BODY PRO P 980 1K FILLING PRIMER

Technical Data Sheet No 107



VOC compliant with the regulations

1K NC system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties

Fast drying

General Technical Description

Mix 4:1 with BODY 740 ACRYLIC THINNER NORMAL

Oven force drying 10 min / 60-65°C panel temperature

Air dry 30min / 22-25°C

IR drying 3-5 min

Surface

On old, sanded paint work

OEM surfaces

Clean and sanded steel panels

HB Body Polyester Fillers

Pretreatment / Cleaning of substrate

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

Make sure the surface is air dried rather than wiped dry

Make sure you always use appropriate face protection and good ventilation

Product Application: As an HS sanding primer

2 passes »» Apply in thin layers over sanded areas only.

4:1 mix with BODY 740 ACRYL NORMAL

25 % BODY 740 ACRYL NORMAL

Ready to spray:
30-35s - Cup 4 @23°C
- DIN 53211

Compliant Spray gun
1.3 – 1.8 mm
3-4 bar inlet pressure
2x coats = 80-120 micron

HVLP Spray gun 1.5 – 1.7 mm
0.7 bar inlet pressure
2x coats = 80-120 micron

3-5 min / 20-22 °C
Final flash off time

Non force dry -
30min / 22-25°C
10min / 60-65°C panel temperature

Short wave 3 – 5 min

P 320 – P 500
Random orbital sander

P 600 – P 1000
Flat bed sander

2K Autoemail Acrylic Paint SR
HB BODY Basecoat
HB BODY UHS Clears

Always wear protective equipment

Follow the application instructions mentioned in this TDS

Flash Point:
14°C / 57°F

Specific Gravity:
1.28 g/cm³

Solid Content (No thinner):
56% Weight

VOC (2001/42/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 535 g/L.
2004/42/IIB(c)(540)535

Theoretical Coverage:
8 m² / l at 50micron dry film thickness

Cleaning of equipment:
Clean after final use with Body 740 ACRYL NORMAL

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and solvents
- It can be used by countries that do not adopt the VOC legislation as well.
- Do not use at temperatures below 15°C.
- Do not apply the primer as 'wet on wet' on TPA surfaces

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