



P 334 4:1 HS PRIMER

Technical Data Sheet No 102

Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter (#340 Plastofix)

VOC compliant with the regulations

2K Acrylic system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties even on plastic bumpers

General Technical Description



Mix 4:1 with
H 725 HARDENER
FOR PRIMERS

Thinner addition 15 - 20%
BODY 740 ACRYLIC THINNER
NORMAL
BODY 741 ACRYLIC THINNER
SLOW

Oven force drying 20-30 min/
60°C (140°F) panel temperature

Air dry 2 - 3h / 23°C (73°F)



IR drying 8-12 min
distance 60-70 cm

Surface

On old, sanded paint work

Unsanded cathaphoresis OEM
panels (E-COAT)

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body 960 Wash Primer

P 961 Etch Filling Primer

Over new and used plastic
bumpers

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

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



4:1 mix with H 725
HARDENER FOR PRIMERS
Pot life: 50 - 60 min @ 23°C (73°F)



Non force dry
2 - 3h / 23°C (73°F)
20-30 min / 60-65°C (140-149°F) panel temperature



Addition 15-20% of thinner.
Use BODY 740 NORMAL ACRYLIC THINNER /
741 SLOW ACRYLIC THINNER



Short wave 8 - 12 min
distance 60-70 cm



Ready to spray:
26 -32 s
DIN 4 @ 20°C (68°F)



P 400 - P 500
Flat bed sander



Compliant Spray gun 1.5mm - 1.8 mm
2-3 bar (29-44psi) inlet pressure
2x coats = 100-120 µm (3.9-4.7mil)



P 600 - P 1000
Sanding by hand, wet



HVLP 1.5mm - 1.7 mm
2 bar (29psi) atomization pressure
2x coats = 100-120 µm (3.9-4.7mil)



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



Always wear protective equipment



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



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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Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.)

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



Dry sanding
P 180 - P 220
(never with a scotch brite)



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



Clean substrate using a soft cloth and BODY 770 ANTISIL NORMAL / BODY 771 ANTISIL FAST.



Non force dry
1 - 2h / 23°C (73°F)

Make sure the surface is first wiped dry and then air dried



Make sure you always use appropriate face protection and good ventilation



P 400 – P 500
Flat bed sander



4:1 mix with
H725 HARDENER
FOR PRIMERS
Pot life: 55-70 min
@23°C (73°F)



P 600 – P 1000
Sanding by hand, wet



Addition 50 - 60% of thinner.
Use BODY 740 NORMAL
ACRYLIC THINNER / 741
SLOW ACRYLIC THINNER



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



Ready to spray:
14 - 16 s
DIN 4 @ 20°C (68°F)



Always wear protective equipment



Compliant Spray gun
1.3 - 1.4 mm
2-3 bar(29-44psi)
inlet pressure
2 - 3 coats = 60 - 80 micron
(2.4-3.2mil)



Follow the application instructions mentioned in this TDS



HVLP Spray gun
1.4 mm
2 bar (29psi)
inlet pressure
2 - 3 coats = 60 - 80 micron
(2.4-3.2mil)

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Product Application: As a "wet on wet" primer

1 pass »» Apply 1 coat of (20-30µm) - 0.8-1.2mil and 20-30 minutes after the application we can paint and clear coat as usual.



4:1 mix with
H 729 HARDENER for
PRIMERS NORMAL
Pot life: 30 -45 min
@23°C (73°F)



20 - 30 min / (73°F)
Final flash off time

Flash Point:
27°C / 80°F

Specific Gravity:
1.48 g/cm³

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)
- Do not apply the primer as 'wet on wet' on TPA surfaces



Addition 50 -60% of
thinner. Use BODY 740
NORMAL ACRYLIC
THINNER / 741 SLOW
ACRYLIC THINNER



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

Solid Content (No thinner):
73% 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 540 g/L. The VOC content in the ready for use form of this product is 460 g/L.
2004/42/II(c)(540)460

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 BODY P 334 application.



Ready to spray:
14 - 16 s
DIN 4 @ 20°C (68°F)



Always wear
protective equipment

Theoretical Coverage:
5 - 6 m² / l at 120 micron (4.7mil)
dry film thickness

Cleaning of equipment:
Clean after final use with
Body 740 ACRYL NORMAL

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



Compliant Spray gun
1.3mm – 1.4mm
2-3 bar(29-44psi)
inlet pressure
1 coat = 20-30 micron
(0.8-1.2mil)



Follow the application
instructions mentioned
in this TDS

Notes:

- On a "wet on wet" application H 729 hardener must be used (never H 725).
- Never apply "wet on wet" over polyester fillers due to the fact that can be seen after clear coating.



HVLP 1.4mm
2 bar (29 psi)
inlet pressure
1 coat = 20-30 micron
(0.8-1.2mil)

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