8-867 Allround Surfacer Grey

GENERAL INFORMATION

8-867 Allround Surfacer Grey can be used for small to large repair work over multiple automotive substrates. It can be applied directly on e-Coat primed parts and does not require an additional guide coat due to its glossy appearance after drying.

This TDS is about the Sanding version.

MIXING RATIO



3:1Surfacer: MS Hardener + max 5% Uni Thinner 7: 2 Surfacer: HS Hardener + max 5% Uni Thinner

6:1 Surfacer: HS420 Hardener + max 15% Uni Thinner

POTLIFE



POTLIFE (+3 SEC/ DIN CUP 4 @ 20C)		
MS hardeners	25 - 30 min	
HS hardeners	20 - 25 min	
HS420 hardeners	18 - 22 min	

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,4-1,6	2/29
HE	1,4-1,6	1,6-2,0/23-29

COMPONENTS



47-35 MS Hardener Fast 47-55 MS Hardener Medium 47-65 MS Hardener Slow 8-130 HS Hardener Very Fast 8-140 HS Hardener Fast 8-150 HS Hardener Medium

8-160 HS Hardener Slow 8-430 HS420 Hardener Very Fast

8-440 HS420 Hardener Fast 8-450 HS420 Hardener Medium 8-460 HS420 Hardener Slow

1-141 Uni Thinner Fast

1-151 Uni Thinner Medium

1-161 Uni Thinner Slow

APPLICATION



2 - 3 coat 60-180 µm

ADDITIVES



47-39 2K Elastic

Check TDS of 47-39. Add before hardener.

FLASH OFF AND DRY TIMES





SUBSTRATES

	AIR DRY 20°C / 68°F	FORCED DRY 40°C / 104°F	FORCED DRY 60°C / 140°F
Flash off	10 - 15 minutes	10 - 15 minutes	10 - 15 minutes
Dust free	-	-	-
Dry to handle	-	-	-
Dry to tape	-	-	-
Dry to sand	1.5 - 4 hours	45 - 60 minutes	20 - 30 minutes
Dry to polish	-	-	-

8-867 Allround Surfacer Grey should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium. Well sanded and degreased GRP, polyester fillers and old paint systems in good condition. Well cleaned and degreased non-sanded OEM primer. On bare steel and aluminium use 1-15 Washprimer

for maximum durability and rust protection.

DRY TIMES AND DISTANCE IR



	FLASH TIME	Half-bake	Full-bake
Maximum 3 coats	5 minutes	8 minutes	7 minutes
ON PLASTIC	FLASH TIME	Half-bake	Full-bake

Follow the IR equipment recommendations for optimal distance between object and IR-lamps

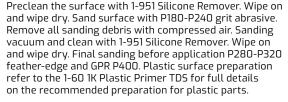
SUBSTRATES PLASTIC



Substrate	8-867 Sanding
ABS	It has good direct to ABS adhesion, no need to use the 1-60 1K Plastic Primer.
PP	It is possible to replace the thinner with the 1-60 1K Plastic Primer. It is also possible to spray the 1-60 1K Plastic Primer first.
PP/EPDM	It is possible to replace the thinner with the 1-60 1K Plastic Primer. It is also possible to spray the 1-60 1K Plastic Primer first.

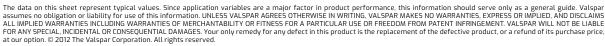
SURFACE PREPARATION







Mask entire vehicle to eliminate unwanted overspray.





8-867Allround Surfacer Grey

NEXT LAYER



MM 900 - 9999 WaterBase 900° Series MM 3000 - 3046 BeroThane HS420 3000 Series MM 500 - 5999 BeroBase 500 Series MM 2000 - 2099 BeroMix 2000 Series

PHYSICAL DATA

EU REGULATIONS			
VOC Code		2004/42/IIB(c)(540)540	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		IIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 540 g/l VOC.	
Chemical Base	2K Polyurethane Primer		
Viscosity (RTS)		15 - 19 Dincup 4 / 20°C	
	Specific Gravity (kg/l)	With MS hardeners: 1,39 (Grey) With HS hardeners: 1,42 (Grey) With HS420 hardeners: 1,42 (Grey)	
	Flash Point Closed Cup	33°C / 91,4°F	
Physical Properties	Volume % Solids	With MS hardeners: 42 (Grey) With HS hardeners: 45 (Grey) With HS420 hardeners: 45 (Grey)	
	Economy	With MS hardeners: 7 m² (Grey) With HS hardeners: 8 m² (Grey) With HS420 hardeners: 8 m² (Grey) (with 60 µm layer thickness)	
	Gloss	Egg Gloss	
	Colour	Grey	

PROTECTION



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).

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

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

CLEANUP



1-051 Gun Cleaner

STORAGE/SHELF LIFE



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

NOTES



The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. UNLESS VALSPAR AGREES OTHERWISE IN WRITING, VALSPAR MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. VALSPAR WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES. Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option. © 2012 The Valspar Corporation. All rights reserved.



8-867 Allround Surfacer Grey

GENERAL INFORMATION

8-867 Allround Surfacer Grey can be used for small to large repair work over multiple automotive substrates. It can be applied directly on e-Coat primed parts and does not require an additional guide coat due to its glossy appearance after drying.

This TDS is about the Non-Sanding version.

MIXING RATIO



3:1 Surfacer: MS Hardener + max 10% Uni Thinner 7:2 Surfacer: HS Hardener + max 10% Uni Thinner

6:1Surfacer: HS420 Hardener + max 25% Uni Thinner

POTLIFE



POTLIFE (+3 SEC/ DIN CUP 4 @ 20C)		
MS hardeners	40 -45 min	
HS hardeners	30 - 35 min	
HS420 hardeners	37 - 45 min	

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	2/29
HE	1,3-1,4	1,8-2,0/26-29

APPLICATION



1 coat 25 - 40 µm

COMPONENTS



47-55 MS Hardener Medium 47-65 MS Hardener Slow 8-150 HS Hardener Medium 8-160 HS Hardener Slow 8-450 HS420 Hardener Medium 8-460 HS420 Hardener Slow 1-151 Uni Thinner Medium 1-161 Uni Thinner Slow

FLASH OFF AND DRY TIMES







Overspray window 15 minutes till 48 hours

ADDITIVES



Properly cleaned un-sanded OEM e-Coat panels. Properly

1-15 Washprimer. Bare metal not exceeding 10 cm² (1-15

If the gelcoat of the Glass Fibre Reinforced Polyester is broken through to the fibres, do NOT use 8-867 Allround Surfacer Grey.



Check TDS of 47-39. Add before hardener.

SUBSTRATES



cleaned and sanded original OEM paint system. Properly cleaned and sanded Glass Fibre Reinforced Polyester laminates.

Washprimer recommended).

SURFACE PREPARATION

47-39 2K Elastic



Wash surface with 9-851 WaterBase 900+ Series Degreaser or mild detergent and water. Rinse with water and dry the surface. Wipe surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product flashes off. Final sanding if needed P400 if the complete panel will be primed. Spot repair/ local priming: final sanding with P500. Wipe surface with 1-951 Silicone Remover and wipe dry with a clean cloth before the product evaporates. Plastic surface preparation refer to the 1-60 1K Plastic Primer TDS for full details on the recommended preparation for plastic parts. Mask entire vehicle to eliminate unwanted overspray. After 48 hours thorough sanding with P400-500 is needed before the topcoat system can be applied.

Mask entire vehicle to eliminate unwanted overspray.

SUBSTRATES PLASTIC



Substrate	8-867 Non-Sanding
ABS	It has good direct to ABS adhesion, no need to use the 1-60 1K Plastic Primer.
PP	It has good direct to PP adhesion, no need to use the 1-60 1K Plastic Primer.
PP/EPDM	It is possible to replace the thinner with the 1-60 1K Plastic Primer. It is also possible to spray the 1-60 1K Plastic Primer first.

NEXT LAYER



MM 900 - 9999 WaterBase 900+ Series MM 3000 - 3046 BeroThane HS420 3000 Series MM 500 - 5999 BeroBase 500 Series

In order to obtain the best result, we recommend the use of HS420 clears.



PHYSICAL DATA

EU REGULATIONS			
VOC Code		2004/42/IIB(c)(540)540	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		IIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 540 g/l VOC.	
Chemical Base	2K Polyurethane Primer		
	Viscosity (RTS)	14 - 17 Dincup 4 / 20°C	
	Specific Gravity (kg/l)	With MS hardeners: 1,37 (Grey) With HS hardeners: 1,39 (Grey) With HS420 hardeners: 1,38 (Grey)	
	Flash Point Closed Cup	33°C / 91,4°F	
Physical Properties	Volume % Solids	With MS hardeners: 40 (Grey) With HS hardeners: 43 (Grey) With HS420 hardeners: 42 (Grey)	
	Economy	With MS hardeners: 13 m² (Grey) With HS hardeners: 14 m² (Grey) With HS420 hardeners: 14 m² (Grey) (with 30 µm layer thickness)	
	Gloss	Egg Gloss	
	Colour	Grey	

PROTECTION



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).

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

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CLEANUP



1-051 Gun Cleaner

STORAGE/SHELF LIFE



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NOTES



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