



P 411 4:1:1 WET ON WET PRIMER

Technical Data Sheet No 122

General Technical Description

High performance acrylic sealing primer, specially designed for wet-on-wet application.

For treatment of new parts before painting.

Excellent adhesion on brand new surfaces without sanding.

It is applied at a 4:1:1 ratio (primer:hardener:thinner).

VOC compliant with the regulations

Product Application: Wet on wet primer 1 coat. Apply one coat as "wet on wet" on metallic surfaces



4:1 mix with H 729 HARDENER FOR PRIMERS NORMAL
Pot life: 60-80min @ 23°C (73°F)



20 - 30 min / 23°C (73°F)
Final flash off time
Time depending on film thickness

Flash Point:
28°C / 82°F

Specific Gravity:
1.16 g/cm³



Addition 25% of thinner / reducer. Use 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



20-30 min can be recoated wet on wet with HB BODY Color Solutions Basecoat Mix System
HB BODY Color Solutions 2K Acrylic Mix System
HB BODY Color Solutions Aqua Basecoat Mix System

Solid Content (No thinner):
56% 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 780 g/L. The VOC content in ready for use form of this product is 630 g/L.
2004/42/IIB(c)(780)630



Ready to spray:
16-18sec
DIN 4 @ 20°C (68°F)



Compliant Spray gun
1.3 - 1.4 mm
2 - 2.5 bar (29 - 36psi)
inlet pressure
1x coat = 15-25µm (0.6-1.0mil)



Always wear protective equipment

Theoretical Coverage:
8 m² / l at 15 micron (0.6mil)
dry film thickness



HVLP
1.3 - 1.4 mm
1.5 - 2 bar (22 - 29psi)
inlet pressure
1x coat = 15 - 25µm (0.6-1.0mil)



Follow the application instructions mentioned in this TDS

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

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

For surfaces that are not OEM or E-Coated, first abrade slightly with P600-P800 wet

Remarks:

- Application only with the recommended hardeners and thinners / reducers
- The primed surface can be overcoated within a maximum of 3 days without sanding, provided it is kept under appropriate temperature and environmental conditions. After this period the surface should be fully sanded and well cleaned before applying the top coat
- 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)
- Not recommended to be applied as wet on wet over Body Wash Primers or P961 Etch Primer

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 Primer 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.

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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High performance acrylic sealing primer, specially designed for wet-on-wet application.

For treatment of new parts before painting.

Excellent adhesion on brand new surfaces, without sanding.

It is applied at a 4:1:1 ratio (primer:hardener:plastofix).

VOC compliant with the regulations

Product Application: Application on plastic bumper and parts 1 coat. Apply one coat on plastic surfaces



4:1 mix with H 729 HARDENER FOR PRIMERS NORMAL
Pot life: 60-80min @ 23°C (73°F)



20 - 30 min / 23°C (73°F)
Final flash off time
Time depending on film thickness

Flash Point:
28°C / 82°F

Specific Gravity:
1.16 g/cm³



Addition 25% of 340 PLASTOFIX instead of thinner/reducer



20-30 min can be recoated wet on wet with
HB BODY Color Solutions Basecoat Mix System
HB BODY Color Solutions 2K Acrylic Mix System
HB BODY Color Solutions Aqua Basecoat Mix System

Solid Content (No thinner):
56% Weight

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Ready to spray:
16-18sec
DIN 4 @ 20°C (68°F)



Always wear protective equipment

Theoretical Coverage:
8 m² / l at 15 micron (0.6mil) dry film thickness



Compliant Spray gun
1.3 - 1.4 mm
2 - 2.5 bar (29 - 36psi) inlet pressure
1x coat = 15-25µm (0.6-1.0mil)



Follow the application instructions mentioned in this TDS

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



HVLP
1.3 - 1.4 mm
1.5 - 2 bar (22 - 29psi) inlet pressure
1x coat = 15-25µm (0.6-1.0mil)



Pretreatment / Cleaning of substrate



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

It is recommended to abrade with P600-P800 plastics of unknown origin and PE

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

Remarks:

- Application only with the recommended hardeners and thinners / reducers
- The primed surface can be overcoated within a maximum of 3 days without sanding, provided it is kept under appropriate temperature and environmental conditions.
- 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)
- Not recommended to be applied as wet on wet over Body Wash Primers or P961 Etch Primer

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