



989 4:1 EPOXY PRIMER

Technical Data Sheet No 119

General Technical Description

Excellent, high performance 2K Epoxy Primer with anticorrosive properties

Excellent sealing, adhesion and filling properties

Resistant to extreme weather conditions

VOC compliant with the regulations

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

Apply one coat and after 15 min flash off time apply the second coat.



4:1 mix with 989 EPOXY HARDENER
Pot life: 24 h @ 23°C (73°F)



15 min / 23°C (73°F)
Flash off time



Addition 25% of thinner / reducer
Use BODY 775 EPOXY or 740 ACRYL NORMAL THINNER / REDUCER



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



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



P 320 – P 400
With random orbital sander



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



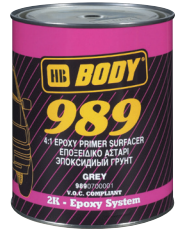
P 320 – P 1000
Sanding by hand, wet



HVLP Spray gun
1.5 – 1.7 mm
1.5 - 2 bar (22 - 29psi) inlet pressure
2x coats = 80 - 120µm (3.2 - 4.7 mil)



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



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Product Application: "Wet on Wet"

Apply two thin coats.

See in remarks for important notice on OEM panel treatment.



4:1 mix with 989 EPOXY HARDENER



HVLP Spray gun
1.3mm - 1.4mm
1.5 - 2 bar (22 - 29psi) inlet pressure
2 coats = 40 - 50 µm (1.6-2.0mil)



Addition 40 - 50% of 775 EPOXY THINNER / REDUCER



5-10 min / 23°C (73°F)



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

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



Compliant Spray gun
1.3mm - 1.4mm
2 - 2.5 bar (29 - 36 psi) inlet pressure
2 coats = 40 - 50 µm (1.6 - 2.0mil)



It can be painted over with all HB BODY Mix Systems

Flash Point:

13°C / 55°F

Specific Gravity:

1.54 g/cm³

Solid Content (No thinner):

74% Weight

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

Theoretical Coverage:

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

Cleaning of equipment:

Clean after final use with 740 ACRYL NORMAL THINNER / REDUCER, 775 EPOXY THINNER

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

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