

BODY BUMPER TEXTURE PAINT

Technical Data Sheet No 609



General Technical Description

VOC compliant with the regulations

1K Thermoplastic acrylic paint

Excellent properties

Excellent mechanical properties



Mix 4:1 with BODY 740 ACRYLIC THINNER NORMAL / BODY 741 ACRYLIC SLOW



Oven force drying – 10 min / 60-65°C
Air dry- 1h / 22-25°C
IR drying 3-5 min

Surface

Plastic parts of the car

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: Fast drying 1K paint for restoring OEM look of plastic bumpers 2 passes »» Apply in thin layers



4:1 mix with BODY 740 ACRYL NORMAL / BODY 741 ACRYL SLOW



5-10 min / 20-22°C
Final flash off time

Flash Point:
8°C/52°F

Specific Gravity:
1.3 g/cm³



20-25% BODY 740 ACRYL NORMAL / BODY 741 ACRYL SLOW



Non force dry – 1h/22-25°C
10 min / 60-65°C panel temperature

Solid Content (No thinner):
40-55% Weight

VOC (2001/42/EC)
The maximum VOC content in this category is 840 g/L. The VOC content in the ready for use form of this product is 610 g/L.
2004/42/IIB(e)(840)610

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature.
- Application only with the recommended hardeners and solvents.
- It should only be used by countries that do not adopt the VOC legislation.
- Do not use at temperatures below 15°C.
- Do not apply the primer as 'wet on wet' on TPA surfaces.



Ready to spray:
20-25 s
Cup 4@23°C
DIN 53211@23°C



Short wave 3-5 min



Compliant Spray gun
1.5 – 1.8 mm
3-4 bar inlet pressure
2x coats = 35-40 micron



Always wear protective equipment



HVLP 1.5 mm
2 bar atomization pressure
2x coats = 35-40 micron



Follow the application instructions mentioned in this TDS

Theoretical Coverage:
7 - 8 m² / l at 50micron dry film thickness

Cleaning of equipment:
Clean after final use with Body 740 ACRYL NORMAL

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