



BODYFILL 307 4:1 FILLING PRIMER

Technical Data Sheet No 105

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%:
• BODY 740 ACRYLIC THINNER NORMAL
• BODY 741 ACRYLIC THINNER SLOW

Oven force drying – 20-30 min / 60-65°C panel temperature

Air dry- 1h / 18-22°C



IR drying 8-12 min distance 60-70 cm

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 5 min flash off time apply the second full coat.



4:1 mix with BODY PRO H725 HB BODY HARDENER FOR PRIMERS
Pot life: 45 min @23°C (73°F)



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



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



Short wave 8 – 12 min distance 60-70 cm



Ready to spray: 25 - 30 s - Cup 4 @23°C - DIN 53211/ 23°C



P 320 - P 400 Flat bed sander



Compliant Spray gun 1.5mm – 1.7 mm
3-4 bar inlet pressure
2x coats = 100-120 micron



P 600 – P 1000 Sanding by hand, wet



HVLP 1.5mm - 1.7 mm
2 bar atomization pressure
2x coats = 100-120 micron



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



10 min / 20-22°C
Final 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.

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Product Application: As "wet on wet" primer

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



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



10 min / 20-22°C
Final flash off time

Flash Point:
25°C / 77°F

Specific Gravity:
1.40 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):
75% 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 420 g/L.
2004/42/IIIB(c)(540)420

- 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



Ready to spray:
14-16 s - Cup 4
@23°C - DIN 53211



Always wear protective equipment



Compliant Spray gun
1.3mm - 1.4mm
3-4 bar inlet pressure
1 - 2 coats = 40-50 micron



Follow the application instructions mentioned in this TDS

Theoretical Coverage:

5 - 6 m² / l at 120micron dry film thickness

Cleaning of equipment:

Clean after final use with Body 740 ACRYL NORMAL



HVLP 1.3mm-1.4mm
2 bar atomization pressure
1 - 2 coats = 40-50 micron

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