



BODY 634 PROLINE 4:1 PRIMER

Technical Data Sheet No 128

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 sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties even on plastic bumpers

General Technical Description



Mix 4:1 with BODY 625 PROLINE HARDENER

Thinner addition 15-20%:
 • BODY 740 ACRYLIC THINNER NORMAL
 • BODY 741 ACRYLIC THINNER SLOW



Oven force drying – 20-30 min / 60-65°C panel temperature
 Air dry- 1h / 22-25°C
 IR drying 8-12 min
 distance: 60 - 70cm

Surface

On old, sanded paint work

Unsanded cathaphoresis 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 15 min flash off time apply the second full coat.



4:1 mix with BODY 625 PROLINE HARDENER FOR PRIMERS
 Pot life: 55-70 min @23°C (73°F)



Non force dry - 1h / 23°C
 20-30min / 60-65°C panel temperature



Addition 15 - 20% of thinner. Use BODY 740 NORMAL ACRYLIC THINNER / 741 SLOW ACRYLIC THINNER



Short wave 8 – 12 min
 Lamp distance: < 70cm



Ready to spray:
 26-34 s - Cup 4 @
 23°C - DIN 53211



P 400 – P 500
 Flat bed sander



Compliant Spray gun
 1.5-1.8 mm
 3-4 bar inlet pressure
 2x coats = 120-150 micron



P 600 – P 1000
 Sanding by hand, wet



HVLP Spray gun
 1.5 - 1.7 mm
 2 bar inlet pressure
 2x coats = 120-150 micron



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



Always wear protective equipment



10 min / 20-22°C
 Final flash off time



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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Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.)
2 passes »» Apply one coat, and after the 15 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
 Final flash off time



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



Non force dry

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



4:1 mix with BODY 625 PROLINE 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:
 16 - 18 s - Cup 4 @
 23°C - DIN 53211



Always wear protective equipment



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



Follow the application instructions mentioned in this TDS



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

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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.



4:1 mix with BODY 720
NORMAL HARDENER
Pot life: 45 min
@23°C (73°F)



10 min / 23°C
Final flash off time

Flash Point:
27°C / 80°F

Specific Gravity:
1.53 g/cm³

Remarks:

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



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

Solid Content (No thinner):
73% Weight

- Application only with the recommended hardeners and solvents

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 490 g/L.
2004/42/II(c)(540)490

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



Ready to spray:
16 - 18 s - Cup 4 @
23°C - DIN 53211



Always wear
protective equipment

- Do not use at temperatures below 15°C.

- Do not apply the primer as 'wet on wet' on TPA surfaces



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



Follow the application
instructions mentioned
in this TDS

Theoretical Coverage:

6 m² / l at 120micron dry film thickness

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 BODY 634 and BODY 635 application.



HVLP 1.3mm-1.4mm
2 bar atomization
pressure
1 coat = 20-30 micron



Follow the application
instructions mentioned
in this TDS

Cleaning of equipment:

Clean after final use with
Body 740 ACRYL NORMAL

Notes:

A. On a "wet on wet" application 720 hardener must be used (never 625 or 635).

B. Never apply "wet on wet" over polyester fillers due to the fact that can be seen after clear coating.

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