



# BODY 605 PROLINE 4:1 FILLING PRIMER

Technical Data Sheet No 135

VOC compliant with the regulations

2K Acrylic system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties

## General Technical Description



Mix 4 parts 605 PROLINE PRIMER with 625 PROLINE HARDENER FOR PRIMERS

Thinner addition  
10-15%: 740 NORMAL / 741 SLOW THINNER

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



IR drying 5-8 min  
distance: 60-70 cm

## Surface

On old, sanded paint work

OEM surfaces

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body 960 Wash Primer

P 961 1K Etch Filling Primer

## Pretreatment / Cleaning of substrate



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

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 the 10 min flash off time apply the second full coat.



4:1 mix with 625 PROLINE HARDENER FOR PRIMERS  
Pot life: 120min  
@ 23°C (73°F)



Non force dry  
100 - 140 µm (4 - 5.5 mil)  
2.5 -3h / 23°C (73°F)  
30min / 60°C (140°F)  
panel temperature

**Flash Point:**  
32°C / 90°F

**Specific Gravity:**  
1.58 g/cm<sup>3</sup>



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



Short wave 5 – 8 min  
distance 60-70 cm

**Solid Content (No thinner):**  
78% Weight



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



P 320 – P 500  
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 460 g/L.  
2004/42/IIIB(c)(540)460

**Theoretical Coverage:**  
5 - 6 m<sup>2</sup> / l at 120 micron (4.7mil)  
dry film thickness

**Cleaning of equipment:**  
Clean after final use with  
Body 740 ACRYL NORMAL

## Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature

- Application only with the recommended hardeners and solvents

- 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).

## 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.



Compliant Spray gun  
1.5 – 1.8 mm  
1.5 - 2 bar (22-29 psi)  
inlet pressure  
2x 100 - 140 µm  
(4 - 5.5 mil)



P 600 – P 1000  
Sanding by hand, wet



HVLP Spray gun  
1.5 – 1.7 mm  
1.5 - 2 bar (22-29 psi)  
inlet pressure  
2x 100 - 140 µm  
(4 - 5.5 mil)



- HB BODY Color Solutions Basecoat
- HB BODY Color Solutions 2K
- HB BODY Clears



Always wear protective equipment



8 - 10 min / 20 - 23°C  
(68°F - 73°F)  
Final flash off time



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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