

# P 981 1K EPOXY PRIMER

Technical Data Sheet No 131

1K epoxy primer with adhesion

stainless steel, aluminium, OEM,

Adhesion promoter to metallic

Excellent mechanical properties

VOC compliant with the

to all metal substrates like

galvanized.

regulations

surfaces



## General Technical Description



Mix 2:1 with 740 ACRYL NORMAL or 741 **ACRYL SLOW THINNER** 

# Surface

Aluminium

Stainless Steel

Galvanized

OEM

### 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



Remarks:

Make sure you always use appropriate face protection and good ventilation

Allow for additional time for

· Application only with the

recommended hardeners and

• It can be used by countries that do not adopt the VOC

• Do not use at temperatures

desired temperature

combi spray booths to reach the



/ REDUCER

Product Application: As a HS sanding primer 1 - 2 passes ">>> Apply in thin layers over light sanded areas



2:1 mix with 740 ACRYL NORMAL / 741 ACRYL SLOW THINNER / REDUCER

Ready to spray:



P 320 - P 500 Random orbital sander

P 600 - P 1000

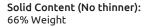
Flat bed sander

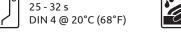
Alwavs wear

Flash Point: 11°C / 52°F

Specific Gravity:







Compliant Spray gun

2 - 2.5 bar (29 - 36 psi)

1 - 2x coats = 20 - 40 µm

1.5mm - 1.8 mm

inlet pressure

(0.8-1.6mil)



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

### 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:

containers

7 - 8 m<sup>2</sup> / l at 40 micron (1.6mil) dry film thickness

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



HVLP 1.5 - 1.7 mm 1.5 - 2 bar (22 - 29 psi) inlet pressure 1 - 2x coats = 20 - 40 µm (0.8-1.6mil)



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



Follow the application instructions mentioned in this TDS

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

below 15°C (59°F).

legislation as well

thinners / 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

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