

GENERAL INFORMATION

1-231 Fade-Out Thinner is designed to fade out 2K top coats, clear coats and 2K wet on wet primer filler on a fade-out area, when partially priming a panel. It creates a smooth transition into the existing finish, so polishing is minimized with top coats. As the ratio between pressure and material inside the canister is adjusted optimally, the product's fast flash off allows for excellent edge wetting during the fade-out process.

MIXING RATIO



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GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	-	-
HE	-	-

APPLICATION



Please see page 2.

FLASH OFF AND DRY TIMES



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



SUBSTRATES



All correctly prepared and applied top coats and clear coats.

POT LIFE AT 20°C / 68°F



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COMPONENTS



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ADDITIVES



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SURFACE PREPARATION



Prepare blending area by intensive cleaning with 1-951 Silicone Remover. Polish the entire area to remove all imperfection & machine sand around the blend area with P2000-3000. Degrease thoroughly with 1-951 Silicone Remover. After pretreatment do not touch with bare hands.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER

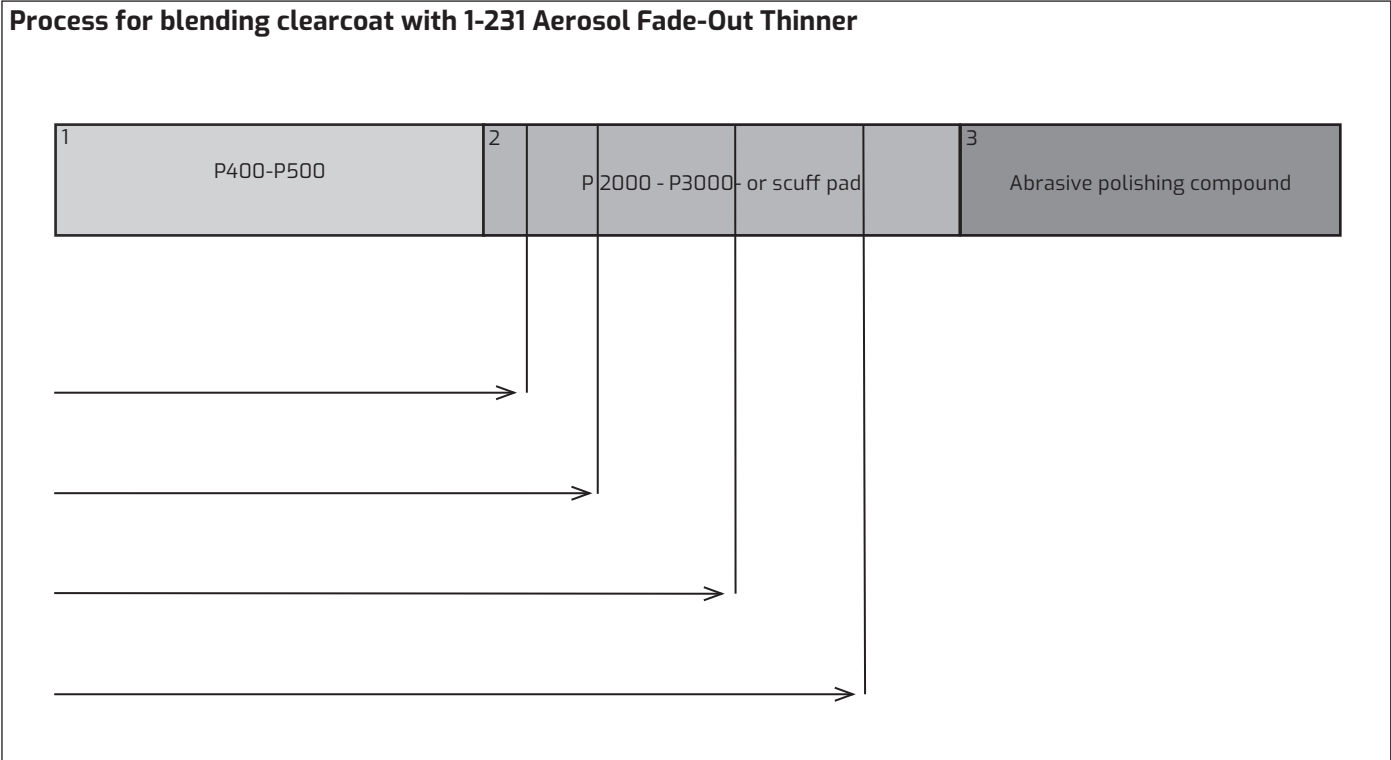


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PHYSICAL DATA

EU REGULATIONS		
VOC Code	2004/42/IB(e)(840)723	
Product sub category (according directive 2004/42/ EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIB/e. Special finishes - All types. EU limit values: 840 g/l. (2007).	
Chemical Base	Mix of organic solvents	
Physical Properties	Viscosity (RT5)	-
	Specific Gravity (kg/l)	0,714
	Flash Point Closed Cup	-41 °C / -41,8°F
	Volume % Solids	0,2
	Economy	-
	Gloss	High Gloss
	Colour	-

The below process describes a typical fading of the edge of clearcoat where the clearcoat can not be painted to a hard edge and clearcoat edge blending is required, this describes the part of the process directly after applying and drying the basecoat.



As you will see in the above diagram, there are three areas:

Area 1. treated with P400-P500,

Area 2. P2000 or P3000 or Scuff pad and

Area 3. a coarse abrasive compounded area (all sanded or scuffed areas) must well sanded and a matt appearance)



Step one: Clearcoat is applied over basecoated area to finish slightly beyond P400 and or P500 scratch pattern.



Step two: Without flash off of the seconded application of clearcoat, fully wet the entire clearcoat edge with the 1-231 aerosol fade out carrying part way into P2000/ P3000/ scuff pad scratch pattern.



Step three: Repeat step two slightly further into P2000/ P3000/ scuff pad scratch pattern.



Step four: Repeat step three (if needed) slightly further into P2000/ P3000/ scuff pad scratch pattern to finish.



Step five: Drying, ensure the clearcoat is fully cured and cooled down before the next step.



Step six: Polishing, if working in a small area, normally a hand polish with compound and polishing cloth will be all that is needed, on lager areas a machine polish with compound maybe needed.

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



NOTES

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