



P420 2K VOC Primer Grey

HYFLASH

Description:

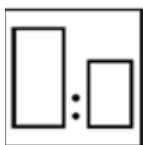
HyFlash P420 is a VOC High Build Air-Dry 2K Primer with excellent filling properties and sandability. It is recommended for high performance bodyshops focusing on efficiency, space utilization and cost reduction with no compromise on premium quality.
(Available in White - P424 and Dark grey - P426)

Hyflash P420 is easy to sand within 1 hour from application. It maintains an excellent gloss holdout when topcoated with any Hymax topcoating 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:

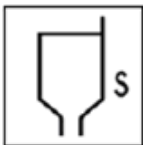
- Old and Sound thermoset topcoats.
- Hymax polyester fillers.
- Sound OEM.



Mix 100 : 25 : 5-25% with H050, H060 General Hardener and Thinner

100%	25%	5--25%
P420	H050 FAST HS HARDENER	S19 THINNER*
P420	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



3-5 minutes between coats
2-3 coats
45-50 microns/coat
2.0 – 2.2 bar inlet pressure

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



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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 the film thickness

Important note : below 15°C
Do not air-dry
Low bake 5-10 minutes @ 60°C panel temperature



5 Minutes at 60°C (140 °F) 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.**



Wear suitable protection

VOC (2004/42/EC):

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/cm³
P424 (White) = 1.637 kg/cm³
P426 (Dark Grey) = 1.493 kg/cm³

Flash Point:

25°C (77°F)

Solids Content:

Approx. 62.5% - 67.5% by weight RFU, depending on reduction ratio

Coverage:

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

SDS:

Refer to the safety data sheet