

**TECHNICAL DATA SHEET No 129** 





# **BODY 635** 5:1 HS FILLING PRIMER

## **GENERAL TECHNICAL DESCRIPTION**

2K acrylic system sanding primer

Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter

**Excellent filling properties** 

Excellent mechanical properties even on plastic bumpers

Easy to sand

## **SURFACE**

On old, sanded paint work Unsanded cataphoresis OEM panels (E-COAT)

Fiberglas

Clean and sanded steel panels HB BODY Polyester Fillers

**HB BODY Wash Primer** 

P961 Etch Primer

Over new and used plastic bumpers, properly degreased.

## 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.

## **PRODUCT APPLICATION: As sanding primer**



Mix 5 parts PRIMER with 1 part BODY 635 HARDENER FOR PRIMERS Pot life: 55 - 70 min / 23°C (73°F)



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



Ready to spray: 30 - 40 sDIN 4 /  $20^{\circ}\text{C}$  ( $68^{\circ}\text{F}$ )



Compliant spray gun 1.5-1.8 mm 2-2.5 bar (29-36 psi) 2x coats = 120-150  $\mu$ m (4.7-5.9 mil)



1.5 – 1.7 mm 1.5 - 2 bar (22 - 29 psi) 2x coats = 120 - 150 μm (4.7 - 5.9 mil)



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



1 - 2 h / 23°C (73°F) 20 - 30 min / 60°C (140°F) panel temperature



Short wave 5 – 8 min distance 60 - 70 cm



P 400 - P 500



P 600 – P 1000 Sanding by hand, wet



It can be painted over with all HB BODY Mix Systems.

# PRODUCT APPLICATION: For plastic parts (PE - PP - ABS - TSOP etc)

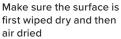
Direct application without the need of an adhesion promoter



Dry sanding P 180 - P 220 (never with a scotch brite)



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





Mix 5 parts PRIMER with 1 part BODY 635 HARDENER FOR PRIMERS Pot life: 55 - 70 min / 23°C (73°F)



Addition 50 - 60% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 15 - 19 s DIN 4 / 20°C (68°F)



Compliant spray gun 1.3-1.4 mm 2-2.5 bar (29-36 psi) 2-3x coats = 60-80  $\mu$ m (2.3-3.1 mil)



1.3 – 1.4 mm 1.5 - 2 bar (22 - 29 psi) 2 - 3x coats = 60 - 80 μm (2.3 - 3.1 mil)



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



1 - 2 h / 23°C (73°F)



P 400 - P 500



P 600 – P 1000 Sanding by hand, wet



It can be painted over with all HB BODY Mix Systems



## **BODY 635 5:1 HS FILLING PRIMER**

#### **FLASH POINT**

26°C / 79°F

## **SPECIFIC GRAVITY**

1.58 g/cm<sup>3</sup>

#### **SOLID CONTENT**

(NO THINNER) 73% Weight

#### VOC (2004/42/EC)

This 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 540 g/L. 2004/42/IIB(c)(540)540

#### THEORETICAL COVERAGE

 $6\ m^2$  / I at 120 micron (4.7 mil) 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
- · Do not use at temperatures below 15°C (59°F)

#### Caution:

Always check with a cloth and thinner if the panel is an OEM (E-COAT) panel. On OEM (E-COAT) panels, the cloth stays clean. Then clean the surface with 770 ANTISIL NORMAL

## 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



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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