

# 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 989 EPOXY HARDENER / 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 989 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/cm<sup>3</sup>

### 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)



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



P 320 – P 1000  
Sanding by hand, wet

**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 m<sup>2</sup> / l at 100 micron (3.9mil) dry film thickness

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



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



Always wear protective equipment



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



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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