CP 394

Available colours

Epoxy primer 2K HS 1:1

Due to its premium-grade resins, the **CP 394** primer delivers exceptional corrosion protection for steel surfaces. Notably, it exhibits excellent adhesion across diverse substrates, including steel, galvanized steel, aluminum, glass reinforced plastic, and existing paint coatings. Functioning both as a robust covering and filling primer, **CP 394** also supports wet-on-wet application.

Available in 0.8-Litre tins, it offers versatile application options and reliable protective properties.

PACKAGING	
Volume	Collective packaging
0.8 l + 0.8 l (hardener)	6 pcs. + 6 pcs.

- VERY GOOD ADHESION
- INSULATING PROPERTIES
- WET-ON-WET APPLICATION
- CORROSION PROTECTION
- SUPERB COAT TIGHTNESS

WET-ON-WET
One coat, next coat application, film thickness **20-30 µm**

SPRAY VISCOSITY
16-22 sec. DIN Flow Cup **4 mm**

RECOMMENDED SIZES FOR PAINT STRAINER
190 µm (wet-on-wet **125 µm**)

PAINT EFFICIENCY
8-10 m²/l

POT LIFE
1 hrs

DRY FILM THICKNESS
- **1** coat - **20-40 µm**
- **2** coats - **40-80 µm**

WET SANDING
P600->P800->P1000

DRY SANDING
P280->P400

MINIMUM SHELF LIFE
CP 394: 24 months in originally sealed packaging
CP 294: 12 months in originally sealed packaging

VOC
LZO VOC
2004/42/WE IIB(c) (540) 540

PROCESS

PROGRESS

SUBSTRATE PREPARATION
Abrade substrate using a red **P300-400** abrasive pad by hand for steel, galvanised steel or grey abrasive pad for aluminium. Alternatively, **P180-P240** sanding disc using orbital sander. Remove dust particles before cleaning substrate with **CP 015**. After the substrate is clean and dry apply **CP 394** with the required number of layers, taking note of the recommended evaporation time between coats. Bake or airdry before progressing to the next step of the process

MIXING RATIO
1:1
100 parts of **CP 394**
100 parts of **CP 294** hardener
The wet-on-wet method requires
10-30% of thinner
CP 040/ CP 070/ CP 055/ CP 075

SPRAY GUN SETTINGS
Nozzle **1.6-1.8 mm**;
Operating pressure: HVLP/RP **1.8-2.0 bar**
Wet-on-wet method:
Nozzle size HVLP/RP **1.3-1.4 mm**;
Operating pressure: **1.8-2.0 bar**

APPLICATION
2 full coats (filling primer)
1 full coat including **10-30%** thinner (insulator)

EVAPORATION TIME AFTER APPLICATION
5-10 min. after priming at **20°C** and **65%** relative humidity
Evaporation continues until a matt surface is visible

DRYING
Drying times at **20°C** and **65%** relative humidity:
- dust dryness: **10 min** (2 coats)
- before sanding: **3 hrs**

Drying times at **60°C** and **65%** relative humidity:
- before sanding **30 min**