

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



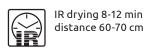
General Technical Description Mix 4:1 with BODY 625

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

PROLINE HARDENER

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

Air dry- 1h / 18-22°C



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)



bumpers

Surface

Fiberglass

panels (E-COAT)

On old, sanded paint work

Unsanded cataphoresis OEM

Thermoplastic Coatings - TPA

Clean and sanded steel panels

Bodyfill 961 Etch Filling Primer

Over new and used plastic

HB Body Polyester Fillers

HB Body 960 Wash Primer

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



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

Compliant Spray gun 1.5mm – 1.7 mm

3-4 bar inlet pressure 2x coats = 100-120 micron

HVLP 1.5mm - 1.7 mm 2 bar atomization pressure

10 min / 20-22°C

Final flash off time

2x coats = 100-120 micron



P 600 – P 1000 Sanding by hand, wet

Short wave 8 – 12 min

distance 60-70 cm

P 320 - P 400 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

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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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



BODYFILL 307 4:1 FILLING PRIMER

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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)

Addition 50 - 60% of

THINNER/741 SLOW

ACRYLIC THINNER

@23°C - DIN 53211

Ready to spray:

14-16 s - Cup 4

740 NORMAL ACRYLIC

thinner. Use BODY



10 min / 20-22°C Final flash off time

2K Autoemail Acrylic Paint SR

HB BODY Basecoat

Always wear

HB BODY UHS Clears

Flash Point: 25°C/77°F

Specific Gravity: 1.40 g/cm³

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/IIB(c)(540)420

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

Cleaning of equipment:

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



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

HVLP 1.3mm-1.4mm

2 bar atomization pressure 1 - 2 coats = 40-50 micron



instructions mentioned in this TDS

protective equipment

Follow the application

Clean after final use with Body 740 ACRYL NORMAL

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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