



989 4:1 EPOXY PRIMER SURFACER

Technical Data Sheet No 119

Excellent 2K high performance Epoxy Primer with anticorrosive properties

Suitable for over old paints, non sanded bare metal, aluminum, stainless steel and zinc surfaces

Excellent sealing, adhesion and filling abilities

Resistant to extreme weather conditions

VOC compliant with the regulations

General Technical Description



Mix 100 parts 989 with 25 parts 989 EPOXY HARDENER / 25 parts 740 ACRYL NORMAL



1h / 60°C (140°F) panel temperature
8 - 14 h / 23°C (73°F)



10-15 min distance 60-70 cm

Surface

Aluminium Surfaces

Stainless Steel

Galvanised Surfaces

Non sanded bare metal

Over old paint work

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: A 2K Epoxy Primer

2 passes »» Apply one coat and after 15 min flash off time apply the second coat.



Mix 100 parts BODY 989 with 25 parts 989 EPOXY HARDENER / Pot life: 24 h @ 23°C (73°F)



80 - 120µm (3.2 - 4.7 mil)
8 - 14 h / 23°C (73°F)
1h / 60°C (140°F) panel temperature



Addition 25% of thinner / reducer
Use BODY 775 EPOXY or 740 ACRYL NORMAL THINNER / REDUCER



P 320 – P 400
With random orbital sander



Ready to spray:
28-32 s
DIN 4 @ 20°C (68°F)



P 320 – P 1000
Sanding by hand, wet



Compliant Spray gun 1.5 – 1.8 mm
2 - 2.5 bar (29 - 36 psi) inlet pressure
2x coats = 80-120µm (3.2 - 4.7 mil)



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



HVLP Spray gun 1.5 – 1.7 mm
1.5 - 2 bar (22-29psi) inlet pressure
2x coats = 80-120µm (3.2 - 4.7 mil)



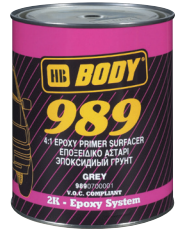
Always wear protective equipment



15 min / 23°C (73°F)
Flash off time



Follow the application instructions mentioned in this TDS



989 4:1 EPOXY PRIMER SURFACER

Technical Data Sheet No 119

Product Application: "wet on wet" »» Apply two thin coats.



4:1 mix with 989
EPOXY HARDENER



2-3h min / 23°C (73°F)
8h max

Flash Point:
13°C / 55°F

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature

Specific Gravity:
1.6 g/cm³

Solid Content (No thinner):
74% Weight

- Application only with the recommended hardeners and thinners / reducers



Addition 40-50% of
775 EPOXY 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

VOC (2004/42/EC)

This product 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 380 g/L.
2004/42/II B(c)(540)380

- It can be used by countries that do not adopt the VOC legislation as well.



Ready to spray:
20-22 s
DIN 4 @ 20°C (68°F)



Always wear
protective equipment

Theoretical Coverage:

6-7 m² / l at 100 micron (4mil)
dry film thickness

- Do not use at temperatures below 15°C (59°F).

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.



Compliant Spray gun
1.3mm – 1.4mm
2 - 2.5 bar (29 - 36 psi)
inlet pressure
2 coats = 40-50 µm
(1.6-2.0mil)

Cleaning of equipment:

Clean after final use with
740 ACRYL NORMAL THINNER /
REDUCER

Storage Shelf life:

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



HVLP 1.3mm-1.4mm
1.5 - 2 bar (22-29psi)
atomization pressure
2 coats = 40-50 µm
(1.6-2.0mil)



Follow the application
instructions
mentioned in this TDS



5-10 min / 23°C (73°F)

For professional use only. The information displayed on this sheet has been carefully selected through a series of laboratory investigations. It is based on our best knowledge at the time of issue. The data is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check for newer updates or further information if needed for his intended purpose. 1K ACRYLIC MAT PRODUCT intellectual property of this product, trademarks and copyrights is protected. All rights reserved. The relevant Material Safety Data Sheet and warnings displayed on the label must be read carefully. We may modify and / or discontinue operation of all or portions of this information at any time in our sole discretion, without any notice and assume no responsibility to update the information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

Issue 9 / 2019, October 2019