



## TECHNICAL DATA SHEET No 123

# P 970 2:1 HS FILLSEALER

### GENERAL TECHNICAL DESCRIPTION

2K Acrylic system fillsealer ideal for sanded areas and where putty has been applied

Excellent as adhesion intermediary over non sanded old paints and OEM surfaces

Seals the surface below

Dual use: wet-on-wet fillsealer or HS sanding primer

No need to sand within 48 hours from application. After this period it has to be sanded

Transparent

Tintable with 2K Acrylic Paint

### SURFACE

On old, non sanded paint work (see remarks)

OEM surfaces

Thermoplastic Coatings - TPA

Clean and sanded steel panels

Polyester Fillers

### PRETREATMENT/CLEANING OF SUBSTRATE



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

Make sure the surface is first wiped dry and then air dried.

## PRODUCT APPLICATION: Wet-on-wet Fillsealer



2:1 mix with H729 HARDENER FOR PRIMERS NORMAL  
Pot life: 2 - 3 h / 23°C (73°F)



For a tinted primer add up to 15% 2K Acrylic Paint into part A, then mix with part B.



Addition 20% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 16 - 19 s DIN 4 / 20°C (68°F)



Compliant spray gun  
1.2 - 1.4 mm  
2 - 2.5 bar (29 - 36 psi)  
2x coats = 40 - 50 µm (1.6 - 2 mil)



1.2 - 1.3 mm  
1.5 - 2 bar (22 - 29 psi)  
2x coats = 40 - 50 µm (1.6 - 2 mil)



15 - 20 min / 23°C (73°F)



It can be painted over with all HB BODY Mix Systems, starting 40 min from application up to 48 hours at 23°C (73°F). After 48 hours it has to be sanded.

## PRODUCT APPLICATION: HS Sanding Primer



2:1 mix with H729 HARDENER FOR PRIMERS NORMAL  
Pot life: 2 - 3 h / 23°C (73°F)



For a tinted primer add up to 15% 2K Acrylic Paint into part A, then mix with part B.



Addition 10 - 20% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 16 - 19 s DIN 4 / 20°C (68°F)



Compliant spray gun  
1.5 - 1.8 mm  
2 - 2.5 bar (29 - 36 psi)  
2x coats = 90 - 110 µm (3.5 - 4.3 mil)



1.5 - 1.7 mm  
1.5 - 2 bar (22 - 29 psi)  
2 coats = 90 - 110 µm (3.5 - 4.3 mil)



15 - 20 min / 23°C (73°F)



10 - 12 h / 23°C (73°F)  
20 - 30 min / 60°C (140°F) panel temperature



10 - 15 min  
60 - 70 cm



P 400 - P 500



P 600 - P 1000  
Sanding by hand, wet



It can be painted over with all HB BODY Mix Systems

**FLASH POINT**

28°C / 82°F

**SPECIFIC GRAVITY**1.30 g/cm<sup>3</sup>**SOLID CONTENT****(NO THINNER)**

75% Weight

**VOC (2004/42/EC)**

This 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 540g/L.  
2004/42/IIIB(c)(540)540

**THEORETICAL COVERAGE**6 m<sup>2</sup> / l at 50 micron (2 mil) dry film thickness**CLEANING OF EQUIPMENT**Clean after final use with 740 ACRYL  
NORMAL THINNER / REDUCER**REMARKS**

- Fill-sealing unsanded old paintwork is not recommended for 1K alkydic or delux paints
- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and thinners / reducers
- When tinted with 2K Acrylic Paint, the final tone will differ slightly from the 2K original shade
- Do not use at temperatures below 5°C (41°F)

**STORAGE SHELF LIFE**

- Store in a cool place (+5°C - +25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers



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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