



TECHNICAL DATA SHEET No 110

## BODY 680 1K FILLING PRIMER

### GENERAL TECHNICAL DESCRIPTION

1K NC system sanding primer  
Excellent filling properties  
Excellent mechanical properties  
Easy to sand

### SURFACE

On old, sanded paint work  
Clean and sanded steel panels  
HB Body 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 with 50% (2:1) Thinner: As HS sanding primer

2 coats • Apply in thin layers over sanded areas only



Mix 2 parts PRIMER  
with 1 part 740 ACRYL  
NORMAL or 741 ACRYL  
SLOW THINNER /  
REDUCER



Ready to spray: 27 - 29 s  
DIN 4 / 20°C (68°F)



Compliant spray gun  
1.5 – 1.8 mm  
2 - 2.5 bar (29 - 36 psi)  
2x coats = 60 - 80 µm  
(2.4 - 3.2 mil)



1.5 – 1.7 mm  
1.5 - 2 bar (22 - 29 psi)  
2x coats = 60 - 80 µm  
(2.4 - 3.2 mil)



5 - 10 min / 23°C (73°F)  
Flash off time



10 min / 60°C (140°F)  
panel temperature  
1 - 2 h / 23°C (73°F)



Short wave 3 – 5 min  
distance 60 - 70 cm



P 320 – P 500



P 600 – P 1000  
Sanding by hand, wet



It can be painted over  
with all HB BODY Mix  
Systems

### REMARKS

It should only be used by countries that do not adopt the VOC  
legislation when applied in this ratio

### PRODUCT APPLICATION with 25% (4:1) Thinner: As HS sanding primer

2 coats • Apply in thin layers over sanded areas only



Mix 4 parts PRIMER  
with 1 part 740 ACRYL  
NORMAL or 741 ACRYL  
SLOW THINNER /  
REDUCER



Ready to spray: 60 - 65 s  
DIN 4 / 20°C (68°F)



Compliant spray gun  
2.5 mm  
2 bar (29 psi)  
2x coats = 80 - 120 µm  
(3.2 - 4.7 mil)



2.5 mm  
1.5 - 2 bar (22 - 29 psi)  
2x coats = 80 - 120 µm  
(3.2 - 4.7 mil)



8 - 10 min / 23°C (73°F)  
Flash off time



10 min / 60°C (140°F)  
panel temperature  
1 - 2 h / 23°C (73°F)



Short wave 3 – 5 min  
distance 60 - 70 cm



P 320 – P 500



P 600 – P 1000  
Sanding by hand, wet



It can be painted over  
with all HB BODY Mix  
Systems

### REMARKS

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

**FLASH POINT**

11°C / 52°F

**SPECIFIC GRAVITY**

1.25 g/cm<sup>3</sup>

**SOLID CONTENT**

**(NO THINNER)**

56% Weight

**THEORETICAL COVERAGE**

5 - 6 m<sup>2</sup> / l at 80 micron (3.2 mil) dry film thickness

**CLEANING OF EQUIPMENT**

Clean after final use with 767 NITRO thinner / reducer

**REMARKS**

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and thinners / reducers
- Do not use at temperatures below 15°C (59°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

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