

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)

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

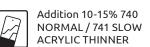
IR drying 5-8 min distance: 60-70 cm

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)





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



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



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)



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



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



Short wave 5 – 8 min distance 60-70 cm



P 320 – P 500 Flat bed sander



P 600 – P 1000 Sanding by hand, wet



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



Always wear protective equipment



Follow the application instructions mentioned in this TDS

Flash Point: 32°C / 90°F

Specific Gravity: 1.58 g/cm³

Solid Content (No thinner): 78% Weight

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/IIB(c)(540)460

Theoretical Coverage:

 $5-6 \text{ m}^2/\text{l}$ 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.

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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Issue 4 / 2018, February 2018