



# P 981 1K EPOXY PRIMER

Technical Data Sheet No 131

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

Adhesion promoter to metallic surfaces

Excellent mechanical properties

VOC compliant with the regulations

## General Technical Description



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

## 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



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 740 ACRYL NORMAL / 741 ACRYL SLOW THINNER / REDUCER



P 320 - P 500 Random orbital sander

**Flash Point:**  
11°C / 52°F

### Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and thinners / reducer
- 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).



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



P 600 - P 1000 Flat bed sander

**Specific Gravity:**  
1.32 g / cm<sup>3</sup>

**Solid Content (No thinner):**  
66% Weight



Compliant Spray gun  
1.5mm - 1.8 mm  
2 - 2.5 bar (29 - 36 psi) inlet pressure  
1 - 2x coats = 20 - 40 µm (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/II(B)(c)(780)650

### 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



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)



Always wear protective equipment

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



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



Follow the application instructions mentioned in this TDS

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



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

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