

# P44 - 2K Rapid Primer Black



## Product Description

This is a sanding 2K VOC high build primer. P4X series is a fast dry 2K primer with excellent sand ability and gloss holdout. It can be applied directly to plastic parts when combined with plastic additive A230 and C100 plasticizer.

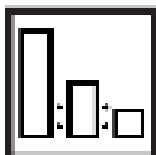
## Suitable Substrates:

- Existing Finishes except thermoplastic acrylic
- "Hymax" Polyester Putties/body fillers
- Bare metal substrates must be pre-primed with Etch primer P97.
- Available colors (Beige P40, Grey P42, Black P43, White P44, Red P45, Dark Grey P46).

## Extra Comments

Stir well before mixing.

## Product Application



100%	25%	5-25%
P44	H050 - Fast H060 - Normal	S11



35 sec / DIN 4 mm / 20°C (68°F) @ 5% reducer  
18-19 sec / DIN 4 mm / 20°C (68°F) @ 25% reducer  
Potlife 45 to 60 min / 20 °C (68 °F)



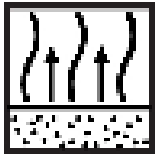
HVLP 1.6 – 1.8 mm  
2.0 – 2.5 bar inlet pressure



2-3 coats  
50-60 microns/coat

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

# P44 - 2K Rapid Primer Black



5-6 minutes at 20 °C (68 °F) between coats



2-3 hours at 20 °C (68 °F)  
20 min. at 60 °C (140 °F)



10 – 15 mn. Medium - long Wave  
The object should be maintained at greater than 80 cm from source



Initial Sanding with P400 grit  
Final Sanding with P500 grit



Clean Surface using Genclean S241 degreaser to remove contamination prior to application of top coat.



Hyflow Top Coat  
Hydrobase Basecoats



Wear suitable protection

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

# P44 - 2K Rapid Primer Black

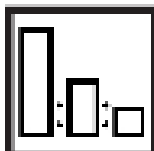


## Tinting the Primer for Limited Opacity Colors

**NB:** Please refer to Hymix comments to select the needed color of the prime that matches with the top coat color.

### Process

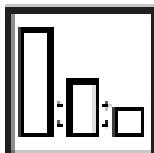
Using the appropriate primer from our range mix:



2:1:1:0.5  
Appropriate Primer 2 Parts.  
Selected T-Series Color Formula 1 Part.  
Hardener 1 Part.

## P44 Primer Direct to Plastics

With the addition of A230, P44 can be applied direct to plastics without the need for a 1k plastic adhesion promotor (plastic primer)



4:1  
- H060 H050 Hardeners.  
- 10 – 25% Reducer “Hymax”  
- Add 15% plastic additive A230  
- Pot life 45-60 mins / 20 °C (68°F)

## P43 Primer Plasticized:

Soft Plastic Application			Hard Plastic Application		
Product	Parts	Weight(g)	Product	Parts	Weight(g)
P44	100	1633	P44	100	1633
C100	50	501.3	C100	15	150.39
H050/H060	50	513.4/490	H050/H060	32.5	333.76/ 318.5
S19/ S11	5.0- 25.0	64.0-348.	S19/ S11	5.0- 25.0	49.0- 266.5

	15-20°C				20-25°C				25-30°C				+30°C			
	Thinner S11				Thinner S21				Thinner S21				Thinner S40			
	Hardener	Time to Sanding			Hardener	Time to Sanding			Hardener	Time to Sanding			Hardener	Time to Sanding		
		20°C	60°C	IR		20°C	60°C	IR		20°C	60°C	IR		20°C	60°C	IR
Full Paint	H050	2.5 HRS	20 MINS	15 MINS	H050	2.5 HRS	20 MINS	15 MINS	H060	2.5 HRS	20 MINS	15 MINS	H070	2.5 HRS	20 MINS	15 MINS
Vertical Areas	H050	2.5 HRS	20 MINS	15 MINS	H050	2.5 HRS	20 MINS	15 MINS	H050 H060	2.5 HRS	20 MINS	15 MINS	H070	2.5 HRS	20 MINS	15 MINS
Fast Repair	H020 H050	2.5 HRS	20 MINS	15 MINS	H020 H050	2.5 HRS	20 MINS	15 MINS	H050	2.5 HRS	20 MINS	15 MINS	H070	2.5 HRS	20 MINS	15 MINS
soft plastics 30%-810 Plasticizer	H050	3.5 HRS	30 MINS	N/A	H020 H050	3.5 HRS	30 MINS	N/A	H050 H060	3.5 HRS	30 MINS	N/A	H070	3.5 HRS	30 MINS	N/A

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

# P44 - 2K Rapid Primer Black



Hard plastics	H050	3 HRS	25 MINS	N/A	H020	3 HRS	25 MINS	N/A	H050	3 HRS	25 MINS	N/A	H070	3 HRS	25 MINS	N/A
15%-810 Plasticizer					H050				H060							

## Wet on wet

Ratio :

<b>100%</b>	<b>100%</b>	<b>75%</b>	<b>30%</b>
Primer : P44	Clear :C061 or C061R	Hardener : H060	Thinner : S11

**Application:** 1 light coat followed by 1 full. No flash off in between.

**Flash off:** 30 minutes before application of topcoating

**Spray gun:** 1.3—1.4 mm needle size

## Product Characteristics

**VOC(2004/42/EC):** 2004/42/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.

<b>Specific Gravity:</b>	P40 = 1633 g/L (13.63 lbs/gal)	P44 = 1630 g/L (13.6 lbs/gal)
	P42 = 1633 g/L (13.63 lbs/gal)	P45 = 1633 g/L (13.63 lbs/gal)
	P43 = 1465 g/L (12.22 lbs/gal)	P46 = 1487 g/L (12.41 lbs/gal)

**Flash Point:** 20-25°C (77°F)

**Solid Content:** ±67.8 % by weight – ready to spray

**Coverage:** 5.7-5.8 m2/l at 80-micron film thickness (theoretical)

**SDS:** Refer to the Safety Data Sheet

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