



# P 334 4:1 HS PRIMER

Technical Data Sheet No 102

Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter (#340 Plastofix)

VOC compliant with the regulations

2K Acrylic system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties even on plastic bumpers

## General Technical Description



Mix 4:1 with H 725 HARDENER FOR PRIMERS

Thinner addition 15 - 20%  
BODY 740 ACRYLIC THINNER NORMAL  
BODY 741 ACRYLIC THINNER SLOW

Oven force drying – 20-30 min  
60°C panel temperature

Air dry 2 - 3h /23°C



IR drying 8-12 min  
distance 60-70 cm

## Surface

On old, sanded paint work

Unsanded cataphoresis OEM panels (E-COAT)

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body 960 Wash Primer

P 961 Etch Filling Primer

Over new and used plastic bumpers

## Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and BODY 770 ANTISIL NORMAL / BODY 771 ANTISIL FAST.

Make sure the surface is air dried rather than wiped dry



Make sure you always use appropriate face protection and good ventilation

## Product Application: As an HS sanding primer

2 passes »» Apply one coat, and after the 15 min flash off time apply the second full coat.



4:1 mix with H 725 HARDENER FOR PRIMERS  
Pot life: 50 - 60 min @ 23°C (73°F)



Non force dry  
2 - 3h / 23°C  
20-30 min / 60-65°C panel temperature



Addition 15-20% of thinner.  
Use BODY 740 NORMAL ACRYLIC THINNER / 741 SLOW ACRYLIC THINNER



Short wave 8 – 12 min  
distance 60-70 cm



Ready to spray:  
26 -32 s  
DIN 4 @ 20°C



P 400 - P 500  
Flat bed sander



Compliant Spray gun 1.5mm – 1.8 mm  
3-4 bar inlet pressure  
2x coats = 100 - 120 micron



P 600 – P 1000  
Sanding by hand, wet



HVLP 1.5mm - 1.7 mm  
2 bar atomization pressure  
2x coats = 100 - 120 micron



2K Autoemail Acrylic Paint SR  
HB BODY Basecoat  
HB BODY Clears



Always wear protective equipment



10 min / 23°C  
Final flash off time



Follow the application instructions mentioned in this TDS

**2K paint systems tend to react with water, hence all the equipment used must be moisture free. Isocyanates may cause skin sensitization. More specifically, care should be taken when handling the material. Anyone with a history of histaminic conditions, or respiratory problems should consult the doctor first.**

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## Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.)

2 passes »» Apply one coat, and after the 15 min flash off time apply the second full coat.



Dry sanding  
P 180 - P 220  
(never with a scotch brite)



5 -10 min / 23°C  
Final flash off time



Clean substrate using a soft cloth and BODY 770 ANTISIL NORMAL / BODY 771 ANTISIL FAST.



Non force dry  
1 - 2h / 23°C

Make sure the surface is air dried rather than wiped dry



Make sure you always use appropriate face protection and good ventilation



P 400 – P 500  
Flat bed sander



4:1 mix with H725  
HARDENER FOR PRIMERS  
Pot life: 55-70 min @23°C (73°F)



P 600 – P 1000  
Sanding by hand, wet



Addition 50 - 60% of thinner.  
Use BODY 740 NORMAL ACRYLIC THINNER / 741 SLOW ACRYLIC THINNER



2K Autoemail Acrylic Paint SR  
HB BODY Basecoat  
HB BODY Clears



Ready to spray:  
14 - 16 s  
DIN 4 @ 20°C



Always wear protective equipment



Compliant Spray gun  
1.3 - 1.4 mm  
3-4 bar inlet pressure  
2 - 3 coats = 60 - 80 micron



Follow the application instructions mentioned in this TDS



HVLP Spray gun  
1.4 mm  
2 bar inlet pressure  
2 - 3 coats = 60 - 80 micron

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## Product Application: As "wet on wet" primer

1 pass »» Apply 1 coat of (20-30µm) and 20-30 minutes after the application we can paint and clear coat as usual.



4:1 mix with H 729  
HARDENER for  
PRIMERS NORMAL  
Pot life: 30 -45 min  
@23°C (73°F)



20 - 30 min / 23°C  
Final flash off time

**Flash Point:**  
27°C / 80°F

**Specific Gravity:**  
1.48 g/cm<sup>3</sup>

**Solid Content (No thinner):**  
73% Weight

**VOC (2004/42/EC)**  
This is a special refinish product  
based on its ingredients and  
its properties. The maximum  
VOC content in this category  
is 540 g/L. The VOC content in  
the ready for use form of this  
product is 460 g/L.  
2004/42/II(c)(540)460

**Theoretical Coverage:**  
5 - 6 m<sup>2</sup> / l at 120 micron dry film  
thickness

**Cleaning of equipment:**  
Clean after final use with  
Body 740 ACRYL NORMAL

### Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and solvents
- It can be used by countries that do not adopt the VOC legislation as well.
- Do not use at temperatures below 15°C.
- Do not apply the primer as 'wet on wet' on TPA surfaces

### Caution:

Always check with a cloth and thinner if the panel is an OEM (E-COAT) panel. On OEM (E-COAT) panels, the cloth stays clean. Then clean the surface with #770 ANTISIL and the "wet on wet" procedure is followed without sanding prior to BODY P 334 application.

### Storage Shelf life:

- Store in a cool place (+5 to 25°C) and use within 12 months for best results.
- Guaranteed shelf life of 24 months in unused original containers



Addition 50 -60% of  
thinner. Use BODY 740  
NORMAL ACRYLIC  
THINNER / 741 SLOW  
ACRYLIC THINNER



2K Autoemail Acrylic  
Paint SR  
HB BODY Basecoat  
HB BODY Clears



Ready to spray:  
14 - 16 s  
DIN 4 @ 20°C



Always wear  
protective equipment



Compliant Spray gun  
1.3mm – 1.4mm  
3-4 bar inlet pressure  
1 coat = 20-30 micron



Follow the application  
instructions mentioned  
in this TDS

### Notes:

**A.** On a "wet on wet" application  
H 729 hardener must be used  
(never H 725).

**B.** Never apply "wet on wet"  
over polyester fillers due to the  
fact that can be seen after clear  
coating.



HVLP 1.4mm  
2 bar inlet pressure  
1 coat = 20-30 micron

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