



TECHNICAL DATA SHEET No 128

## BODY 634 4:1 HS FILLING PRIMER

### GENERAL TECHNICAL DESCRIPTION

2K acrylic system sanding primer  
 Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter  
 Excellent filling properties  
 Excellent mechanical properties even on plastic bumpers  
 Easy to sand

### SURFACE

On old, sanded paint work  
 Unsanded cataphoresis OEM panels (E-COAT)  
 Fiberglass  
 Clean and sanded steel panels  
 HB BODY Polyester Fillers  
 HB BODY Wash Primer  
 P961 Etch Primer  
 Over new and used plastic bumpers, properly degreased

### 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: As sanding primer

Mix 4 parts PRIMER with 1 part BODY 625 HARDENER FOR PRIMERS Pot life: 55 - 70 min / 23°C (73°F)	Addition 15 - 20% 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) 2x coats = 120 - 150 µm (4.7 - 5.9 mil)
1.5 - 1.7 mm 1.5 - 2 bar (22 - 29 psi) 2x coats = 120 - 150 µm (4.7 - 5.9 mil)	5 - 10 min / 23°C (73°F) Flash off time	1 - 2 h / 23°C (73°F) 20 - 30 min / 60°C (140°F) panel temperature	Short wave 5 - 8 min distance 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	

### PRODUCT APPLICATION: For plastic parts (PE - PP - ABS - TSOP etc)

Direct application without the need of an adhesion promoter

Dry sanding P 180 - P 220 (never with a scotch brite)	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	Mix 4 parts PRIMER with 1 part BODY 625 HARDENER FOR PRIMERS Pot life: 55 - 70 min / 23°C (73°F)	Addition 50 - 60% 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) 2 - 3x coats = 60 - 80 µm (2.3 - 3.1 mil)	1.3 - 1.4 mm 1.5 - 2 bar (22 - 29 psi) 2 - 3x coats = 60 - 80 µm (2.3 - 3.1 mil)	5 - 10 min / 23°C (73°F) Flash off time
1 - 2 h / 23°C (73°F)	P 400 - P 500	P 600 - P 1000 Sanding by hand, wet	It can be painted over with all HB BODY Mix Systems

**PRODUCT APPLICATION: As "wet on wet" primer**


Mix 4 parts PRIMER with 1 part H 729 HARDENER FOR PRIMERS NORMAL  
Pot life: 45 min / 23°C (73°F)



Addition 50 - 60% 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)  
1 - 2x coats = 20 - 30 µm (0.8 - 1.2 mil)



1.3 - 1.4 mm  
1.5 - 2 bar (22 - 29 psi)  
1 - 2x coats = 20 - 30 µm (0.8 - 1.2 mil)



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



It can be painted over with all HB BODY Mix Systems

**Notes:**

- On a "wet on wet" application H 729 HARDENER FOR PRIMERS must be used (never BODY 625 HARDENER)
- Never apply "wet on wet" over polyester fillers. High risk of mapping appearance after clear coating

**FLASH POINT**

27°C / 80°F

**SPECIFIC GRAVITY**

1.5 g/cm<sup>3</sup>

**SOLID CONTENT**

(NO THINNER)

74% Weight

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

This is a special refinishing 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

**THEORETICAL COVERAGE**

6 m<sup>2</sup> / l at 120 micron (4.7 mil) dry film thickness

**CLEANING OF EQUIPMENT**

Clean after final use with 740 ACRYL NORMAL 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)
- Do not apply the primer as 'wet on wet' on TPA surfaces

**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 BODY 634 application.

**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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