



BODY PRO P 335 5:1 HS 2K PRIMER

Technical Data Sheet No 103

Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter (#340 Plastofix)

VOC compliant with the regulations

2K Acrylic system sealing primer

Excellent filling properties

Easy to sand

Excellent mechanical properties even on plastic bumpers

General Technical Description



Mix 5 parts BODY PRO P335 PRIMER with BODY PRO H 725 HARDENER FOR PRIMERS

Thinner addition 15 - 20% BODY 740 ACRYLIC THINNER NORMAL

Oven force drying – 20-30 min / 60°C panel temperature

Air dry 1 - 1.5h / 23°C



IR drying 8-12 min distance 60 - 70cm

Surface

On old, sanded paint work

Unsanded cataphoresis OEM panels (E-COAT)

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body 960 Wash Primer

Bodyfill 961 Etch Filling Primer

Over new and used plastic bumpers

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 one coat, and after the 10 - 15 min flash off time apply the second full coat.



5:1 mix with BODY PRO H 725 HARDENER FOR PRIMERS
Pot life: 50 min @23°C (73°F)



Non force dry
100-120 µm
1 - 1.5h / 23°C
20-30 min / 60°C panel temperature



Addition 15 - 20% of thinner.
Use BODY 740 NORMAL ACRYLIC THINNER



Short wave 8 – 12 min
distance 60 - 70cm



Ready to spray:
27 - 34 s
DIN 4 @ 20°C



P 400 - P 500
Flat bed sander



Compliant Spray gun 1.5mm – 1.8 mm
3-4 bar inlet pressure
2x coats = 100-120 µm



P 600 – P 1000
Sanding by hand, wet



HVLP 1.5mm - 1.7 mm
2 bar atomization pressure



Always wear protective equipment



Follow the application instructions mentioned in this TDS



10 - 15 min / 23°C
Final flash off time

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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Issue 3/2015, November 2015



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Technical Data Sheet No 103

Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.)

1 - 2 passes »» Apply one coat, and after the 5 - 10 min flash off time apply the second full coat.



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



5 - 10 min / 23°C
Flash off time



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



Non force dry
1h / 23°C

Make sure the surface is air dried rather than wiped dry



Make sure you always use appropriate face protection and good ventilation



P 400 – P 500
Flat bed sander



5:1 mix with BODY PRO H 725 HARDENER FOR PRIMERS Pot life: 55-70 min @23°C (73°F)



P 600 – P 1000
Sanding by hand, wet



Addition 50 - 60% of thinner. Use BODY 740 NORMAL ACRYLIC THINNER/741 SLOW ACRYLIC THINNER



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



Ready to spray:
17 - 19 s
DIN 4 @ 20°C



Always wear protective equipment



Compliant Spray gun 1.8 mm
3 - 4 bar inlet pressure
1 - 2 coats = 30 - 35 micron



Follow the application instructions mentioned in this TDS



HVLP Spray gun
1.8 mm
2 bar inlet pressure

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Product Application: As "wet on wet" primer

1 pass »» Apply 1 coat of (20-30µm) and 20-30 minutes after the application we can paint and clear coat as usual.



5:1 mix with BODY 720
NORMAL HARDENER
Pot life: 45 min
@23°C (73°F)



10 min / 23°C
Final flash off time

Flash Point:
26°C / 79°F

Specific Gravity:
1.52 g/cm³

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 480 g/L.
2004/42/II(b)(c)(540)480

Theoretical Coverage:
6 m² / l at 120 micron 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

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 and the "wet on wet" procedure is followed without sanding prior to primer

Storage Shelf life:

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



Addition 50 -60% of thinner. Use BODY 740 NORMAL ACRYLIC THINNER / 741 SLOW ACRYLIC THINNER



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



Ready to spray:
17 - 19 s
DIN 4 @ 20°C



Always wear protective equipment



Compliant Spray gun
1.3mm – 1.4mm
3-4 bar inlet pressure
1 coat = 20-30 µm



Follow the application instructions mentioned in this TDS



HVLP 1.3mm-1.4mm
2 bar inlet pressure

Notes:

- On a "wet on wet" application 720 hardener must be used (never H 725 HARDENER).
- Never apply "wet on wet" over polyester fillers due to the fact that can be seen after clear coating.

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