

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 989 EPOXY HARDENER / 25 parts BODY ACRYL 740 THINNER

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

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 989 EPOXY HARDENER / 25 parts BODY ACRYL 740 THINNER Pot life: 24 h @ 23°C (73°F)



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



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



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)



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



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



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



P 320 – P 400 With random orbital sander



P 320 – P 1000 Sanding by hand, wet



- HB BODY Color Solutions Basecoat
- HB BODY Color Solutions 2K
- HB BODY Clears



Always wear protective equipment



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

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 **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 (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 and the "wet on wet" procedure is followed without sanding prior to BODY 634 and BODY 635 application.

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.

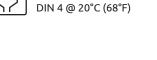


Addition 40-50% of thinner, Use BODY 775 EPOXY THINNER



• HB BODY Color Solutions Basecoat • HB BODY Color Solutions 2K





Ready to spray:

20-22 5



2-3 bar (29 - 44 psi) inlet pressure 2 coats = 40-50 µm (1.6-2.0mil)



Always wear protective equipment



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



Follow the application instructions mentioned in this TDS



5-10 min / 23°C (73°F)

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