

GENERAL INFORMATION

30-746 HS Non-Sanding Filler Grey is especially developed for commercial vehicles, coaches, trucks and machinery. With outstanding leveling properties.

MIXING RATIO



5 : 1 Filler : HS420 Hardener + 20% Uni Thinner

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,4-1,6	2/29
HE	1,4-1,6	1,8-2,0/26-29

APPLICATION



1-2 coat 30 - 50 µm (1,2-2,0 mil)

FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	20 minutes	Flash off	20 minutes	
Dust free	-	Dust free	-	
Dry to handle	15 minutes	Dry to handle	30 minutes	
Dry to tape	15 minutes	Dry to tape	30 minutes	
Dry to sand	15 minutes	Dry to sand	30 minutes	
Dry to polish	-	Dry to polish	-	



SUBSTRATES



30-746 HS Non-Sanding Filler Grey should only be applied over well sanded/scuffed and degreased primed bare steel and primed aluminium. Well sanded GRP, polyester fillers, OEM primer and old paint systems in good condition. (Use on bare metal always 1-15 Washprimer for maximum durability and rust protection.)

Plastic primer for plastics.

POT LIFE AT 20°C / 68°F



45 - 60 minutes

COMPONENTS



8-450 HS420 Hardener Medium
 1-141 Uni Thinner Fast
 1-151 Uni Thinner Medium
 1-161 Uni Thinner Slow 47-91 Spot Repair Thinner
 1-231 Fade-Out Thinner

ADDITIVES



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SURFACE PREPARATION



Good preparation is vital in order to obtain the best possible result. 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 and GRP P400.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



MM 900 - 9999 WaterBase 900[®] Series
 MM 3000 - 3046 BeroThane HS420 3000 Series.

PHYSICAL DATA

EU REGULATIONS			
VOC Code	2004/42/IIIB(c)(540)591B)		
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/L. (2007) This product contains a maximum of 518 g/L VOC.		
Chemical Base	2K Polyurethane Primer		
Physical Properties	Viscosity (RT5)	16 Dincup 4 / 20°C	
	Specific Gravity (kg/l)	1,497	
	Flash Point Closed Cup	30°C / 86°F	
	Volume % Solids	49,3	
	Economy	16 m ² /L/30 µm	
		650 ft ² /Gal/1.2 mil	
	Gloss	Matt	
Colour	Grey / Black		

PROTECTION

Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).



For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.de-beer.com/en/debeer/choose_localization

CLEAN UP



1-051 Gun Cleaner

STORAGE/SHELF LIFE

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



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