



BODY 989 4:1 EPOXY PRIMER SURFACER

Technical Data Sheet No 119

VOC compliant with the regulations

Suitable for over old paints, non sanded bare metal, aluminum, stainless steel and zinc surfaces

Excellent sealing, adhesion and filling abilities

Resistant to extreme weather conditions

Excellent 2K high performance Epoxy Primer with anticorrosive properties

General Technical Description



Mix 100 parts BODY 989 with 25 parts BODY EPOXY HARDENER 732 / 25 parts ACRYL 740 THINNER

Oven force drying
1h / 80°C (176°F) panel temperature

Air dry 8 - 14 h / 23°C (73°F)



IR drying 10-15 min
distance 60-70 cm

Surface

Aluminium Surfaces

Stainless Steel

Galvanised Surfaces

Non sanded bare metal

Over old pant work

Pretreatment / Cleaning of substrate



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

Make sure the surface is first wiped dry and then air dried.



Make sure you always use appropriate face protection and good ventilation

Product Application: A 2K Epoxy Primer

2 passes »» Apply a thin layer and after 15 min flash off time apply the second coat.



Mix 100 parts BODY 989 with 25 parts BODY EPOXYHARDENER 732 / 25 parts ACRYL 740 THINNER
Pot life: 24 h @ 23°C (73°F)



Non force dry
80 - 120µm (3.2 - 4.7 mil)
8 - 14 h / 23°C (73°F)
1h / 80°C panel temperature



Addition 25% of thinner.
Use BODY 775 EPOXY THINNER / BODY ACRYL 740 THINNER



P 320 – P 400
With random orbital sander



Ready to spray:
28-32 s
DIN 4 @ 20°C (68°F)



P 320 – P 1000
Sanding by hand, wet



Compliant Spray gun 1.5 – 1.8 mm
2-3 bar (29 - 44 psi) inlet pressure
2x coats = 80-120µm (3.2 - 4.7 mil)



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



HVLP Spray gun 1.5 – 1.7 mm
2 bar (29 psi) inlet pressure
2x coats = 80-120µm (3.2 - 4.7 mil)



Always wear
protective equipment



15 min / 23°C (73°F)
Final flash off time



Follow the application instructions
mentioned in this TDS



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Product Application: "wet on wet"

»» Apply two thin coats.



4:1 mix with BODY 989
EPOXY HARDENER



Non force dry
2-3h min / 23°C (73°F)
8h max

Flash Point:
13°C / 55°F

Specific Gravity:
1.6 g/cm³

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature



Addition 40-50% of
thinner. Use BODY 775
EPOXY THINNER



Always wear
protective equipment

Solid Content (No thinner):
74% Weight

- Application only with the recommended hardeners and solvents

VOC (2004/42/EC)

This product 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 380 g/L.
2004/42/IIB(c)(540)380

- It can be used by countries that do not adopt the VOC legislation as well.



Ready to spray:
20-22 s
DIN 4 @ 20°C (68°F)



Follow the application
instructions
mentioned in this TDS

Theoretical Coverage:

6-7 m² / l at 100 micron (4mil) dry film thickness

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 634 and BODY 635 application.



Compliant Spray gun
1.3mm – 1.4mm
2-3 bar (29 - 44 psi)
inlet pressure
2 coats = 40-50 µm
(1.6-2.0mil)



HVLP 1.3mm-1.4mm
2 bar 2 (29 psi)
atomization pressure



5-10 min / 23°C (73°F)

Storage Shelf life:

- Store in a cool place +5°C - +25°C (41-77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.

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