



P 334 4:1 HS FILLING PRIMER

Technical Data Sheet No 102

2K Acrylic system sanding primer

Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter (#340 Plastofix)

Excellent filling properties

Excellent mechanical properties even on plastic bumpers

Easy to sand

VOC compliant with the regulations

General Technical Description



Mix 4:1 with H 725 HARDENER FOR PRIMERS

Thinner / Reducer addition 15 - 20% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



20-30 min / 60°C (140°F) panel temperature
2 - 3h / 23°C (73°F)



8-12 min distance 60-70 cm

Surface

On old, sanded paint work

Unsanded cathaphoresis OEM panels (E-COAT)

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body Wash Primer

P961 Etch Primer

Over new and used plastic bumpers

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



Make sure you always use appropriate face protection and good ventilation

Product Application: As a HS sanding primer

2 passes »» Apply one coat, and after 10 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)



2 - 3h / 23°C (73°F)
20-30 min / 60-65°C (140-149°F) panel temperature



Addition 15-20% of thinner / reducer
Use 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Short wave 8 - 12 min distance 60-70 cm



Ready to spray:
26 -32 s
DIN 4 @ 20°C (68°F)



P 400 - P 500
Flat bed sander



Compliant Spray gun
1.5mm - 1.8 mm
2 - 2.5 bar (29 - 36 psi) inlet pressure
2x coats = 100-120 µm (3.9-4.7mil)



P 600 - P 1000
Sanding by hand, wet



HVLP Spray gun
1.5mm - 1.7 mm
1.5 - 2 bar (22 - 29psi)
2x coats = 100-120 µm (3.9-4.7mil)



It can be painted over with
HB BODY Color Solutions Basecoat Mix System
HB BODY Color Solutions 2K Acrylic Mix System
HB BODY Color Solutions Aquabase Mix System



10 min / 23°C (73°F)
Flash off time



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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Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.)
 2 passes »» Apply one coat, and after 10 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 (73°F)
 Final flash off time



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



1 - 2h / 23°C (73°F)

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



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 / reducer.
 Use 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



It can be painted over with HB BODY Color Solutions Basecoat Mix System
 HB BODY Color Solutions 2K Acrylic Mix System
 HB BODY Color Solutions Aquabase Mix System



Ready to spray:
 14 - 16 s
 DIN 4 @ 20°C (68°F)



Compliant Spray gun
 1.3 - 1.4 mm
 2 - 2.5 bar (29 - 36 psi) inlet pressure
 2 - 3 coats = 60 - 80 micron (2.4-3.2mil)



Always wear protective equipment



Compliant Spray gun
 1.3 - 1.4 mm
 1.5 - 2 bar (22 - 29psi) inlet pressure
 2 - 3 coats = 60 - 80 micron (2.4-3.2mil)



Follow the application instructions mentioned in this TDS

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Product Application: As a "wet on wet" primer

1 pass »» Apply 1 coat of (20-30µm) - 0.8-1.2mil and 20-30 minutes after application use paint and clearcoat as usual.



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



20 - 30 min / (73°F)
Final flash off time

Flash Point:
27°C / 80°F

Specific Gravity:
1.48 g/cm³

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and thinners / reducers
- 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)
- Do not apply the primer as 'wet on wet' on TPA surfaces



Addition 50 -60% of
thinner / reducer. Use
740 ACRYL NORMAL
or 741 ACRYL SLOW
THINNER / REDUCER.



It can be painted over with
HB BODY Color Solutions
Basecoat Mix System
HB BODY Color Solutions
2K Acrylic Mix System
HB BODY Color Solutions
Aquabase Mix System

Solid Content (No thinner):
73% 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 460 g/L.
2004/42/IIIB(c)(540)460

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.



Ready to spray:
14 - 16 s
DIN 4 @ 20°C (68°F)



Always wear
protective equipment

Theoretical Coverage:
5 - 6 m² / l at 120 micron (4.7mil)
dry film thickness

Cleaning of equipment:
Clean after final use with
740 ACRYL NORMAL THINNER /
REDUCER

Storage Shelf life:

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



Compliant Spray gun
1.3mm – 1.4mm
2 - 2.5 bar (29 - 36 psi)
inlet pressure
1 coat = 20-30 micron
(0.8-1.2mil)



Follow the application
instructions mentioned
in this TDS

Notes:

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

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



HVLP Spray gun
1.3mm – 1.4mm
1.5 - 2 bar (22 - 29psi)
inlet pressure
1 coat = 20-30 micron
(0.8-1.2mil)

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