



BODY PRO 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 BODY PRO P411 WET ON WET PRIMER with 1 part BODY 720 HARDENER NORMAL / 721 HARDENER SLOW

Thinner addition 25%:
• BODY 740 ACRYL NORMAL THINNER / 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 #70 ANTISIL NORMAL / BODY 771 ANTISIL FAST..

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

Make sure the surface is air dried rather than wiped dry



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 BODY 720 HARDENER NORMAL / BODY 721 HARDENER SLOW
Pot life: 60-80min @ 23°C (73°F)



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



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



Non force dry
20-30min 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
3-4 bar inlet pressure
1x coat = 15 - 25µm



SYNTHETIC
2K ACRYLIC
BASECOAT



HVLP 1.4 mm
2 bar inlet pressure



Follow the application instructions mentioned in this TDS

Flash Point:
28°C / 82°F

Specific Gravity:
1.15 g/cm³

Solid Content (No thinner):
65% 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 the ready for use form of this product is 630 g/L.
2004/42/IB(c)(780)630

Theoretical Coverage:
8 m² / l at 15 micron 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.

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 to 25oC) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.

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 3/2015, November 2015