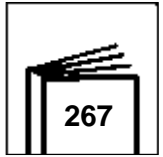




HP MULTIPRIME 1.841.9101 - 9104 - 9106

HP MULTIPRIME, WHITE (9101) GREY (9104) DARK GREY (9106) (9106)



HP MULTIPRIME is a multipurpose primer designed to be used over a wide range of substrates. The excellent application and the flow properties of **HP MULTIPRIME** will give the same holdout and appearance of a sandable primer.

New panels in electrocoat, when in sound condition, do not require any sanding before the application of **HP MULTIPRIME**, and can be held up to 5 days before topcoating.

HP MULTIPRIME is designed to be used under AQUAMAX® and UHS Duralit Extra®.

SUBSTRATES



HP MULTIPRIME can be applied over:-

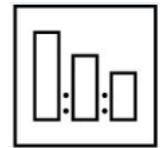
- New panels in good quality electrocoat, without sanding.
- GRP and Fibre glass prepared with P120/P240 and finished with P320.
- Polyester filler prepared with P120/P240 and finished with P320.
- Original finishes in sound condition, after sanding with P400 Dry.
- Bare Plastic Substrates that have been prepared according to TDS 228V and 499V

Note: A 2-pack Etch Primer should be applied prior to the application of HP MULTIPRIME for areas of bare metal.

PREPARATION



Clean the surface with water (preferably warm) and detergent. Clean using a suitable Precleaner prior to painting. Bare metal areas may be degreased using Degreaser 3600.



	Volume	Weight in Grams
HP MULTIPRIME	2	1000
Hardener	1	340
Thinner	0.5	140
Application Viscosity - DIN4 at 20°C	16 - 18 seconds	
Pot Life	1 hour @ 20°C	

HARDENERS - THINNERS

HARDENER	1.954.400	Slow	For all repairs
THINNER	1.921.6051	Catalyst Thinner	Repairs below 25°C
ADDITIVE	1.921.6041	HP Plastic Additive	For painting of plastic parts



HP MULTIPRIME 1.841.9101 - 9104 - 9106

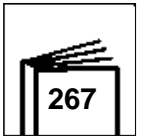
APPLICATION

CYCLE

Equipment	<i>Conventional or Compliant Sprayguns</i>	
Fluid Tip (mm)	1.2 - 1.3 mm	
Spray-Gun pressure (bar)	2 bar - or as per manufacturers recommendations	
Number of coats	1 full coat or 1 visit application*	
Recommended thickness	25 - 30 microns	
Maximum thickness	30 microns	

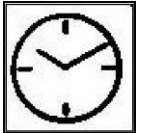
Apply to achieve an even finish. Do not apply heavy coats.

* 1 light and 1 full



DRYING

Dry time before topcoat	25 minutes
Interval between coats	None
Can be used as a Primer filler applying 1 light coat +2 full to achieve 90-110 microns	
Dry to sand @ 60°C.	30 minutes
Dry to sand with IR (Short Wave)	5 minutes flash and 10 minutes cure
For use with IR use slowest mixing ratio	



OVERCOATABILITY

HP MULTIPRIME can be directly overcoated with either Aquamax or UHS Duralit Extra.

RECOAT TIME

- Minimum 15 minutes @ 20°C
- If left more than 8 hours – preclean before topcoating.
- After 3 days - light denibbing and precleaning is required when used as standby/holding primer to prevent any workshop contamination from the environment affecting the topcoat performance.
- After 5 days – panels should be fully sanded & precleaned prior to topcoat

PLASTIC RECOMMENDATIONS

HP MULTIPRIME can be applied directly over well prepared and cleaned ABS, NORYL, PC/PBT, LEXAN, PUR AND SMC, as well as sanded and pre-primed bumpers.

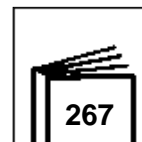
Bare plastic sections or rub through areas on bumpers, e.g. PP, TPO, PP/EPDM should be activated normally and thinned with 1.921.6041 HP Plastic Additive for Primer.



HP MULTIPRIME 1.841.9101 - 9104 – 9106

MIXING MULTIGREY SHADES

% by weight	M1	M3	M4	M5	M6
1.841.9101	100	75	--	--	--
1.841.9104	--	25	100	48	--
1.841.9106	--	--	--	52	100



WEIGHT TABLE

PAINT VOLUME (L)	0.20 L	0.40 L	0.60 L	0.80L	1.0 L
Primer	165	331	497	663	829
Hardener	222	443	665	887	1109
Thinner	245	490	735	981	1226
PAINTING PLASTICS					
Primer	165	331	497	663	829
Hardener	222	443	665	887	1109
Plastic additive	247	494	740	987	1234

TECHNICAL DATA

Pack size 1.841.9101-9106: E1, 1.841.9104: E1/E3
 Storage In a cool dry place away from heat



HEALTH AND SAFETY

These products are for professional use only and are not to be used for purposes other than those specified.

The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information, please refer to the material Safety Data Sheet, also available at: www.maxmeyer.com



For further information please contact:
 PPG Industries (UK) Limited. MaxMeyer Division Customer Service & Sales Group, Needham Road,
 Stowmarket, Suffolk. IP14 2AD, England. Tel: 01449 771779 Fax: 01449 773495

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