

BODYFILL 360 2:1 HS FILLING PRIMER

Technical Data Sheet No 104

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

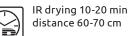
Excellent mechanical properties even on plastic bumpers



No Thinner Addition

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

Air dry 2 - 3 h / 20-25°C



Surface

On old, sanded paint work

OEM surfaces

Thermoplastic Coatings - TPA

Fiberalass

- Clean and sanded steel panels
- HB Body Polyester Fillers

HB Body 960 Wash Primer

Bodyfill 961 Etch Filling Primer

Bodyfill 360 transparent can be used as a Fill sealer as well

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.

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2:1 mix with BODY PRO H 725 HARDENER FOR PRIMERS Pot life: 30-45 min @ 23°C (73°F)



Non force drv 2 - 3h / 23°C 30 min / 60-65°C panel temperature



No Thinner Addition



Short wave 10 – 20 min distance 60-70 cm



P 320 - P 500 Flat bed sander

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P 600 - P 800 Sanding by hand, wet



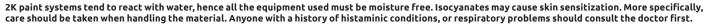
2K Autoemail Acrylic Paint SR HB BODY Basecoat HB BODY UHS Clears



Always wear protective equipment



Follow the application instructions mentioned in this TDS



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Ready to spray: 19-24 s - Cup 4 @ 23°C - DIN 53211 / 23°C



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



HVLP 1.5mm - 1.7 mm 2 bar atomization pressure 2x coats = 120-150 micron



5 min / 20-22°C Final flash off time











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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)



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



2:1 mix with BODY PRO H 725 HARDENER FOR PRIMERS Pot life: 55-70 min @23°C (73°F)



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



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

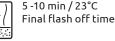


Compliant Spray gun 1.8 mm 3-4 bar inlet pressure 1 - 3 coats = 30 - 35 micron



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







Non force dry



P 400 – P 500 Flat bed sander



P 600 - P 1000



Sanding by hand, wet



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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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.



2:1 mix with BODY 720 NORMAL HARDENER Pot life: 45min @23°C (73°F)

Addition 50 - 60%

or BODY 741 SLOW

ACRYLIC THINNER

14-16 s - Cup 4 @23°C

Ready to spray:

DIN 53211/23°C

Use BODY 740 NORMAL ACRYLIC THINNER

of thinner



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

Always wear protec-

Follow the application

instructions mentioned

tive equipment

in this TDS

A. On a "wet on wet" application

720 hardener must be used (never

over polyester fillers due to the fact that can be seen after clear

B. Never apply "wet on wet"

Notes:

H 725).

coating.

Flash Point: 25°C/77°F

Specific Gravity: 1.50 g/cm³

Solid Content (No thinner): 73% 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 470 g/L. 2004/42/IIB(c)(540)470

Theoretical Coverage: 12 m²/l at 40micron 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



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



15-20 min / 20-25°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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