



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

General Technical Description



Mix 3:1 with BODY PRO H725 HARDENER FOR PRIMERS

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



IR drying 8-12 min distance 60 - 70 cm

Surface

On old, sanded paint work

OEM surfaces

Thermoplastic Coatings - TPA

Fiberglass

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.

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.



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



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



Short wave 8 – 12 min
Lamp distance: 60 - 70cm



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



P 400 – P 500
Flat bed sander



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



P 600 – P 1000
Sanding by hand, wet



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



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



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



Always wear protective equipment



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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BODY PRO P 333 3:1 HS 2K PRIMER

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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)



5 -10 min / 23°C
 Final flash off time

Flash Point:
 25°C / 77°F

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature



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



Non force dry

Specific Gravity:
 1.50 g/cm³

Solid Content (No thinner):
 75% Weight

- Application only with the recommended hardeners and solvents

Make sure the surface
 is air dried rather than
 wiped dry

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/IIIB(c)(540)495

- It can be used by countries that do not adopt the VOC legislation as well.



Make sure you always
 use appropriate face
 protection and good
 ventilation



P 400 – P 500
 Flat bed sander

Theoretical Coverage:

5-6 m² / l at 50micron dry film thickness

- Do not use at temperatures below 15°C.

- Do not apply the primer as 'wet on wet' on TPA surfaces



3:1 mix with BODY
 PRO H 725 HARDENER
 FOR PRIMERS
 Pot life: 55-70 min
 @23°C (73°F)



P 600 – P 1000
 Sanding by hand, wet

Cleaning of equipment:

Clean after final use with
 Body 740 ACRYL NORMAL

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



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



Always wear
 protective equipment



Ready to spray:
 16 - 17 s - Cup 4
 @ 23°C - DIN 53211



Follow the application
 instructions mentioned
 in this TDS



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

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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