

# **305 4:1 FILLING PRIMER**

Technical Data Sheet No 141

2K Acrylic system sanding primer

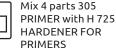
Excellent filling properties

Excellent mechanical properties

Easy to sand

VOC compliant with the regulations





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



8-12 min distance 60-70 cm

80-120 µm (3.2-4.7mil)

distance 60-70 cm

# 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)



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



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



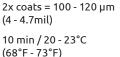
Compliant Spray gun 1.5 – 1.8 mm 2 - 2.5 bar (29 - 36 psi) inlet pressure 2x coats = 100 - 120 µm

(4 - 4.7mil) HVLP Spray gun

1.5 – 1.7 mm 2 bar (29 psi) inlet pressure 2x coats = 100 - 120 µm

Flash off time





Follow the application



instructions mentioned in this TDS

2K paint systems tend to react with water, hence all the equipment used must be moisture free. Isocvanates 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.

For professional use only. The information displayed on this sheet has been carefully selected through a series of laboratory investigations. It is based on our best knowledge at the time of issue. The data is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check for newer updates or further information if needed for his intended purpose. The intellectual property of this product, trademarks and copyrights is protected. All rights reserved. The relevant Material Safety Data Sheet and warnings displayed on the label must be read carefully. We may modify and / or discontinue operation of all or portions of this information at any time in our sole discretion, without any notice and assume no responsibility to update the information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

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## 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

 Allow for additional time for combi spray booths to reach the

• 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:

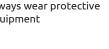
 Store in a cool place (+5°C to 25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.

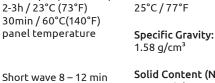
HB BODY S.A. AUTO REFINISHING PRODUCTS, GREECE www.hbbody.com

#### 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

equipment





Surface

OEM surfaces

Fiberglass

On old, sanded paint work

Thermoplastic Coatings - TPA

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body Wash Primer

P961 Etch Primer

Flash Point:

Solid Content (No thinner): 75% 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 460 g/L. 2004/42/IIB(c)(540)460

Theoretical Coverage:

5 - 6 m<sup>2</sup> / l at 80 micron (3.2 mil) dry film thickness

Cleaning of equipment:

P 320 – P 500 Flat bed sander P 600 - P 1000 Sanding by hand, wet

Always wear protective

Clean after final use with 740 ACRYL NORMAL THINNER / REDUCER

Remarks:

