



P 981 1K EPOXY PRIMER

Technical Data Sheet No 131

1K epoxy primer with very good adhesion to all metal substrates like stainless steel, aluminium, OEM, galvanized.

VOC compliant with the regulations

Excellent mechanical properties

Adhesion promoter to metallic surfaces

General Technical Description



Mix 2:1 with BODY 740 ACRYL NORMAL / BODY 741 ACRYLIC SLOW

1 - 2 passes

Surface

Aluminium

Stainless Steel

Galvanized

OEM

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: As a HS sanding primer

1 - 2 passes »» Apply in thin layers over light sanded areas



2:1 mix with BODY 740 ACRYL NORMAL / BODY 741 ACRYL SLOW



P 320 - P 500
Random orbital sander

Flash Point:
11°C / 52°F

Specific Gravity:
1.32 g / cm³

Solid Content (No thinner):
66% 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 the ready for use form of this product is 650 g/L.
2004/42/IIB(c)(780)650

Theoretical Coverage:
7 - 8 m² / l at 40 micron (1.6mil) 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).

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



Ready to spray:
25 - 32 s
DIN 4 @ 20°C (68°F)



P 600 - P 1000
Flat bed sander



Compliant Spray gun
1.5mm - 1.7 mm
2-3 bar (29-44psi)
inlet pressure
1 - 2x coats = 20 - 40 µm (0.8-1.6mil)



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



HVLP 1.5 - 1.7 mm
2 bar (29 psi)
inlet pressure
1 - 2x coats = 20 - 40 µm (0.8-1.6mil)



Always wear protective equipment



5 - 10 min / 23°C (73°F)
Final flash off time



Follow the application instructions mentioned in this TDS



Non Force dry
20 min / 23°C (73°F)
Full hardness within 12 hours

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