



305 4:1 FILLING PRIMER

Technical Data Sheet No 141

2K Acrylic system sanding primer

Excellent filling properties

Excellent mechanical properties

Easy to sand

VOC compliant with the regulations

General Technical Description



Mix 4 parts 305 PRIMER with H 725 HARDENER FOR PRIMERS

Thinner / Reducer addition 10-20%: 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



30 min / 60°C (140°F) panel temperature
2-3h / 23°C (73°F)



8-12 min distance 60-70 cm

Surface

On old, sanded paint work

OEM surfaces

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body Wash Primer

P961 Etch Primer

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 a sanding Primer

2 coats. Apply one full coat, and after 10 min flash off time apply the second full coat.



4:1 mix with H 725 HARDENER FOR PRIMERS
Pot life: 60min @ 23°C (73°F)



80-120 µm (3.2-4.7mil)
2-3h / 23°C (73°F)
30min / 60°C (140°F) panel temperature

Flash Point:
25°C / 77°F

Specific Gravity:
1.58 g/cm³



Addition 10-20% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Short wave 8 - 12 min distance 60-70 cm

Solid Content (No thinner):
75% Weight



Ready to spray:
21 - 31 s
DIN 4 @ 20°C (68°F)



P 320 - P 500
Flat bed sander

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 460 g/L.
2004/42/II(c)(540)460



Compliant Spray gun
1.5 - 1.8 mm
2 - 2.5 bar (29 - 36 psi) inlet pressure
2x coats = 100 - 120 µm (4 - 4.7mil)



P 600 - P 1000
Sanding by hand, wet

Theoretical Coverage:
5 - 6 m² / l at 80 micron (3.2 mil) dry film thickness



HVLP Spray gun
1.5 - 1.7 mm
2 bar (29 psi) inlet pressure
2x coats = 100 - 120 µm (4 - 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
Aquadase Mix System

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



10 min / 20 - 23°C (68°F - 73°F)
Flash off time



Always wear protective equipment
Follow the application instructions mentioned in this TDS

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 to 25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.

2K paint systems tend to react with water, hence all the equipment used must be moisture free. Isocyanates may cause skin sensitization. More specifically, care should be taken when handling the material. Anyone with a history of histaminic conditions, or respiratory problems should consult the doctor first.

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