



980 1K FILLING PRIMER

Technical Data Sheet No 106

1K NC system sanding primer
Excellent filling properties
Excellent mechanical properties
Easy to sand

General Technical Description



Mix 2:1 with 740
ACRYL NORMAL or
741 ACRYL SLOW or
767 ECO-THINN NITRO
THINNER / REDUCER



10 min / 60 - 65°C
(140 - 149°F)
panel temperature
2h / 23°C (73°F)



3 - 5 min
distance 60 - 70 cm

Surface

On old, sanded paint work
Clean and sanded steel panels
HB Body Polyester Fillers

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 sanding primer

2 passes »» Apply in thin layers over sanded areas only



2:1 mix with 740
ACRYL NORMAL or
741 ACRYL SLOW or
767 ECO-THINN NITRO
THINNER / REDUCER



3 - 5 min
distance: 60 - 70cm



Ready to spray:
27-29 s
DIN 4 @ 20°C (68°F)



P 320 - P 500
Random orbital sander



Compliant Spray gun
1.5 - 1.8 mm
2 - 2.5 bar (29 - 36 psi)
inlet pressure
2x coats = 80 - 120 µm
(3.2-4.7mil)



P 600 - P 1000
Flat bed sander



HVLP 1.5 - 1.7 mm
1.5 - 2 bar (22-29psi)
inlet pressure
2x coats = 80 - 120 µm
(3.2-4.7mil)



It can be painted over with
HB BODY Color Solutions
Basecoat Mix System
HB BODY Color Solutions
2K Acrylic Mix System
HB BODY Color Solutions
Aquabase Mix System



5 - 10 min / 23°C (73°F)
Final flash off time



Always wear
protective equipment



30 min / 23°C (73°F)
10 min / 60°C - 65°C
(140°F - 149°F)
panel temperature



Follow the application
instructions mentioned
in this TDS

Flash Point:
11°C / 52°F

Specific Gravity:
1.25 g / cm³

Solid Content (No thinner):
64% Weight

VOC (2004/42/EC)
-

Theoretical Coverage:
7 - 8 m² / l at 50 micron (2.0mil)
dry film thickness

Cleaning of equipment:
Clean after final use with
BODY 767 ECO NITRO THINNER
/ REDUCER

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended thinners / reducers
- It should only be used by countries that do not adopt the VOC legislation when applied in this ratio
- 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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