

BODY 989 4:1 EPOXY PRIMER SURFACER BLACK CHASSIS COAT

Technical Data Sheet No 136

VOC compliant with the regulations

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

Excellent 2K high performance Epoxy Primer with anticorrosive properties

General Technical Description



Mix 100 parts BODY 989 with 25 parts BODY EPOXY HARDENER 732 / 10 - 15 parts 775 EPOXY THINNER/ 740 ACRYL NORMAL

Oven force drying
1h / 80°C (176°F) panel temperature

Air dry 5- 6 h / 23°C (73°F)



IR drying 10-15 min
distance 60-70 cm

Surface

Aluminium Surfaces

Stainless Steel

Galvanised Surfaces

Non sanded bare metal

Over old pant work

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: A 2K Epoxy Primer

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



Mix 100 parts BODY 989 with 25 parts BODY 732 EPOXY HARDENER/
Pot life: 24 h @ 23°C (73°F)



Non force dry
100 - 150µm (3.9-5.9mil)
5 - 6 h / 23°C (73°F)
1h / 80°C (176°F) panel temperature

Flash Point:
27°C / 81°F

Specific Gravity:
1.28 g/cm³

Solid Content (No thinner):
62% Weight

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 540 g/L.
2004/42/II(c)(540)540

Theoretical Coverage:
6-7 m² / l at 100 micron (3.9mil) dry film thickness

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

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)

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



Addition 10-15% of thinner.
Use 775 EPOXY THINNER/
740 ACRYL NORMAL



P 320 – P 1000
Sanding by hand, wet



Ready to spray:
18-24 s
DIN 4 @ 20°C (68°F)



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



Compliant Spray gun
1.5 – 1.8 mm
2-3 bar (29-44psi)
inlet pressure
2-3x coats = 100-150µm (3.9-5.9mil)



Always wear protective equipment



HVLP Spray gun
1.5 – 1.7 mm
2 bar (29psi)
inlet pressure
2-3x coats = 100-150µm (3.9-5.9mil)



Follow the application instructions mentioned in this TDS



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

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