

CP 394

Epoxy primer filler HS 1:1

Epoxy primer is a perfect basis for all popular car body paints.

It has outstanding filling power.

It can be used on raw and zinc-coated sheets of metal as well as hard polymers.



Filling:	●●●●○
Paint fluidity:	●●●●○
Steel adhesion:	●●●●○
Aluminum adhesion:	●●●●○
Plastic adhesion:	●●●○
Grinding facility:	●●●○

Unit	Packaging	Available colors
800 L + 800 L (hard.)	Collective (box) 6 pcs + 6 pcs	●



100 parts of CP 394 HS,
100 parts of hardener CP 294 HS,
10-30 parts of thinner CP 040 (for wet-on-wet technique)

Surface preparation:

Cleansing with silicone remover CP 015, matt old coatings with P240 sanding paper, steel P180-P240, aluminum and galvanized steel - maroon nonwoven.

Spray viscosity in 20°C:

16-22 s DIN Cup 4 mm

Pot life:

6 h

Recommended sizes of paint strainers:

190 µm (wet-on-wet 125 µm)

Output:

~8-10 m²/l (layer 40-50 µm)

Thickness of dry coating:

~40-80 µm

VOC:

2004/42/WE/II(b)(c)(540) 540

Sanding

Dry: P400 - P500. Wet: P600 - P1000

Date of minimum durability:

CP 394: 24 months (in the original unopened package)
 CP 294: 12 months (in the original unopened package)



One full layer - for isolation. Two full layers for filling.
 Spray gun*: Gravity nozzle: **1,2-1,9 mm**; pneumatic: **1,6-1,8 mm**. For wet-on-wet: **1,3-1,4 mm**. Operating pressure - high pressure: **3-4 bar***; HVLP: **2 bar***.

* Use high pressure equipment and HVLP. Pressure as recommended by the gun manufacturer.



Evaporation between the layers (20°C, 65% H.R.): **5-10 min.**



Drying time 20°C, 65% H.R.: **3 h**
 Drying time 60°C, 65% H.R.: **30 min**

* Tests with CP 294 hardener.



Drying IR: **~10-15 min**

The recipe of the product complies with the VOC guidelines. The products supplied by our company are subject to a number of factory tests, so they can meet the highest demands. However, be aware of the individual conditions of storage, preparation and applications that can influence on the effect of varnishing. The guarantee to keep the highest quality of the coating is to use the product only with the products of the Manufacturer and in accordance with the recommendations of the Manufacturer. The Manufacturer does not guarantee performance and compatibility of the Products with products other than those of the Manufacturer. In order to recognize the guarantee and all claims, the user shall use the technologies and techniques for given Products - according to the technical data sheet and execute the sample spray prior to target painting.