/A

20-40

N/A



**Option 2  
8-414 HS 420  
Clear Coat**

3:1 up to 5%

8-430  
8-440  
8-450  
8-460

1-141  
1-151  
1-161  
1-171

2-2.5

1.5

No Flash  
Between Coats

Flash 5-10 mins  
between coats

N/A

N/A

25-35

N/A



**Option 3  
8-214 Scratch  
Resistant  
Clear Coat**

2:1 + 0.5%

8-140  
8-150  
8-160

1-141  
1-151  
1-161  
1-171

2-2.5

1.5

No Flash  
Between Coats

Flash 5-10 mins  
between coats

N/A

Polish within 48 hours

20-40

N/A

## SUBSTRATE

## SAND PAPER GRADE

## DRY SANDING PROCESS

Removal of Old Paint

P80 - P180 - P320



Clean substrate of all contamination

Bare Steel

P80 - P150



Apply guide coat to substrate

Reducing deep scratching  
in bare metal

P120 - P240



Sand substrate with hand block using P240

Aluminium

P180 - P280

Clean surface after first sand ensuring surface is free of dust and dirt.  
Recommended to clean with 1-951 silicone remover to remove all  
dust from scratch marksEcoat to be prepared for  
wet on wet process

P320 - P400



Apply guide coat to substrate

Stainless steel

P280 - P320

Sand with P320. Use interface pad  
Use osculating finishing sander (3.0mm orbit)

Spray Polyester

P120 - P220 - P320

3000 Series final preparation after primer.  
Sand with P400 to topcoat with hs 3000 Series. Use interface pad.  
Use osculating finishing sander (3.0mm orbit)  
Final clean with 1-951 before paint

Polyester Filler

P80 - P180 - P280

900 Series final preparation after primer.  
Sand with P500 to topcoat with 900 Series, use inetrface pad.  
Final clean with 1-951 water cleaner

Paint Edges

P220 - P320

HS Surfacer/final sand for  
topcoat HS 3000 Series

P220 - P320 - P400 final sand with interface pad

HS Surfacer/final sand for  
topcoat 900 Series

P220 - P320 - P500 final sand with interface pad

Prepare panels  
for blendingGrey scotch bright  
or P800/P1000 used on machine with  
3.0mm osculating action