

BODY 605 4:1 HS FILLING PRIMER



GENERAL TECHNICAL DESCRIPTION

2K Acrylic system sanding primer
Excellent filling properties
Excellent mechanical properties
Easy to sand

SURFACE

On old, sanded paint work
OEM surfaces
Clean and sanded steel panels
HB BODY Polyester Fillers
960 / P965 Wash Primer
P 961 1K 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.

PRODUCT APPLICATION:



Mix 4 parts PRIMER with 1 part BODY 625 HARDENER FOR PRIMERS
Pot life: 2h / 23°C (73°F)



Addition 10 - 15% 740 NORMAL or 741 SLOW ACRYLIC THINNER / REDUCER



Ready to spray: 26 - 31 s
DIN 4 / 20°C (68°F)



Compliant spray gun
1.5 - 1.8 mm
2 - 2.5 bar (29 - 36 psi)
2x coats = 100 - 140 µm (3.9 - 5.5 mil)



1.5 - 1.7 mm
1.5 - 2 bar (22 - 29 psi)
2x coats = 100 - 140 µm (3.9 - 5.5 mil)



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



2.5 - 3 h / 23°C (73°F)
30 min / 60°C (140°F)
panel temperature



Short wave: 5 - 8 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.

FLASH POINT

32°C / 90°F

SPECIFIC GRAVITY

1.58 g/cm³

SOLID CONTENT

(NO THINNER)

78% 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 540g/L.
2004/42/IIIB(c)(540)540

THEORETICAL COVERAGE

5 - 6 m² / 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)
- 2K paint systems tend to react with water, hence all the equipment used must be moisture free

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

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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