



P 333 3:1 HS FILLING PRIMER

Technical Data Sheet No 101

2K Acrylic system sanding primer

Excellent filling properties

Excellent mechanical properties

Easy to sand

VOC compliant with the regulations

General Technical Description



Mix 3 parts
P 333 PRIMER with
1 part H 725
HARDENER FOR
PRIMERS

Thinner addition 10 - 15% 740
ACRYL NORMAL or 741 ACRYL
SLOW THINNER/ REDUCER



20-30 min / 60°C
(140°F)
panel temperature
2-3h / 23°C (73°F)



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 Wash Primer

P961 Etch Primer

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



Make sure you always
use appropriate face
protection and good
ventilation

Product Application: As a HS sanding primer

2 passes »» Apply one coat, and after 10 min flash off time apply the second full coat.



3:1 mix with
H 725 HARDENER
FOR PRIMERS
Pot life: 60 min
@23°C (73°F)



100-120 µm (3.9-4.7mil)
2-3h / 23°C (73°F)
20-30min / 60°C (140°F)
panel temperature



Addition 10-15% of
thinner / reducer. Use
740 ACRYL NORMAL
or 741 ACRYL SLOW
THINNER / REDUCER



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



Ready to spray:
22 - 24 s
DIN 4 @ 20°C (68°F)



P 400 – P 500
Flat bed sander



Compliant Spray gun
1.5 – 1.8 mm
2 - 2.5 bar (29 - 36 psi)
inlet pressure
2x coats = 100-120 µm
(3.9-4.7mil)



P 600 – P 1000
Sanding by hand, wet



HVLP Spray gun
1.5 – 1.7 mm
1.5 - 2 bar (22-29psi)
inlet pressure
2x coats = 100-120 µm
(3.9-4.7mil)



System Always wear
protective equipment



10 min / 23°C (73°F)
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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Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.)

1 - 2 passes »» Apply one coat, and after 10 min flash off time apply the second full coat.



Dry sanding
P 180 - P 220
(never with a scotch
brite)



10 min / 23°C (73°F)
Final flash off time

Flash Point:
25°C / 77°F



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



1-2h / 23°C (73°F)

Specific Gravity:
1.50 g/cm³

Solid Content (No thinner):
75% Weight

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



P 400 – P 500
Flat bed sander

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 430 g/L.
2004/42/IIIB(c)(540)430

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and thinners / reducers
- It can be used by countries that do not adopt the VOC legislation as well.
- Do not use at temperatures below 15°C (59°F).
- Do not apply the primer as 'wet on wet' on TPA surfaces



Make sure you always
use appropriate face
protection and good
ventilation



3:1 mix with
H 725 HARDENER
FOR PRIMERS
Pot life: 60 min
@23°C (73°F)



P 600 – P 1000
Sanding by hand, wet

Theoretical Coverage:

5-6 m² / l at 100 micron (3.9mil)
dry film thickness



Addition 50 - 60% of
thinner / reducer. Use
740 ACRYL NORMAL
or 741 ACRYL SLOW
THINNER / REDUCER



It can be painted over with
HB BODY Color Solutions
Basecoat Mix System
HB BODY Color Solutions
2K Acrylic Mix System
HB BODY Color Solutions
Aquabase Mix System

Cleaning of equipment:

Clean after final use with
BODY 740 ACRYL NORMAL
THINNER / REDUCER

Caution:

Always check with a cloth and
thinner if the panel is an OEM
(E-COAT) panel. On OEM
(E-COAT) panels, the cloth stays
clean. Then clean the surface
with #770 ANTISIL and the "wet
on wet" procedure is followed
without sanding prior to primer
application.



Ready to spray:
16 - 17 s
DIN 4 @ 20°C (68°F)



Always wear
protective equipment



Compliant Spray gun
1.3 - 1.4 mm
2-3 bar (29-44psi)
inlet pressure
1-2 coats = 30-35 micron
(1.2-1.4mil)



Follow the application
instructions mentioned
in this TDS



HVLP Spray gun
1.3 - 1.4 mm
1.5 - 2 bar (22-29psi)
inlet pressure
1-2 coats = 30-35 micron
(1.2-1.4mil)

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Issue 8 / 2019, October 2019