



# BODYFILL 989 4:1 EPOXY PRIMER

Technical Data Sheet No 119

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 4:1 with with BODY 989 EPOXY HARDENER

Oven force drying  
1h / 60- 65°C panel temperature

Air dry - 5 - 6h /23°C



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 air dried rather than wiped dry



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 5-10 min flash off time apply the second coat.



4:1 mix with BODY 989 EPOXY HARDENER  
Pot life: 60 min @23°C (73°F)



Non force dry -  
5-6h / 22-25°C  
1h / 80°C panel temperature



Addition 20-30% of thinner.  
Use BODY 775 EPOXY THINNER



P 320 – P 400  
With random orbital sander



Ready to spray:  
28-32 s - Cup 4 @23°C DIN 53211



P 320 – P 1000  
Sanding by hand, wet



Compliant Spray gun 1.5 – 1.8 mm  
3-5 bar inlet pressure  
2x coats = 80-120 micron



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



HVLP Spray gun 1.5 – 1.8 mm  
2 bar inlet pressure  
2x coats = 80-120 micron



Always wear  
protective equipment



15 min / 23°C  
Final flash off time



Follow the application instructions  
mentioned in this TDS



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## Product Application: "wet on wet"

»» Apply one full coat.



4:1 mix with BODY 989  
EPOXY HARDENER



Non Force dry  
8 h / 22-25°C

**Flash Point:**  
13°C / 55°F

### Remarks:

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



Addition 20-30% of  
thinner. Use BODY 775  
EPOXY THINNER



P 320 – P 400  
With random orbital  
sander

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

**Solid Content (No thinner):**  
76% Weight

- Application only with the recommended hardeners and solvents



Ready to spray:  
20-22 s - Cup 4 @23°C  
DIN 53211/ 23°C



P 320 – P 1000  
Sanding by hand, wet

### 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 380 g/L.  
2004/42/IB(c)(540)380

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

- Do not use at temperatures below 15°C.



Compliant Spray gun  
1.3mm – 1.4mm  
3-5 bar inlet pressure  
2 coats = 50-60 micron



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

### Theoretical Coverage:

6-7 m<sup>2</sup> / l at 10micron dry film thickness



HVLP 1.3mm-1.4mm  
2 bar atomization pressure  
2 coats = 50-60 micron



Always wear  
protective equipment

### Cleaning of equipment:

Clean after final use with  
Body 740 ACRYL NORMAL



5-10 min / 23°C



Follow the application  
instructions  
mentioned in this TDS

**\*\*When air drying BodyFill 989 EPOXY PRIMER, is suitable for maximum "wet on wet" in 8 h instead of 24 h that was before\*\***

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Issue 1/2013, October 2013