



BODY 605 4:1 FILLING PRIMER

Technical Data Sheet No 135

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 605 PRIMER with 625 HARDENER FOR PRIMERS



Thinner / Reducer addition
10-15%: 740 ACRYL NORMAL / 741 ACRYL SLOW THINNER / REDUCER



30 min / 60°C (140°F) panel temperature
2.5 -3h / 23°C (73°F)



5-8 min distance: 60-70 cm

Surface

On old, sanded paint work

OEM surfaces

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body Wash Primer

P 961 1K 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:

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



4:1 mix with 625 HARDENER FOR PRIMERS
Pot life: 120min @ 23°C (73°F)



100 - 140 µm (4 - 5.5 mil)
2.5 -3h / 23°C (73°F)
30min / 60°C (140°F) panel temperature

Flash Point:
32°C / 90°F

Specific Gravity:
1.58 g/cm³



Addition 10-15% 740 NORMAL or 741 SLOW ACRYLIC THINNER / REDUCER



Short wave 5 – 8 min distance 60-70 cm

Solid Content (No thinner):
78% Weight



Ready to spray:
26 - 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

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



Compliant Spray gun
1.5 – 1.8 mm
2 - 2.5 bar (29 - 36 psi) inlet pressure
2x coats 100 - 140 µm (4 - 5.5 mil)



P 600 – P 1000
Sanding by hand, wet

Theoretical Coverage:

5 - 6 m² / l at 120 micron (4.7mil) dry film thickness



HVLP Spray gun
1.5 – 1.7 mm
1.5 - 2 bar (22-29 psi) inlet pressure
2x coats 100 - 140 µm (4 - 5.5 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



8 - 10 min / 20 - 23°C (68°F - 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.

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.