



TECHNICAL DATA SHEET No 122

P411 4:1:1 WET ON WET PRIMER

GENERAL TECHNICAL DESCRIPTION

High performance acrylic sealing primer, specially designed for wet-on-wet application.

For treatment of new parts before painting.

Excellent adhesion on brand new surfaces without sanding.

It is applied at a 4:1:1 ratio (primer: hardener: thinner).

SURFACE

Brand new OEM parts

Cataphoresis OEM panels (E-COAT)

OEM brand new 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.

Note: For surfaces that are not OEM or E-Coated, first abrade slightly with P600 - P800, wet.

PRODUCT APPLICATION: Apply one thin closed coat on metallic surfaces.



Mix 4 parts PRIMER with 1 part H729 HARDENER FOR PRIMERS NORMAL
Pot life: 60 - 80 min / 23°C (73°F)



Addition 25% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 16 - 18 s
DIN 4 / 20°C (68°F)



1.2 - 1.3 mm
1.7 - 2.2 bar (25 - 32 psi)
1x coat = 20 - 25 µm
(0.8 - 1.0 mil)



It can be painted over with all HB BODY paint systems, starting from 20-30min after application, up to 48h at 23°C (73°F). After 48 hours, light sanding is required.

PRODUCT APPLICATION: Apply one thin closed coat on plastic surfaces.



Mix 4 parts PRIMER with 1 part H729 HARDENER FOR PRIMERS NORMAL
Pot life: 60 - 80 min / 23°C (73°F)



Addition 25% P340 PLASTOFIX instead of thinner / reducer



Ready to spray: 16 - 18 s
DIN 4 / 20°C (68°F)



1.2 - 1.3 mm
1.7 - 2.2 bar (25 - 32 psi)
1x coat = 20 - 25 µm
(0.8 - 1.0 mil)



It can be painted over with all HB BODY paint systems, starting from 20-30min after application, up to 48h at 23°C (73°F). After 48 hours, light sanding is required.

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.

SPECIFIC GRAVITY1.16 ± 0.02 g/cm³**SOLID CONTENT**

56 ± 2% Weight

VOC (2004/42/EC)

This is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 780 g/L. The VOC content in the ready for use form of this product is 780 g/L. 2004/42/IB(c)(780)780

THEORETICAL COVERAGE

8 m² / l at 15 µm (0.6 mil)
dry film thickness

CLEANING OF EQUIPMENT

Clean after final use with 740 ACRYL
NORMAL or 767 NITRO Thinner /
Reducer

REMARKS

- Application only with the recommended hardeners and thinners / reducers.
- Do not use at temperatures below 10°C (50°F).
- Not recommended to be applied as wet on wet over HB BODY Wash Primers or P961 Etch Primer.

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 P411 application.

STORAGE SHELF LIFE

Guaranteed shelf life of 24 months in unused original containers stored in a cool place (5 - 25°C) (41 - 77°F).



Always wear protective equipment



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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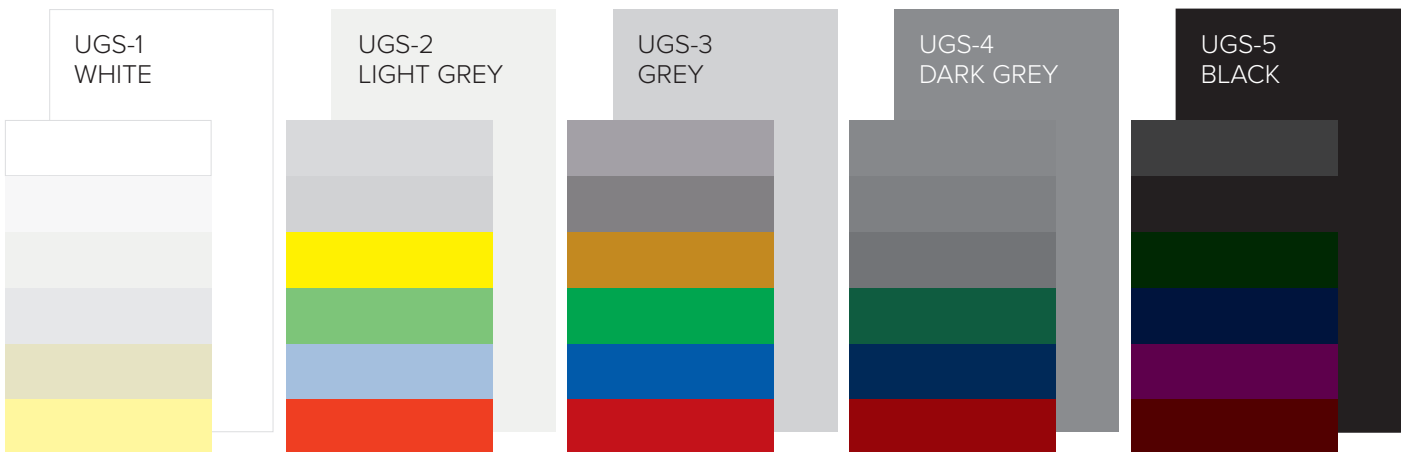
DECEMBER 2025

Undercoat Grey Shades (UGS) MIXING TABLE

P411 4:1:1 WET ON WET PRIMER		MIX BY VOLUME		MIX BY WEIGHT (grams)			
		SHADE RATIO	MIX RATIO	100ml PRIMER	250ml PRIMER	500ml PRIMER	1000ml PRIMER
UGS-1 WHITE	WHITE	100%	4	116,80	292,00	584,00	1168,00
	GREY	-		-	-	-	
	BLACK	-		-	-	-	
UGS-2 LIGHT GREY	WHITE	80%	4	93,44	233,60	467,20	934,40
	GREY	20%		22,94	57,35	114,70	229,40
	BLACK	-		-	-	-	
UGS-3 GREY	WHITE	-	4	-	-	-	-
	GREY	100%		114,70	286,75	573,50	1147,00
	BLACK	-		-	-	-	
UGS-4 DARK GREY	WHITE	-	4	-	-	-	-
	GREY	80%		91,76	229,40	458,80	917,60
	BLACK	20%		22,80	57,00	114,00	228,00
UGS-5 BLACK	WHITE	-	4	-	-	-	-
	GREY	-		-	-	-	-
	BLACK	100%		114,00	285,00	570,00	1140,00
HARDENER	H729		1	23,55	58,88	117,75	235,50
THINNER (REDUCER)	740/741		25%	21,90	54,70	109,40	218,80

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.