



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

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



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 hardener **CP 294**
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**

PROCESS

PROGRESS