



TECHNICAL DATA SHEET No 119

P 989 4:1 EPOXY PRIMER

GENERAL TECHNICAL DESCRIPTION

Excellent, high performance 2K Epoxy Primer with anticorrosive properties
 Excellent sealing, adhesion and filling properties
 Resistant to extreme weather conditions

SURFACE

Aluminium
 Stainless Steel
 Galvanised Surfaces
 Non sanded bare metal
 Over old paint work

PRETREATMENT/CLEANING OF SUBSTRATE



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

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

PRODUCT APPLICATION: As 2K Epoxy Primer



Mix 4 parts PRIMER with 1 part H732 EPOXY HARDENER
 Pot life: 24 h / 23°C (73°F)



Addition 25% of 775 EPOXY or 740 ACRYL NORMAL THINNER / REDUCER



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



Compliant spray gun
 1.5 - 1.8 mm
 2 - 2.5 bar (29 - 36 psi)
 2x coats = 80 - 120 µm (3.2 - 4.7 mil)



1.5 - 1.7 mm
 1.5 - 2 bar (22 - 29 psi)
 2x coats = 80 - 120 µm (3.2 - 4.7 mil)



15 min / 23°C (73°F)
 Flash off time



8 - 14 h / 23°C (73°F)
 1 h / 60°C (140°F)
 panel temperature



P 320 - P 400



P 320 - P 1000
 Sanding by hand, wet



It can be painted over with all HB BODY Mix Systems.
 It can be painted over without sanding after 2 - 3 h from its application and until 8h max.

PRODUCT APPLICATION: "Wet on Wet"

Apply two thin coats. See in remarks for important notice on OEM panel treatment



Mix 4 parts PRIMER with 1 part H732 EPOXY HARDENER



Addition 40 - 50% of 775 EPOXY THINNER / REDUCER



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



Compliant spray gun
 1.3 - 1.4 mm
 2 - 2.5 bar (29 - 36 psi)
 2x coats = 40 - 50 µm (1.6 - 2 mil)



1.3 - 1.4 mm
 1.5 - 1.2 bar (22 - 29 psi)
 2x coats = 40 - 50 µm (1.6 - 2 mil)



5 - 10 min / 23°C (73°F)
 Final flash-off time
 min. 2 - 3 h / 23°C (73°F)
 max. 8 h



It can be painted over with all HB BODY Mix Systems

FLASH POINT

13°C / 55°F

SPECIFIC GRAVITY1.54 g/cm³**SOLID CONTENT****(NO THINNER)**

74% 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 540 g/L.
2004/42/II(c)(540)540

THEORETICAL COVERAGE6 - 7 m² / l at 100 micron (4 mil) dry film thickness**CLEANING OF EQUIPMENT**

Clean after final use with 740 ACRYL NORMAL / 775 EPOXY thinner / reducer

REMARKS

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and thinners / reducers
- Do not use at temperatures below 15°C (59°F)

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 NORMAL DEGREASER and the "Wet on Wet" procedure is followed without sanding

STORAGE SHELF LIFE

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



Always wear protective equipment



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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