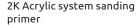


P 334 4:1 HS FILLING PRIMER

Technical Data Sheet No 102



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 cataphoresis 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



Short wave 8 - 12 min distance 60-70 cm



P 400 - P 500 Flat bed sander



P 600 - P 1000 Sanding by hand, wet



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



Always wear protective equipment



Follow the application instructions mentioned in this TDS



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



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



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)



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



10 min / 23°C(73°F) Flash off time

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

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



1 - 2h / 23°C (73°F)



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



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



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



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

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: 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)



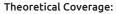
20 - 30 min / (73°F) Final flash off time Flash Point: 27°C / 80°F



Solid Content (No thinner): 73% Weight



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/IIB(c)(540)460



 $5 - 6 \text{ m}^2 / \text{l}$ at 120 micron (4.7mil) dry film thickness

Cleaning of equipment: Clean after final use with

740 ACRYL NORMAL 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
- 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

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.

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

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

Ready to spray:

DIN 4 @ 20°C (68°F)

Compliant Spray gun

2 - 2.5 bar (29 - 36 psi)

1 coat = 20-30 micron

1.3mm - 1.4mm

inlet pressure

(0.8-1.2mil)

14 - 16 s



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



Always wear protective equipment



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)

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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