



BODY AUTOEMAIL 2K ACRYLIC PAINT SR

Technical Data Sheet No 602



VOC compliant with the regulations

An Exceptional 2K acrylic, automotive finishing paint

Available in several shades

Excellent scratch resistance

Dull satin mat

General Technical Description



Mix 2:1 with HB BODY HARDENERS

Thinner addition 0-10% HB BODY THINNERS



Ready to spray: 17-23 s / 23°C



Oven force drying – 30min / 60°C
Non force dry – 8-12 h / 23°C

Surface

In Body Primed surfaces

In metallic surfaces

OEM surfaces

Already pre painted surfaces for specific uses (military vehicles)*

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: 2 passes and a mist »» Apply one hand, and after the 10 min flash off time apply the second hand and a mist.
For temperature range: 20-30°C*



2:1 mix with Body 720 Normal Hardener
Pot life: >5h / 23°C



8-15 min / 23°C
Final flash off time

Flash Point:
28°C/82°F

Specific Gravity:
0.9 - 1.3 g/cm³

Solid Content (No thinner):
36-58% Weight

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 840 g/L. The VOC content in the ready for use form of this product is 570 g/L. 2004/42/IIB(e)(840)570

Theoretical Coverage:
-

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 BODY 720 NORMAL HARDENER or BODY 722 FAST or BODY 721 SLOW
- After preparing the area to be painted ensure it to be free from dirt, wax, oil etc.
- It can be used by countries that do not adopt the VOC legislation as well
- Store in a cool place and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers
- Optimum operating range 10-25°C



Addition 10-15% of thinner
Use Body 740 Acryl Normal / Body 741 Acryl Slow / Body 742 Extra Slow



30min / 60-65°C panel temperature
Non force dry – 8-12h / 23°C



Ready to spray: 17-23 s
Cup 4/23°C - DIN 53211@23°C



Always wear protective equipment



Compliant Spray gun
1.3 – 1.5 mm
2.5-3 bar inlet pressure
2x coats = 40-50 micron



Follow the application instructions mentioned in this TDS



HVLP 1.2 – 1.3 mm
2 bar atomization pressure

* The specified temperatures are based on theoretical calculations only and does not mean that this combination cannot be used out of this range.

**For improved adhesion properties on already painted surfaces always sand lightly before applying a 2K acrylic paint on.

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 1/2013, October 2013

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Thinner addition 0-10% HB BODY THINNERS



Ready to spray: 17-23 s / 23°C



Oven force drying – 30min / 60°C
Non force dry – 8-12 h / 23°C

Surface

In Body Primed surfaces

In metallic surfaces

OEM surfaces

Already pre painted surfaces for specific uses (military vehicles)*

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: 2 passes and a mist »» Apply one hand, and after the 10 min flash off time apply the second hand and a mist. For temperature range: higher than 35°C*



2:1 mix with Body 721 Slow Hardener
Pot life: >5h / 23°C



8-15 min / 23°C
Final flash off time



Addition 10-15% of thinner
Use Body 740 Acryl Normal / Body 741 Acryl Slow / Body 742 Extra Slow



45min / 60-65°C panel temperature
Non force dry – 14-16h / 23°C



Ready to spray: 17-23 s
Cup 4/23°C - DIN 53211@23°C



Always wear protective equipment



Compliant Spray gun
1.3 – 1.5 mm
2.5-3 bar inlet pressure
2x coats = 40-50 micron



Follow the application instructions mentioned in this TDS



HVLP 1.2 – 1.3 mm
2 bar atomization pressure

Flash Point:
28°C/82°F

Specific Gravity:
0.9 - 1.3 g/cm³

Solid Content (No thinner):
36-58% Weight

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 840 g/L. The VOC content in the ready for use form of this product is 570 g/L. 2004/42/IIB(e)(840)570

Theoretical Coverage:
-

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 BODY 720 NORMAL HARDENER or BODY 722 FAST or BODY 721 SLOW
- After preparing the area to be painted ensure it to be free from dirt, wax, oil etc.
- It can be used by countries that do not adopt the VOC legislation as well
- Store in a cool place and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers
- Optimum operating range 10-25°C

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Thinner addition 0-10% HB BODY THINNERS



Ready to spray: 17-23 s / 23°C



Oven force drying – 30min / 60°C
Non force dry – 8-12 h / 23°C

Surface

In Body Primed surfaces

In metallic surfaces

OEM surfaces

Already pre painted surfaces for specific uses (military vehicles)*

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: 2 passes and a mist »» Apply one hand, and after the 10 min flash off time apply the second hand and a mist.
For temperature range: 5-15°C*



2:1 mix with Body 722 Fast Hardener
Pot life: >5h / 23°C



8-15 min / 23°C
Final flash off time

Flash Point:
28°C/82°F

Specific Gravity:
0.9 - 1.3 g/cm³

Solid Content (No thinner):
36-58% Weight

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Theoretical Coverage:

-

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 BODY 720 NORMAL HARDENER or BODY 722 FAST or BODY 721 SLOW
- After preparing the area to be painted ensure it to be free from dirt, wax, oil etc.
- It can be used by countries that do not adopt the VOC legislation as well
- Store in a cool place and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers
- Optimum operating range 10-25°C



Addition 10-15% of thinner
Use Body 740 Acryl Normal / Body 741 Acryl Slow / Body 742 Extra Slow



20min / 60-65°C panel temperature
Non force dry – 6-10h / 23°C



Ready to spray: 17-23 s
Cup 4 / 23°C - DIN 53211 @ 23°C



Always wear protective equipment



Compliant Spray gun
1.3 - 1.5 mm
2.5-3 bar inlet pressure
2x coats = 40-50 micron



Follow the application instructions mentioned in this TDS



HVLP 1.2 - 1.3 mm
2 bar atomization pressure

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