



# AUTO 534 4:1 HS 2K PRIMER

## Technical Data Sheet

Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter (#340 Plastofix)

VOC compliant with the regulations

2K Acrylic system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties even on plastic bumpers

### General Technical Description



Mix 4:1 with AUTO 534 HARDENER FOR PRIMERS

Thinner addition 15 - 20%  
BODY 740 ACRYLIC THINNER NORMAL  
BODY 741 ACRYLIC THINNER SLOW

Oven force drying – 20-30 min / 60-65°C panel temperature

Air dry 1h / 23°C



IR drying 8-12 min distance 60-70 cm

### Surface

On old, sanded paint work

Unsanded cathaphoresis OEM panels (E-COAT)

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body 960 Wash Primer

Bodyfill 961 Etch Filling Primer

Over new and used plastic bumpers

### Pretreatment / Cleaning of substrate



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

Make sure the surface is air dried rather than wiped dry



Make sure you always use appropriate face protection and good ventilation

### Product Application: As an HS sanding primer

2 passes »» Apply one coat, and after the 15 min flash off time apply the second full coat.



4:1 mix with AUTO 534 HARDENER FOR PRIMERS  
Pot life: 45 mins @ 23°C (73°F)



Non force dry - 1h / 23°C  
20-30 min / 60-65°C panel temperature



Addition 15-20% of thinner.  
Use BODY 740 NORMAL ACRYLIC THINNER/741 SLOW ACRYLIC THINNER



Short wave 8 – 12 min distance 60-70 cm



Ready to spray:  
28 - 36 s - Cup 4 @ 23°C - DIN 53211



P 400 - P 500  
Flat bed sander



Compliant Spray gun 1.5mm – 1.8 mm  
3-4 bar inlet pressure  
2x coats = 120 - 140 micron



P 800  
Sanding by hand, wet



HVLP 1.5mm - 1.7 mm  
2 bar atomization pressure  
2x coats = 120 - 140 micron



2K Autoemail Acrylic Paint SR  
HB BODY Basecoat  
HB BODY UHS Clears



Always wear protective equipment



10 min / 23°C  
Final flash off time



Follow the application instructions mentioned in this TDS

**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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# AUTO 534 4:1 HS 2K PRIMER

## Technical Data Sheet

**Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.)**  
 2 passes »» Apply one coat, and after the 15 min flash off time apply the second full coat.



Dry sanding  
 P 180 - P 220  
 (never with a scotch  
 brite)



5 -10 min / 23°C  
 Final flash off time

**Flash Point:**  
 27°C / 80°F

**Remarks:**

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



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



Non force dry

**Specific Gravity:**  
 1.50 g/cm<sup>3</sup>

**Solid Content (No thinner):**  
 72% Weight

- Application only with the recommended hardeners and solvents

Make sure the surface  
 is air dried rather than  
 wiped dry



Make sure you always  
 use appropriate face  
 protection and good  
 ventilation



P 400 – P 500  
 Flat bed sander

**VOC (2001/42/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 490 g/L.  
 2004/42/II(c)(540)490

- It can be used by countries that do not adopt the VOC legislation as well.

- Do not use at temperatures below 15°C.

- Do not apply the primer as 'wet on wet' on TPA surfaces



4:1 mix with AUTO 534  
 HARDENER FOR PRIM-  
 ERS Pot life: 55-70 min  
 @23°C (73°F)



P 600 – P 1000  
 Sanding by hand, wet

**Theoretical Coverage:**  
 5 - 6 m<sup>2</sup> / l at 120micron dry film  
 thickness

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



Addition 50 - 60% of  
 thinner. Use BODY  
 740 NORMAL ACRYLIC  
 THINNER/741 SLOW  
 ACRYLIC THINNER



2K Autoemail Acrylic  
 Paint SR  
 HB BODY Basecoat  
 HB BODY UHS Clears



Ready to spray:  
 16 - 18 s - Cup 4 @  
 23°C - DIN 53211



Always wear  
 protective equipment



Compliant Spray gun  
 1.8 mm  
 3-4 bar inlet pressure  
 1-3 coats = 30 - 35 micron



Follow the application  
 instructions mentioned  
 in this TDS



HVLP Spray gun  
 1.8 mm  
 2 bar inlet pressure  
 1-3 coats = 30 - 35 micron

**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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