



# BODY ZINC-FILL 2K Adhesion Primer

Technical Data Sheet No 124

VOC compliant with the regulations

2K Acryl based Primer for direct to metal application

Ideal for metal protection against corrosion

Excellent adhesion to galvanized steel and aluminium. Overcoatable with any coating system.

Excellent physical properties

## General Technical Description



Mix 4:1 with BODY 720 HARDENER NORMAL

No Thinner Addition



Air drying – 30-60min @23°C (73°F)  
Oven force drying – 10 min / 60-65°C panel temperature  
IR drying 3-5 min

## Surface

Applied on sanded metallic surfaces

Aluminium surfaces

Galvanized steel

Bare metal surfaces

## 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: A 2K Acryl based filling primer 2 passes »» Apply one coat, and after the 5 min flash off time apply the second full coat. Apply over sanded areas or direct to metallic surfaces. After drying it can be overcoated.**



4:1 mix with BODY 720 HARDENER NORMAL  
Pot life: 2hrs @23°C (73°F)



Short wave 3 – 5 min distance: 60-70 cm

**Flash Point:**  
26°C / 79°F



No Thinner Addition



P 1000 Sanding by hand, wet

**Specific Gravity:**  
1.10 g/cm<sup>3</sup>

**Solid Content (No thinner):**  
59% Weight



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



BODY Polyester Putty

**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 490 g/L.  
2004/42/IIB(c)(540)490

### 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.



Compliant Spray gun  
1.3 – 1.5 mm  
3-4 bar inlet pressure  
2x coats = 20-35 micron



BODY Polyester Spray Filler / 2K Filling Primer

**Theoretical Coverage:**

8-10 m<sup>2</sup> / l at 20micron dry film thickness



HVLP Spray gun 1.3 – 1.5 mm  
0.7 bar inlet pressure  
2x coats = 20-35 micron



Always wear protective equipment



10 min / 23°C  
Final flash off time



Follow the application instructions mentioned in this TDS

**Cleaning of equipment:**

Clean after final use with Body 740 ACRYL NORMAL



Non force dry -  
30-60min / 22-25°C  
10min / 60-65°C panel temperature

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