



# BODY 989 4:1 EPOXY PRIMER SURFACER

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 100 parts BODY 989 with 25 parts BODY EPOXY HARDENER 732 / 25 parts BODY ACRYL 740 THINNER

Oven force drying  
1h / 80°C (176°F)  
panel temperature

Air dry  
8 - 14 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 EPOXYHARDENER 732 / 25 parts BODY ACRYL 740 THINNER  
Pot life: 24 h @ 23°C (73°F)



Non force dry  
80 - 120µm (3.2 - 4.7 mil)  
8 - 14 h / 23°C (73°F)  
1h / 80°C panel temperature



Addition 25% of thinner.  
Use BODY 775 EPOXY THINNER / BODY ACRYL 740 THINNER



P 320 – P 400  
With random orbital sander



Ready to spray:  
28-32 s  
DIN 4 @ 20°C (68°F)



P 320 – P 1000  
Sanding by hand, wet



Compliant Spray gun 1.5 – 1.8 mm  
2-3 bar (29 - 44 psi) inlet pressure  
2x coats = 80-120µm (3.2 - 4.7 mil)



• HB BODY Color Solutions Basecoat  
• HB BODY Color Solutions 2K  
• HB BODY Clears



HVLP Spray gun 1.5 – 1.7 mm  
2 bar (29 psi) inlet pressure  
2x coats = 80-120µm (3.2 - 4.7 mil)



Always wear protective equipment



15 min / 23°C (73°F)  
Final flash off time



Follow the application instructions mentioned in this TDS



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## Product Application: "wet on wet"

»» Apply two thin coats.



4:1 mix with BODY 989 EPOXY HARDENER



Non force dry  
2-3h min / 23°C (73°F)  
8h max

**Flash Point:**  
13°C / 55°F

### Remarks:

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

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

**Solid Content (No thinner):**  
74% Weight

• Application only with the recommended hardeners and solvents



Addition 40-50% of thinner. Use BODY 775 EPOXY THINNER



• HB BODY Color Solutions Basecoat  
• HB BODY Color Solutions 2K  
• HB BODY Clears

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

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



Ready to spray:  
20-22 s  
DIN 4 @ 20°C (68°F)



Always wear protective equipment

### Theoretical Coverage:

6-7 m<sup>2</sup> / l at 100 micron (4mil) dry film thickness

• Do not use at temperatures below 15°C (59°F).



Compliant Spray gun  
1.3mm – 1.4mm  
2-3 bar (29 - 44 psi)  
inlet pressure  
2 coats = 40-50 µm  
(1.6-2.0mil)

### Cleaning of equipment:

Clean after final use with BODY 740 ACRYL NORMAL

### 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 BODY 634 and BODY 635 application.



HVLP 1.3mm-1.4mm  
2 bar (29 psi)  
atomization pressure



Follow the application instructions mentioned in this TDS

### 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.



5-10 min / 23°C (73°F)

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