



TECHNICAL DATA SHEET No 119

P989 4:1 EPOXY PRIMER

GENERAL TECHNICAL DESCRIPTION

High-performance 2K epoxy primer with anticorrosive properties.

Outstanding sealing, adhesion and filling abilities.

Resistant to extreme weather conditions.

SURFACE

Aluminium
Stainless Steel
Galvanised
Non sanded Bare steel
Old paintwork

PRETREATMENT/CLEANING OF SUBSTRATE

The surface to be coated must be dry, clean, and free of grease and other contaminants. Ensure all substrates are thoroughly cleaned and dried at every step of the preparation process.



Sand substrate with an appropriate grit paper.



Clean the surface with 770 NORMAL / 771 FAST ANTISIL Degreaser.

Use 2 clothes wipe on, wipe off. Always wipe cleaner off the surface as long is wet, with a clean, dry cloth.

Remove dust by air blowing and a tack cloth.

PRODUCT APPLICATION: As 2K Epoxy Primer



Mix 4 parts PRIMER with 1 part H732 EPOXY HARDENER
Pot life: 24 h / 23°C (73°F)



Addition 25% of 775 EPOXY or 740 ACRYL NORMAL THINNER / REDUCER



Ready to spray: 28 - 32 s
DIN 4 / 20°C (68°F)



1.5 - 1.8 mm
1.7 - 2.2 bar (25 - 32 bar)
2x coats = 80 - 120 µm (3.2 - 4.7 mil)



15 min / 23°C (73°F)
Flash off time between coats



8 - 14 h / 23°C (73°F)
1 h / 60°C (140°F)
panel temperature



P 320 - P 400



P 320 - P 1000
Sanding by hand, wet



It can be painted over with HB BODY 2K Primers and any paint system.*

***Note:** It is also possible to overcoat without sanding (from 2 up to 8 hours after application). The final finish may not result as smooth and uniform as desired. Product performance is not affected. For optimal results it is recommended to apply a 2K primer/surfacer after P989, before proceeding with painting.

PRODUCT APPLICATION: "Wet on Wet"

Apply two thin coats. See in remarks for important notice on OEM panel treatment.



Mix 4 parts PRIMER with 1 part H732 EPOXY HARDENER
Pot life: 16 h / 23°C (73°F)



Addition 40 - 50% of 775 EPOXY THINNER / REDUCER



Ready to spray: 20 - 22 s
DIN 4 / 20°C (68°F)



1.2 - 1.3 mm
1.7 - 2.2 bar (25 - 32 psi)
2x coats = 40 - 50 µm (1.6 - 2 mil)



5 - 10 min / 23°C (73°F)
Flash off time between coats



It can be painted over with all HB BODY paint systems, starting from 2-3h after application, up to 8h at 23°C (73°F). After 8 hours, light sanding is required.

SPECIFIC GRAVITY1.52 ± 0.03 g/cm³**SOLID CONTENT**

72 ± 2% 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 540 g/L.
2004/42/IB(c)(540)540

THEORETICAL COVERAGE

6 - 7 m² / l at 100 µm (4 mil) dry film thickness

CLEANING OF EQUIPMENT

Clean after final use with 775 EPOXY or 767 NITRO thinner / reducer

REMARKS

- Application only with the recommended hardeners and thinners / reducers.
- Do not use at temperatures below 15°C (59°F).

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 NORMAL DEGREASER and the "Wet on Wet" procedure is followed without sanding.

STORAGE SHELF LIFE

- Guaranteed shelf life of 24 months in unused original containers stored in a cool place (5 - 25°C) (41 - 77°F).



Always wear protective equipment



Follow the application instructions mentioned in this TDS

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