



## TECHNICAL DATA SHEET No 102

# P334 4:1 HS FILLING PRIMER

### GENERAL TECHNICAL DESCRIPTION

Multi-use 2K acrylic primer.  
 Direct application over brand new and used OEM plastic parts without the use of an intermediate adhesion promoter.  
 Superior filling properties.  
 Excellent mechanical properties even on plastic parts.  
 Easy to sand and fast drying.

### SURFACE

Old, sanded paint work  
 Unsanded cataphoresis OEM panels (E-COAT)  
 Fiberglass  
 Clean and sanded steel panels  
 HB BODY Polyester Fillers  
 HB BODY Wash Primers  
 P961 Etch Primer  
 Over new and used plastic parts except pure Polyethylene (PE)

### PRETREATMENT/CLEANING OF SUBSTRATE

The surface to be coated must be dry, clean, and free of grease and other contaminants. Ensure all substrates are thoroughly cleaned and dried at every step of the preparation process.



Clean the surface with 770 NORMAL / 771 FAST ANTISIL Degreaser

Use 2 clothes wipe on, wipe off. Always wipe cleaner off the surface as long is wet, with a clean, dry cloth.

Remove dust by air blowing and a tack cloth.

### PRODUCT APPLICATION: As sanding primer



Mix 4 parts PRIMER with 1 part H725 HARDENER FOR PRIMERS  
 Pot life: 50 - 60 min / 23°C (73°F)



Addition 15 - 20% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 25 - 33 s  
 DIN 4 / 20°C (68°F)



1.5 - 1.8 mm  
 1.7 - 2.2 bar (25 - 32 psi)  
 2x coats = 100 - 120 µm (3.9 - 4.7 mil)



10 min / 23°C (73°F)  
 Flash off time



2 - 3 h / 23°C (73°F)  
 20 - 30 min / 60°C (140°F)  
 panel temperature



Short wave 8 - 12 min  
 distance 60 - 70 cm



P 400 - P 500



P 600 - P 1000  
 Sanding by hand, wet



It can be painted over with all HB BODY paint systems

### PRODUCT APPLICATION: For plastic parts

Direct application without the need of an adhesion promoter



Dry sanding  
 P240 - P320



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



Mix 4 parts PRIMER with 1 part H725 HARDENER FOR PRIMERS  
 Pot life: 55 - 70 min / 23°C (73°F)



Addition 50 - 60% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 14 - 16 s  
 DIN 4 / 20°C (68°F)



1.3 - 1.5 mm  
 1.7 - 2.2 bar (25 - 32 psi)  
 2 - 3x coats = 60 - 80 µm (2.3 - 3.1 mil)



5 - 10 min / 23°C (73°F)  
 Flash off time



1 - 2 h / 23°C (73°F)



P 400 - P 500









P 600 - P 1000  
 Sanding by hand, wet



It can be painted over with all HB BODY paint systems



**PRODUCT APPLICATION: As "wet on wet" primer. Apply one thin closed coat.**

 <p>Mix 4 parts PRIMER with 1 part H729 HARDENER FOR PRIMERS NORMAL          Pot life: 30 - 45 min / 23°C (73°F)</p>	 <p>Addition 50 - 60% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER</p>	 <p>Ready to spray: 14 - 16 s          DIN 4 / 20°C (68°F)</p>	 <p>1.2 - 1.4 mm          1.7 - 2.2 bar (25 - 32 psi)          1x coat = 20 - 25 µm (0.8 - 1.0 mil)</p>
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 <p>20 - 30 min / 23°C (73°F)          Flash off time before painting</p>	 <p>It can be painted over with all HB BODY paint systems</p>
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**Notes:**

- On a "wet on wet" application H729 HARDENER FOR PRIMERS must be used (never H725).
- Never apply "wet on wet" over polyester fillers. High risk of mapping appearance after clear coating.

<p><b>SPECIFIC GRAVITY</b> 1.48 ± 0.02 g/cm<sup>3</sup></p> <p><b>SOLID CONTENT</b> 73 ± 1% Weight</p> <p><b>VOC (2004/42/EC)</b> This 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/IIIB(c)(540)540</p> <p><b>THEORETICAL COVERAGE</b> 5 - 6 m<sup>2</sup> / l at 120 micron (4.7 mil) dry film thickness</p> <p><b>CLEANING OF EQUIPMENT</b> Clean after final use with 740 ACRYL NORMAL or 767 NITRO thinner / reducer</p>	<p><b>REMARKS</b></p> <ul style="list-style-type: none"> <li>• Application only with the recommended hardeners and thinners / reducers.</li> <li>• Do not use at temperatures below 10°C (50°F).</li> <li>• Do not apply the primer as "wet on wet" on TPA surfaces.</li> </ul> <p><b>CAUTION:</b> 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 P334 application.</p>	<p><b>STORAGE SHELF LIFE</b> Guaranteed shelf life of 24 months in unused original containers stored in a cool place (5 - 25°C) (41 - 77°F).</p> <p> Always wear protective equipment</p> <p> Follow the application instructions mentioned in this TDS</p>
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**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.**

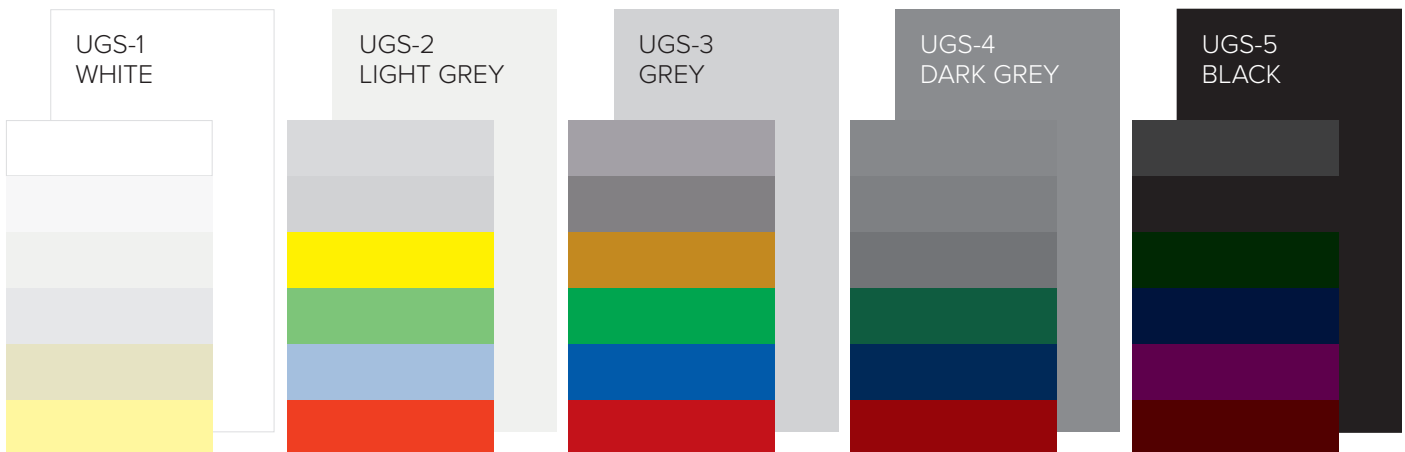
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### Undercoat Grey Shades (UGS) MIXING TABLE

P334 4:1 HS FILLING PRIMER		MIX BY VOLUME		MIX BY WEIGHT (grams)			
		SHADE RATIO	MIX RATIO	100ml PRIMER	250ml PRIMER	500ml PRIMER	1000ml PRIMER
<b>UGS-1 WHITE</b>	WHITE	100%	4	147,50	368,75	737,50	1475,00
	GREY	-		-	-	-	
	BLACK	-		-	-	-	
<b>UGS-2 LIGHT GREY</b>	WHITE	80%	4	118,00	295,00	590,00	1180,00
	GREY	20%		29,50	73,75	147,50	295,00
	BLACK	-		-	-	-	
<b>UGS-3 GREY</b>	WHITE	-	4	-	-	-	-
	GREY	100%		147,50	368,75	737,50	1475,00
	BLACK	-		-	-	-	
<b>UGS-4 DARK GREY</b>	WHITE	-	4	-	-	-	-
	GREY	80%		118,00	295,00	590,00	1180,00
	BLACK	20%		29,50	73,75	147,50	295,00
<b>UGS-5 BLACK</b>	WHITE	-	4	-	-	-	-
	GREY	-		-	-	-	-
	BLACK	100%		147,50	368,75	737,50	1475,00
<b>HARDENER</b>	<b>H725</b>		1	24,05	60,13	120,25	240,50
	OR						
	<b>H729</b>			23,55	58,88	117,75	235,50
<b>THINNER (REDUCER)</b>	<b>740 / 741</b>	max 20%		17,73	44,33	88,65	177,20

Follow recommended grey undercoat shades for faster paint covering, shorter time application, less consumption and better colour matching. Proceed with activation of UGS mixture with hardeners and thinners according to each primer's mixing specifications provided in its TDS.

### Undercoat Shade Indication Chart



The above colour guidelines are provided for user convenience and are not mandatory when using HB BODY Basecoat and 2K Acrylic Mix System products.