



TECHNICAL DATA SHEET No 122

P 411 4:1:1 WET ON WET PRIMER

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)

SURFACE

Brand new OEM parts
Cataphoresis OEM panels (E-COAT)
OEM brand new plastic parts (except PE)

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

PRODUCT APPLICATION: Wet on wet primer

Apply one coat as "wet on wet" on metallic surfaces



Mix 4 parts PRIMER with 1 part H 729 HARDENER FOR PRIMERS NORMAL
Pot life: 60 - 80 min / 23°C (73°F)



Addition 25% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



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



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



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



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



20 - 30 min can be recoated wet on wet with any HB BODY Mix System

PRODUCT APPLICATION: On plastic bumpers and parts

Apply one coat on plastic surfaces



Mix 4 parts PRIMER with 1 part H 729 HARDENER FOR PRIMERS NORMAL
Pot life: 60 - 80 min / 23°C (73°F)



Addition 25% 340 PLASTOFIX instead of thinner / reducer



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



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



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



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Final flash off time
Time depending on film thickness



20 - 30 min can be recoated wet on wet with any HB BODY Mix System

FLASH POINT

28°C / 82°F

SPECIFIC GRAVITY1.16 g/cm³**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 the ready for use form of this product is 780 g/L.

2004/42/IIIB(c)(780)780

THEORETICAL COVERAGE

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

CLEANING OF EQUIPMENT

Clean after final use with 740 ACRYL
NORMAL thinner / reducer

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



Always wear protective equipment



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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NOVEMBER 2021