

TECHNICAL DATA SHEET No 119

P988 2K EPOXY CHASSIS COAT

GENERAL TECHNICAL DESCRIPTION

Direct to Metal, high quality epoxy primer & paint in one for the treatment of chassis

Reinforced anticorrosive protection

Excellent adhesion to all metallic substrates

High mechanical and chemical resistance

Semigloss finish

PRODUCT APPLICATION:

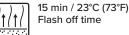
P 400 - P 800

Mix 4 parts PRIMER with 1 1 4

part H732 EPOXY HARDENER Pot life: 24 h / 23°C (73°F)



1.5 – 1.7 mm 1.5 - 2 bar (22 - 29 psi) 2 - 3x coats = 100 - 150 μ m (3.9 - 5.9 mil)



REDUCER

P 400 - P 1000

Sanding by hand, wet

SURFACE

Aluminium

Addition 10 - 15% BODY

NORMAL THINNER /

775 EPOXY or 740 ACRYL

Stainless Steel

Galvanised Surfaces

Non sanded bare metal



18-24

2x coats Flash off time 30 min at 23°C (73°F)

Ready to spray: 18 - 24 s

DIN 4 / 20°C (68°F)



It can be painted over with all HB BODY Mix Systems.

It can be painted over without sanding after 2 - 3 h from its application and until 8 h max.



13°C / 55°F SPECIFIC GRAVITY

1.27 g/cm³ SOLID CONTENT (NO THINNER)

60% 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 a/L. The VOC content in the ready for use form of this product is 540g/L. 2004/42/IIB(c)(540)540

THEORETICAL COVERAGE

6 - 7 m² / I at 100 micron (4 mil) dry film thickness

CLEANING OF EQUIPMENT Clean after final use with 740 ACRYL

NORMAL THINNER / REDUCER, 775 **EPOXY THINNER / REDUCER**

REMARKS

· Avoid direct exposure to sunlight. In opposite case the primer must be painted over (compatible with all HB BODY Mix Systems)

 Allow for additional time for combi spray booths to reach the desired temperature

· Application only with the recommended

- hardeners and thinners / reducers
- Do not use at temperatures below 15°C (59°F)

STORAGE SHELF LIFE

Store in a cool place (+5°C - +25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers



Always wear protective equipment



Follow the application instructions mentioned in this TDS

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OCTOBER 2021



Compliant spray gun

2 - 2.5 bar (29 - 36 psi)

5 - 6 h / 23°C (73°F)

1 h / 60°C (140°F)

panel temperature

2 - 3x coats = 100 - 150 μm

1.5 – 1.8 mm

(3.9 - 5.9 mil)

PRETREATMENT/CLEANING OF SUBSTRATE



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

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

HB BODY S.A. AUTOMOTIVE REFINISH