

# P542 – 2K Wet on Wet Primer



## Product Description

P542 is a VOC compliant Wet on Wet primer with excellent application and adhesion properties. It offers outstanding flow with minimal overspray and ensures excellent gloss retention for the final finish.

P542 can be easily overcoated with all HYMAX Basecoats and Topcoats, allowing for a one-visit application process.

Moreover, when used with A230, it enables direct-to-plastic application.

## Suitable Substrates:

- Existing Finishes except TPA.
- OEM Primer or EDP, sanded.
- Well sanded and finished body filler.
- Bare metal substrates must be pre-primed with Wash Primer P97.

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## Extra Comments

Stir well before mixing.

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## Product Application



| 100% | 50%                  | 20-30%  |
|------|----------------------|---|
| P542 | H055<br>H066<br>H077 | S19<br>S11<br>S21<br><i>(Max 20% for VOC)</i> |



17 – 20 secs / DIN 4 mm / 20 °C (68 °F).

Pot life 2hrs / 20 °C (68 °F).



2.0 – 2.5 bar air pressure.

HVLP 1.3-1.5 mm

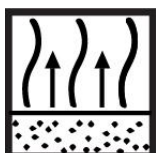
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Apply 1 full single coat 25 – 30 microns.  
0.5 + 1 coat if applying over a small area of body filler on vertical panels  
Note: Not recommended for spot repairs on flat panels.



20-30 mins at 20 °C (68 °F).  
Note: After 60 mins, light sanding of primer is recommended before top-coating.



Normally wet on wet primers do not require flattening and can be directly top-coated. If some dirt inclusions occur, dry light flattening/denibbing can be carried out after 30 mins using P1200 or finer flattening papers.



Hyflow T-series & Hyflow B-series  
Hydrobase Basecoat



Wear suitable protection and for more information on safety, check the product's Safety Data Sheet.

## P542 Primer on Plastic Direct

With the addition of A230 P542 can be applied direct to plastics without the need for a 1K plastic adhesion promoter (plastic primer).



Process Notes

| 100% | 15%                   | 50%                  | 20-30%  |
|------|-----------------------|----------------------|---|
| P542 | A230 Plastic Additive | H055<br>H066<br>H077 | S19<br>S11<br>S21<br><b>(Max 20% for VOC)</b> |

All other processes remain the same as per the P542 TDS sheet on application, drying and sanding.

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## **Product Characteristics**

|                          |   |
|--------------------------|---|
| <b>VOC (2004/42/EC):</b> | 2004/42/IIB (c) (540)538. The EU limit value for this product (product category IIB.c) in ready to use form is max 538 g/l. The VOC content of this product in ready to use form is max. 540 g/l. |
| <b>Specific Gravity:</b> | 1.338 kg/cm <sup>3</sup> .  |
| <b>Flash Point:</b>      | 20-25°C (77 °F).  |
| <b>Solid Content:</b>    | 68.1 % by weight.   |
| <b>Coverage:</b>         | 5-6 m <sup>2</sup> /l (theoretical).  |
| <b>SDS:</b>              | Refer to the Safety Data Sheet  |

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