

P54 – 2K Wet on Wet Primer White



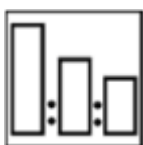
Product Description

A VOC compliant, Wet on Wet primer, with good application and adhesion properties. Excellent flow, very little overspray, Excellent gloss retention of final finish, overcoatable with all Hymax Basecoats and Topcoats. One visit application. Direct to Plastic application when A230 is used.

Suitable Substrates

- Existing Finishes except TPA
- OEM Primer or EDP, sanded
- Well sanded and finished Body filler.
- Bare metal substrates must be pre-primed with wash primer P97.

Product Application



100% Clear	25% Hardener	25 - 32% Thinner
P54	H060	S19 THINNER FAST
	H070	S11 THINNER NORMAL
	H075	S21 THINNER SLOW



STIR P54 well before mixing



17 – 20 secs / DIN 4 mm / 20°C (68°F)
Potlife 40 min / 20°C (68°F)



HVLP 1.3 - 1.5 mm
2.0 – 2.5 bar inlet pressure

Disclaimer: Users assume full responsibility for any consequences resulting from the incorrect usage of our products.

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Apply 1 full single coat 25 – 30 microns. 0.5 + 1 coat if applying over a small area of body filler. Note: Not recommended for spot repairs on flat panels.



30 mins at 20°C (68°F) Note: After 60 mins light resanding of primer recommended before Topcoating



Normally wet on wet primers do not require flatting and can be directly top- coated. If some dirt inclusions occur, light flatting/denibbing can be carried out after 30 mins using P1200 or finer flatting papers.



Hyflow Top Coat
Hydrobase Basecoats



Wear suitable protection

P54 Primer on Plastics Direct:

With the addition of A230, P54 can be applied direct to plastics without the need for a 1K plastic adhesion promoter (plastic primer).



100% Clear	15% Plastic Additive A230	25% Hardener	30% Thinner
P54	A230	H060 H070	S21 SLOW S11 NORMAL

Potlife 100 min / 20°C (68°F)

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Process Notes: All other processes remain the same as per the P54 TDS sheet on application, drying and sanding.

Product Characteristics

VOC:	2004/42/II B (c) (540)540. The EU limit value for this product (product category IIB.c) in ready to use form is max 540 g/ltr. The VOC content of this product in ready for use form is max. 540 g/l.
Flash Point:	20-25°C (77°F)
Specific Gravity:	1.4 kg/cm ³ (11.658 lbs/gal)
Solids Content:	56 % by weight – ready to spray
Coverage:	5.7-5.8 m ² /l at 25-30 micron film thickness (theoretical)
SDS:	Refer to the Safety Data Sheet

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