



BODY 607 4:1 UHS FILLING PRIMER

Technical Data Sheet No 115

2K Acrylic system filling primer

Easy to apply with anti sagging properties

Excellent filling properties

Excellent mechanical properties

VOC compliant with the regulations

General Technical Description



Mix 4 parts BODY 607 4:1 UHS FILLING PRIMER with 625 HARDENER or any HB BODY Hardener for Primers



Thinner / Reducer addition
20±5%: THINNER 740 ACRYL NORMAL / 741 ACRYL SLOW



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

Aluminium and galvanised surfaces

HB Body Polyester Fillers

HB Body 960/P965 Wash Primer
P961 Etch Primer

On new and painted plastic bumpers

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:

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



4:1 mix with 625 HARDENER or any HB BODY Hardener for Primers
Pot life: 60min @ 23°C (73°F)



110-150 µm (3.2-4.7mil)
4-5h / 23°C (73°F)
30min / 60°C (140°F) panel temperature

Flash Point:
25°C / 77°F

Specific Gravity:
1.62 g/cm³



Addition 20±5% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Short wave 8 – 12 min distance 60-70 cm

Solid Content (No thinner):
77% Weight



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



P 320 – P 400
Flat bed sander

VOC (2004/42/EC)
This product 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 500 g/L.
2004/42/II(c)(540)500



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)



P 600 – P 1000
Sanding by hand, wet

Theoretical Coverage:
5 - 6 m² / l at 80 micron (3.2 mil) dry film thickness



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)



- 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 740 ACRYL NORMAL THINNER / REDUCER



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



Always wear protective equipment



Follow the application instructions mentioned in this TDS

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).
- 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 to 25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers .

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 new plastic bumpers (PE - PP - ABS - TSOP etc)
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)



(68°F - 73°F)
 Flash off time



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



4-5h / 23°C (73°F)
 20-30 min / 60°C (140°F)

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



Make sure you always use appropriate face protection and good ventilation



P 400 – P 500
 Flat bed sander



4:1 mix with 625 HARDENER or any HB BODY Hardener for Primers
 Pot life: 55-70 min @23°C (73°F)



P 600 – P 1000
 Sanding by hand, wet



Addition 30% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER
 For optimum results you may use 340 PLASTOFIX instead of 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



Ready to spray:
 23 - 27 s
 DIN 4 @ 20°C (68°F)



Always wear protective equipment



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)



Follow the application instructions mentioned in this TDS



HVLP Spray gun
 1.5 - 1.7 mm
 1.5 - 2 bar (22 - 29 psi) inlet pressure
 2x coats = 100-120 µm (3.9 - 4.7mil)
 10 min / 20 - 23°C

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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