

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



Short wave 8 – 12 min distance 60-70 cm



P 400 - P 500 Flat bed sander



P 600 – P 1000 Sanding by hand, wet



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



Always wear protective equipment



Follow the application instructions mentioned in this TDS



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



Ready to spray: 26 -32 s DIN 4 @ 20°C



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



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



10 min / 23°C Final flash off time

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)



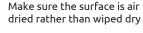
5 -10 min / 23°C Final flash off time



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



Non force dry 1 - 2h / 23°C





Make sure 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.



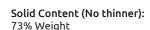
4:1 mix with H 729 HARDENER for PRIMERS NORMAL Pot life: 30 -45 min @23°C (73°F)

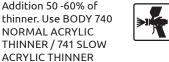


20 - 30 min / 23°C Final flash off time



Specific Gravity: 1.48 g/cm3





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



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/IIB(c)(540)460



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



Always wear protective equipment

Follow the application

instructions mentioned



5 - 6 m² / l at 120 micron dry film thickness



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

HVLP 1.4mm

2 bar inlet pressure

1 coat = 20-30 micron

Notes:

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

in this TDS

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

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

- 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

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