



300 3:1 FILLING PRIMER

Technical Data Sheet No 117

2K Acrylic system sanding primer

Excellent filling properties

Excellent mechanical properties

Easy to sand

VOC compliant with the regulations

General Technical Description



Mix 3 parts 300 FILLING PRIMER with 1 part H 725 HARDENER FOR PRIMERS

Thinner / Reducer addition
15%: 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



20-30 min / 60°C (140°F) panel temperature
2 - 3/23°C (73°F)



8-12 min distance: 60 - 70cm

Surface

OEM surfaces

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body Wash Primer

961 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 passes »» Apply one coat, and after 10 min flash off time apply the second full coat.



3:1 mix with H 725 HARDENER FOR PRIMERS
Pot life: 45 min @ 23°C (73°F)



100-120µm (4 - 4.7 mil)
2 - 3h / 23°C (73°F)
20-30min / 60°C (140°F) panel temperature

Flash Point:
25°C / 77°F

Specific Gravity:
1.50 g/cm³

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature



Addition 15% of 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Short wave 8 – 12 min
Lamp distance:
60 - 70cm

Solid Content (No thinner):
74% Weight

- Application only with the recommended hardeners and thinners / reducers



Ready to spray:
22-24 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 495 g/L.
2004/42/IIB(c)(540)495

- It can be used by countries that do not adopt the VOC legislation as well.



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



P 600 – P 1000
Sanding by hand, wet

Theoretical Coverage:
5-6 m² / l at 100micron (4 mil) dry film thickness

- Do not use at temperatures below 15°C (59°F).



HVLP Spray gun
1.5 – 1.7 mm
1.5 - 2 bar (22 - 29 psi) inlet pressure
2x coats = 100-120 µm (4 - 4.7 mil)



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

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

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



10 min / 23°C (73°F)
Flash off time



Always wear protective equipment



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. 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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