

P424 - Hyflash Air dry 2K VOC Primer White

Product Description

Hyflash P424 is a VOC High Build Air-Dry 2K Primer with excellent filling properties and sandability. It is recommended for high performance bodyshops focusing on efficiency, space utilization and cost-reduction with no compromise on premium quality. (Available in Grey - P420 and Dark grey – P426). Hyflash P424 is easy to sand within 1 hour from application at 20°C room temp. It maintains an excellent gloss holdout when top coated with any Hymax top coating material. It uses the same HS hardener family (H050, H060) as other primers in the HYMAX range, providing a complete and compact offer.

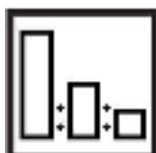
Suitable Substrates:

- Old and Sound thermoset topcoats.
- Hymax polyester fillers.
- Sound OEM Hydrobase Basecoat

Notes:

- Adhesion promoter is required to apply to special substrate i.e: plastic, fiber glass, and GRP.
- etch primer (P97) is required to apply to bare metal prior to P42X application

Product Application



| 100% | 25% | 5-25% |
|------|-------------------------|--------------|
| P424 | H050 FAST HS HARDENER | S19 THINNER* |
| | H060 NORMAL HS HARDENER | S11 THINNER |

* recommended



18-19 s / DIN 4 mm / 20°C
Potlife: 40 minutes at 20°C



HVLP 1.6 – 1.8 mm

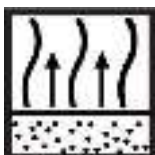
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2-3 coats
45-50 microns/coat

| THINNING RATIO% | VISCOSITY | FILM THICKNESS/COAT | 3 COATS TOTAL FILM BUILD |
|-----------------|-----------|---------------------|--------------------------|
| 5% | 40" | 70 μ | 210 μ |
| 10% | 30" | 67 μ | 200 μ |
| 15% | 25" | 65 μ | 195 μ |
| 20% | 22" | 60 μ | 180 μ |
| 25% | 19" | 55 μ | 165 μ |



3-5 minutes between coats



Dust free after 10 minutes @ 20 °C (68°F)

Touch free after 15 minutes @ 20 °C (68°F)

Sandable after 60 minutes @ 20 °C (68°F)

Depending on film thickness

Important note: below 15°C Do not air-dry

Low bake 5-10 minutes @ 60°C panel temperature



5-7 minutes, depending on color.

Substrate temperature 80°C-100°C (176°F to 212°F)

*Important note: keep panel at greater than 80cm from IR unit, depending on repair film thickness.



5 Min at 60°C panel temperature (140°F)

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Wear suitable protection

Product Characteristics

| | |
|--------------------------|--|
| VOC(2004/42/EC): | 2004/42/EC IIB (c) (540)540. The EU limit value for this product (product category IIB. c) in ready to use form is max 540g/ltr. The VOC content of this product in ready for use form is max.540 g/l. |
| Specific Gravity: | P420 (Grey) = 1.64 kg/cm ³ P424 (White)= 1.637 kg/cm ³ P426 (Dark Grey) = 1.493 kg/cm ³ |
| Flash Point: | 25°C (77°F) |
| Solid Content: | Approx. 62.5% - 67.5% by weight RFU, depending on reduction ratio. |
| Coverage: | 8 - 9 m ² /l at 5.7-5.8 m ² /l at 80-micron film thickness (theoretical) micron dry film thickness |
| SDS: | Refer to the Safety Data Sheet |

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