



# 320 ZINC FILL

Technical Data Sheet No 124

2K Acryl based Primer for direct to metal application

Ideal for metal protection against corrosion

Excellent adhesion to galvanized steel and aluminium. Overcoatable with any coating system.

Excellent physical properties

VOC compliant with the regulations

## General Technical Description



Mix 4:1 with H729 HARDENER FOR PRIMERS NORMAL

No Thinner / Reducer addition



30-60min @23°C (73°F)  
10 min / 60°C (140°F)  
panel temperature



3-5 min

## Surface

Applied on sanded metallic surfaces

Aluminium surfaces

Galvanized steel

Bare metal surfaces

## Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER

Make sure the surface is first wiped dry and then air dried



Make sure you always use appropriate face protection and good ventilation

**Product Application:** As 2K Acryl based adhesion primer 2 passes »» Apply one coat, and after 10 min flash off time apply the second coat. Apply over sanded areas or direct to metallic surfaces. After drying it can be overcoated.



4:1 mix with H729 Hardener For Primers Normal  
Pot life: 2h @ 23°C (73°F)



Short wave 3 – 5 min  
distance: 60-70 cm



No Thinner / Reducer addition



P 1000  
Sanding by hand, wet



Ready to spray:  
24 s  
DIN 4 / 20°C (68°F)



BODY Polyester Putty



Compliant Spray gun  
1.5 – 1.8 mm  
2 - 2.5 bar (29 - 36 psi)  
inlet pressure  
2x coats = 20-35 µm  
(0.8-1.4mil)



- HB BODY Polyester Spray Fillers
- HB BODY 2K Filling Primers



HVLP Spray gun  
1.5 – 1.7 mm  
1.5 - 2 bar (22-29psi)  
inlet pressure  
2x coats = 20-35 µm  
(0.8-1.4mil)



Always wear protective equipment



10 min / 23°C (73°F)  
Flash off time



Follow the application instructions mentioned in this TDS



30-60min / 22-25°C  
(68 - 77°F)  
10min / 60°C (140°F)  
panel temperature

**Flash Point:**  
26°C / 79°F

**Specific Gravity:**  
1.20 g/cm<sup>3</sup>

**Solid Content (No thinner):**  
62% Weight

**VOC (2004/42/EC)**  
This product is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 540 g/L. The VOC content in the ready for use form of this product is 490 g/L.  
2004/42/II(c)(540)490

**Theoretical Coverage:**  
8-10 m<sup>2</sup> / l at 20micron (0.8mil)  
dry film thickness

**Cleaning of equipment:**  
Clean after final use with  
740 ACRYL NORMAL THINNER /  
REDUCER

### Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and thinners / reducers
- It can be used by countries that do not adopt the VOC legislation as well.
- Do not use at temperatures below 15°C (59°F).

### Storage Shelf life:

- Store in a cool place (+5°C - 25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers

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