

# BODY PRO P 333 3:1 HS 2K PRIMER

Technical Data Sheet No 101

VOC compliant with the regulations

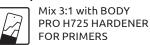
2K Acrylic system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties

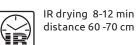




Thinner addition 0-10% BODY 740 ACRYLIC THINNER NORMAL

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

Air dry- 2h /22-25°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

### Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and BODY 770 ANTISIL NORMAL/ BODY 771 ANTISIL FAST.

333 Acrvl Svs

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 HS sanding primer

2 passes »» Apply one coat, and after the 15 min flash off time apply the second full coat.

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3:1 mix with BODY PRO H 725 HBBODY HARDENER FOR PRIMERS Pot life: 45 min @23℃ (73°F)

Non force dry -2h/22-25°C 20-30min / 60-65°C panel temperature



Addition 10-15% of thinner. Use BODY 740 NORMAL ACRYLIC THINNER



Ready to spray: 22-24 s - Cup 4 @23°C - DIN 53211



Compliant Spray gun 1.5 – 1.8 mm 3-4 bar inlet pressure 2x coats = 100-120 micron



HVLP Spray gun 1.5 – 1.8 mm 0.7 bar inlet pressure 2x coats = 100-120 micron



Always wear protective equipment

HB BODY UHS Clears



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

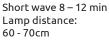


Follow the application instructions mentioned in this TDS

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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Issue 1/2013, November 2013







P 600 – P 1000

Sanding by hand, wet

2K Autoemail Acrylic Paint SR HB BODY Basecoat





# BODY PRO P 333 3:1 HS 2K PRIMER

Technical Data Sheet No 101

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.

5 -10 min / 23°C

Final flash off time



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



3:1 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 - 17 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





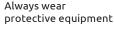
P 600 – P 1000



Sanding by hand, wet

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







Follow the application instructions mentioned in this TDS

Specific Gravity: 1.50 g/cm<sup>3</sup>

Flash Point:

25°C/77°F

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 495 g/L. 2004/42/IIB(c)(540)495

Theoretical Coverage: 5-6 m<sup>2</sup> / l at 50micron dry film thickness

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

#### Remarks:

• Allow for additional time for combi sprav 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

• Store in a cool place and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers

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