



P 411 4:1:1 WET ON WET PRIMER

Technical Data Sheet No 122

VOC compliant with the regulations

No need to sand.

Excellent adhesion on brand new surfaces.

General Technical Description



Mix 4 parts P 411 WET ON WET PRIMER with 1 part H 729 HARDENER NORMAL

Thinner addition 25%:
• BODY 740 ACRYL NORMALTHINNER / BODY 741 ACRYL SLOW THINNER

Surface

OEM surfaces

BRAND NEW UNSANDED PARTS

CATAPHORESIS OEM PANELS (E-COATS)

PLASTIC BUMPERS & PARTS

Pretreatment / Cleaning of substrate



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

For WET on Wet application on BUMPERS ABRASE SLIGHTLY WITH P600-P800 WET.

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: Wet on wet primer 1 pass »» Apply one coat as "wet on wet"



4:1 mix with H 729 HARDENER NORMAL
Pot life: 60-80min @ 23°C (73°F)



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



Addition 25% of thinner. Use 740 NORMAL / 741 SLOW THINNER



Non force dry
20-30 min can be recoated wet on wet with basecoat + clearcoat or 2K PUR paint



Ready to spray:
16-18sec
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
1x coat = 15-25µm (0.6-1.0mil)



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



HVLP
1.4 mm
2 bar (29psi)
inlet pressure
1x coat = 15-25µm (0.6-1.0mil)



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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Issue 9 / 2018, June 2018



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Mix 4 parts P 411 WET ON WET PRIMER with 1 part H 729 HARDENER NORMAL



Unsanded plastic parts. Addition 25% of 340 PLASTOFIX instead of thinner.

Surface

PLASTIC BUMPERS & PARTS

Pretreatment / Cleaning of substrate



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

For application with 340 PLASTOFIX no sanding is necessary apart from PE plastics. Use P600-P800 wet.

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: Application on plastics

1 pass »» Apply one coat on plastic surfaces



4:1 mix with H 729 HARDENER NORMAL
Pot life: 60-80min @ 23°C (73°F)



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

Flash Point:
28°C / 82°F

Specific Gravity:
1.16 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 ready for use form of this product is 630 g/L.
2004/42/II(c)(780)630

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

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

Remarks:

- 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)
- Not recommended to be applied as wet on wet over Body 960 Wash Primer or 961 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 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.



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