

HB BODY AUTOMOTIVE
REFINISH



SERIES 6

THE EXCLUSIVE EXPERIENCE

www.series-6.com

SERIES 6

UNDERBODY



BODY 640 CAVITY WAX

Special anticorrosive cavity wax oil treatment with sound deadening properties. Can be applied to all closed parts (doors, bonnet and running boards) and external underbody of the vehicle.



**Shake well
before using**
2 - 3 min



UBS gun
5 - 6 bar (73-87psi)
Pressure



Drying time
60 min/23°C (73°F)

Underbody material with sound deadening / sealing properties and optimum covering ability. Suitable for the external underneath and internal parts of the car body with excellent adhesion properties.

BODY 650 STONE CHIP



**Shake well
before using**
2 - 3 min



UBS gun
5 - 6 bar (73-87psi) Pressure
150 - 200 µm (5.9-7.9mil)



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



Drying time
2 h/23°C (73°F)
30 min/60°C (140°F)
panel temperature



Paint over
with all HB BODY
Mix Systems

SPRAYS



BODY 650 STONE CHIP

Fast drying underbody material with sound deadening/sealing properties, optimum covering ability and excellent adhesion. Suitable for application on internal or external parts of the underbody.



Spraying
20 - 30 cm thinly applied coats
within 5 - 10 min intervals



Application
2 - 3 coats approximately
20 - 30 µm



Drying time
Dust free 10 min/23°C (73°F)
Through drying 2 hours



Paint over
with all HB BODY
Mix Systems



After use turn bottle upside
down and spray out a small
quantity, for the cleaning
of the nozzle.

High quality alkyd based anticorrosive primer, suitable for fast repair or small areas (spot repairs). It can be painted over with any HB BODY paint system.

BODY 692 PRIMER





! for more information, please download the complete editions of TDS's on www.series-6.com

FILLERS

BODY 610 UNIVERSAL FILLER

2K Universal polyester filler with smooth spreading and easy sanding. Suitable for all kind of repairs. Excellent adhesion on aluminium, galvanized, zinc-coated, stainless steel, bare metal and polyester surfaces.



2 - 3% mix with
BPO Paste



Pot life
4 - 5 min
/23°C (73°F)



Drying time
20 - 30min
/23°C (73°F)



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 100 - P 220



Paint over
with HB BODY
acrylic Primers

BODY 611 MULTI FILLER

2K multi-purpose polyester filler suitable for use on all metallic, polyester and wooden surfaces. An excellent filler that spreads smoothly, giving a pinhole free finish. Extermely easy sanding.



2 - 3% mix with
BPO Paste



Pot life
4 - 5 min
/23°C (73°F)



Drying time
20 - 30min
/23°C (73°F)



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 100 - P 220



Paint over
with HB BODY
acrylic Primers

BODY 615 FIBER FILLER

2K Fiberglass polyester filler. Ideal for bridging and filling of cavities. Spreads smoothly and dries fast. Gives an elastic and durable surface.



2 - 3% mix with
BPO Paste



Pot life
4 - 5 min
/23°C (73°F)



Drying time
20 - 30min
/23°C (73°F)



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 80 - P 120



Paint over
with HB BODY
acrylic Primers

BODY 617 NANO FIBER

2K Fiberglass polyester filler for bridging and filling of cavities. Also suitable for filling over corroded surfaces. Resulting in a high resistant and elastic surface.



2 - 3% mix with
BPO Paste



Pot life
4 - 5 min
/23°C (73°F)



Drying time
20 - 30min
/23°C (73°F)



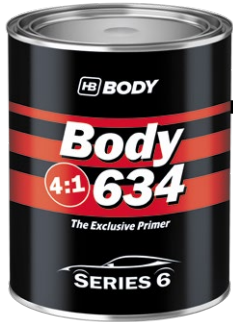
Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 80 - P 120



Paint over
with HB BODY
acrylic Primers



BODY 634 4:1 HS FILLING PRIMER

2K acrylic primer, suitable for spot panel repairs and general automotive refinishes.
Excellent adhesion to all metals and unsanded OEM panels (E-COAT).

AS SANDING PRIMER



4:1 mix with
BODY 625
Hardener for Primers
Pot life 55 - 70 min
/23°C (73°F)



Addition 15 - 20% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
26 - 34 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.5 - 1.8 mm
2 - 2.5 bar (29-36 psi)
inlet pressure
2x coats = 120 - 150 µm (4.7-5.9mil)

HVLP Spray gun 1.5 - 1.7 mm
1.5 - 2 bar (22-29 psi) inlet pressure
2x coats = 120 - 150 µm (4.7-5.9mil)



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



Drying time
1 - 2h/23°C (73°F)
20 - 30 min/60°C (140°F)
panel temperature



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 400 - P 500



Wet Sanding
P 600 - P 1000



Paint over
with all HB BODY
Mix Systems

FOR PLASTIC PARTS



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



4:1 mix with BODY 625
Hardener for Primers
Pot life
55 - 70 min/23°C (73°F)



Addition 50 - 60% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
16 - 18 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.3 - 1.4 mm
2 - 2.5 bar (29-36 psi)
inlet pressure
2-3 coats = 60 - 80 µm
(2.4-3.1mil)

HVLP Spray gun
1.3 - 1.4 mm
1.5 - 2 bar (22-29 psi)
inlet pressure
2-3 coats = 60 - 80 µm
(2.4-3.1mil)



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



Drying time
1 - 2h/23°C (73°F)



Dry Sanding
P 400 - P 500



Wet Sanding
P 600 - P 1000



Paint over
with all HB BODY
Mix Systems

AS "WET ON WET"



4:1 mix with
H 729 NORMAL
Hardener for Primers
Pot life 45 min
/23°C (73°F)



Addition 50 - 60% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
16 - 18 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.3 - 1.4 mm
2 - 2.5 bar (29-36 psi) inlet pressure
1-2 coats = 20 - 30 µm (0.8-1.2mil)

HVLP Spray gun
1.3 - 1.4 mm
1.5 - 2 bar (22-29 psi) inlet pressure
1-2 coats = 20 - 30 µm (0.8-1.2mil)



Flash off time
20 - 30 min
/23°C (73°F)



Paint over
with all HB BODY
Mix Systems

NOTES

A. On a "wet on wet" application H 729 HARDENER must be used (Do not use 625 HARDENER).

B. Never apply "wet on wet" over polyester fillers. High risk of mapping appearance after clear coating.

PRIMERS



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BODY 635 5:1 HS FILLING PRIMER

2K acrylic primer, suitable for spot panel repairs and general automotive refinishes.
Excellent adhesion to all metals and unsanded OEM panels (E-COAT).



5:1 mix with
BODY 635
Hardener for Primers
Pot life
55 - 70 min/23°C (73°F)



Addition 20% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
30 - 40 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.5 - 1.8 mm
2 - 2.5 bar (29-36 psi)
inlet pressure
2x coats = 120 - 150 µm (4.7-5.9mil)

HVLP Spray gun 1.5 - 1.7 mm
1.5 - 2 bar (22-29 psi) inlet pressure
2x coats = 120 - 150 µm (4.3-5.9mil)



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



Drying time
1 - 2h/23°C (73°F)
20 - 30 min/60°C (140°F)
panel temperature



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



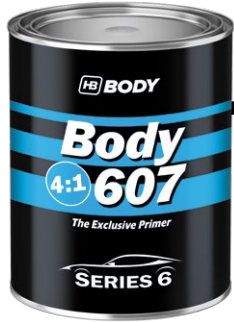
Dry Sanding
P 400 - P 500



Wet Sanding
P 600 - P 1000



Paint over
with all
HB BODY
Mix Systems



BODY 607 4:1 UHS FILLING PRIMER

2K acrylic primer with excellent filling properties, fast drying and easy sanding.
Easy to apply in thick layers even in vertical surfaces due to its high viscosity formula.



4:1 mix with BODY 625
or H725, H729
Hardeners for Primers
Pot life
60 min/23°C (73°F)



Addition 20±5% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
30 - 40 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.5 - 1.8 mm
2 - 2.5 bar (29-36 psi)
inlet pressure
2x coats = 110 - 150 µm (4.3-5.9mil)

HVLP Spray gun 1.5 - 1.7 mm
1.5 - 2 bar (22-29 psi) inlet pressure
2x coats = 110 - 150 µm (4.3-5.9mil)



Flash off time
10 min/20-23°C
(68°F - 73°F)



Drying time
4 - 5 h/23°C (73°F)
30 min/60°C (140°F)
panel temperature



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



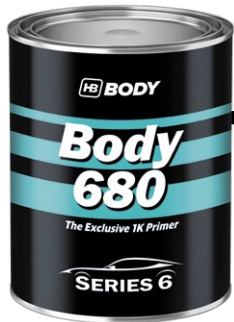
Dry Sanding
P 320 - P 400



Wet Sanding
P 600 - P 1000



Paint over
with all
HB BODY
Mix Systems



BODY 680 1K FILLING PRIMER

Fast drying 1K filling primer suitable for all kinds of paints (synthetic, single coat or base coat).
Applied in thin layers over sanded areas only.



2:1 mix with
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) inlet pressure
2x coats = 60 - 80 µm (2.4-3.2mil)

HVLP Spray gun
1.5 - 1.7 mm
1.5 - 2 bar (22-29 psi) inlet pressure
2x coats = 60 - 80 µm (2.4 - 3.2mil)



Flash off time
5 - 10 min/23°C (73°F)



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



Short wave
3 - 5 min
Lamp distance
60 - 70 cm



Dry Sanding
P 320 - P 500



Wet Sanding
P 600 - P 1000



Paint over
with all
HB BODY
Mix Systems

CLEAR COATS

BODY 691 CLEAR UHS SR 2:1

2K Ultra HS Clear Coat with excellent levelling, high gloss and long-lasting protection. Easy to apply on all types of refinish (partial, full and spot repairs).



2:1 mix with H752 SLOW H753 NORMAL, H754 FAST
Hardeners for Topcoats
Pot life > 6h 23°C (73°F)



Addition 10 - 20% of 740 ACRYL NORMAL or 741 ACRYL SLOW
Thinner/Reducer



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



Compliant Spray gun 1.3 – 1.4 mm
2 - 3 bar (29-44 psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)



HVLP Spray gun 1.2 - 1.3 mm
2 bar (29psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)



Flash off time
10 - 15 min/23°C (73°F)



Drying time
16 - 20 h/23°C (73°F)
25 - 30 min/60°C (140°F)
panel temperature



Short wave
10 - 15 min
Lamp distance
60 - 70 cm

TEMPERATURE	PARTIAL REPAIR	FULL REPAIR
10-15°C (50-59°F)	H754 +10-20% 740	-
15-20°C (59-68°F)	H754 +10-20% 740 H753 +10-20% 740	H753 +10-20% 740
20-25°C (68-77°F)	H754 +10-20% 740 H753 +10-20% 740	H753 +10-20% 740
25-30°C (77-86°F)	H754 +10-20% 740 H754 +10-20% 741 H753 +10-20% 740 H752 +10-20% 740	H753 +10-20% 740 H753 +10-20% 741 H752 +10-20% 740
>30°C (86°F)	H753 +10-20% 740 H752 +10-20% 740	H752 +10-20% 740 H752 +10-20% 741

BODY 697 CLEAR HS SR 2:1

2K HS Clear Coat with fast hardening properties. Due to its excellent levelling and high gloss, this product is suitable for all types of refinish (partial, full and spot repairs).



2:1 mix with BODY 620 Hardener H752 SLOW, H753 NORMAL H754 FAST
Hardeners for Topcoats
Pot life > 7h 23°C (73°F)



Addition 0-5% of 740 ACRYL NORMAL or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
13 - 16 s
DIN 4/20°C (68°F)



Compliant Spray gun 1.3 – 1.4 mm
2 - 3 bar (29-44 psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)



Flash off time
5 - 10 min/23°C (73°F)



Drying time
8 - 14 h/23°C (73°F)
20 - 30 min/60°C (140°F)
panel temperature



Short wave
8 - 10 min
Lamp distance
60 - 70 cm

HVLP Spray gun 1.2 - 1.3 mm
2 bar (29psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)

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BODY 698 CLEAR HS SR 2:1

2K HS Clear Coat, with excellent levelling, high gloss and long lasting protection.
Easy to apply due to its high viscosity formula. Fast hardening properties for spot panel and full automotive repairs.



2:1 mix with BODY 620 Hardener
H752 SLOW, H753 NORMAL
H754 FAST Hardeners for Topcoats
Pot life > 4h 23°C (73°F)



Addition 5 - 15% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
17 - 19 s
DIN 4/20°C (68°F)



Compliant Spray gun 1.3 – 1.4 mm
2 - 3 bar (29-44 psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)



Flash off time
5 - 10 min/23°C (73°F)



Drying time
8 - 16 h/23°C (73°F)
20 - 30 min/60°C (140°F)
panel temperature



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

HVLP Spray gun 1.2 - 1.3 mm
2 bar (29psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)

APPLICATION WITH

BODY 620 / H754 FAST Hardener

TEMP.	ORANGE PEEL TEXTURE 1-2 PARTS	LEVELLING SURFACE 1-2 PARTS	FULL REPAIR
10-15°C (50-59°F)	H754/620 + 5-10% 740 20 min / 60°C (140°F)	H754/620 + 5-15% 740 20 min / 60°C (140°F)	H754/620 + 5-15% 740/741 20 min / 60°C (140°F)
15-25°C (59-77°F)			
25-30°C (77-86°F)	H754/620 + 5-10% 740/741 20 min / 60°C (140°F)	H754/620 + 5-15% 740/741 20 min / 60°C (140°F)	
>30°C (86°F)			

APPLICATION WITH

H753 NORMAL / H752 SLOW Hardener

TEMP.	ORANGE PEEL TEXTURE 1-2 PARTS	LEVELLING SURFACE 1-2 PARTS	FULL REPAIR
10-15°C (50-59°F)	H753 + 5-10% 740 30 min / 60°C (140°F)	H753 + 5-15% 740 30 min / 60°C (140°F)	H753 + 5-15% 740 30 min / 60°C (140°F)
15-25°C (59-77°F)			
25-30°C (77-86°F)		H752/H753 + 5-15% 740 30 min / 60°C (140°F)	H752/H753 + 5-15% 740/741 30 min / 60°C (140°F)
>30°C (86°F)	H752/H753 + 5-10% 740/741 30 min / 60°C (140°F)	H752/H753 + 5-15% 740/741 30 min / 60°C (140°F)	



BODY 699 CLEAR HS SR 2:1

2K HS Clear Coat with high gloss retention, excellent levelling and fast hardening properties. Suitable for spot panel and full automotive repairs.



2:1 mix with
H752 SLOW, H753 NORMAL,
H754 FAST
Hardener for Topcoats
Pot life > 4h 23°C (73°F)



Addition 0 - 10% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
15 - 16 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.3 – 1.4 mm
2 - 3 bar (29-44 psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)



Flash off time
8 - 12 min /23°C (73°F)
(68°F - 73°F)



Drying time
14-18h/23°C (73°F)
20 - 30 min /60°C (140°F)
panel temperature



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

TEMP.	ORANGE PEEL TEXTURE 1-2 PARTS	LEVELLING SURFACE 1-2 PARTS	PARTIAL REPAIR	FULL REPAIR
10-15°C (50-59°F)	H754 20 min / 60°C (140°F)	H754 +max 10% 740 20 min / 60°C (140°F) H753 +max 10% 740 30 min / 60°C (140°F)	H754 +max 10% 740/741 20 min / 60°C (140°F) H753 +max 10% 740 30 min / 60°C (140°F)	H753 +max 10% 740 30 min / 60°C (140°F)
15-25°C (59-77°F)		H754 +max 10% 740/741 20 min / 60°C (140°F) H753 +max 10% 740 30 min / 60°C (140°F)		
25-30°C (77-86°F)	H754 +max 10% 740 20 min / 60°C (140°F) H753 30 min / 60°C (140°F)	H754 +max 10% 740/741 20 min / 60°C (140°F) H753 +max 10% 740/741 30 min / 60°C (140°F)	H754 +max 10% 740/741 20 min / 60°C (140°F) H753 +max 10% 740/741 30 min / 60°C (140°F) H752 +max 10% 740/741 30 min / 60°C (140°F)	H753 +max 10% 740/741 30 min / 60°C (140°F) H752 +max 10% 740/741 30 min / 60°C (140°F)
>30°C (86°F)	H754 +max 10% 741 20 min / 60°C (140°F) H753 +max 10% 740/741 30 min / 60°C (140°F)	H754 +max 10% 741 20 min / 60°C (140°F) H753 +max 10% 740 30 min / 60°C (140°F)	H753 +max 10% 741 30 min / 60°C (140°F) H752 +max 10% 740 30 min / 60°C (140°F)	H752 +max 10% 741 30 min / 60°C (140°F)



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