




















# BODYFILL 360 2:1 HS FILLING PRIMER

Technical Data Sheet No 104

<p>Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter (#340 Plastofix)</p> <p>VOC compliant with the regulations</p> <p>2K Acrylic system sanding primer</p> <p>Excellent filling properties</p> <p>Easy to sand</p> <p>Excellent mechanical properties even on plastic bumpers</p>	<p><b>General Technical Description</b></p>  <p>Mix 2 parts BODYFILL 360 HS PRIMER with 1 part BODY PRO H 725 HARDENER FOR PRIMERS</p> <p>No Thinner Addition</p> <p>Oven force drying 20 - 30 min 60°C (140°F) panel temperature</p> <p>Air dry 2 - 3 h / 23°C (73°F)</p>  <p>IR drying 10-15 min distance 60-70 cm</p>	<p><b>Surface</b></p> <p>On old, sanded paint work</p> <p>OEM surfaces</p> <p>Thermoplastic Coatings - TPA</p> <p>Fiberglass</p> <p>Clean and sanded steel panels</p> <p>HB Body Polyester Fillers</p> <p>HB Body 960 Wash Primer</p> <p>Bodyfill 961 Etch Filling Primer</p> <p>Bodyfill 360 transparent can be used as a Fill sealer as well</p>	<p><b>Pretreatment / Cleaning of substrate</b></p>  <p>Clean substrate using a soft cloth and BODY 770 ANTISIL NORMAL / BODY 771 ANTISIL FAST.</p> <p>Make sure the surface is air dried rather than wiped dry</p>  <p>Make sure you always use appropriate face protection and good ventilation</p>
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## Product Application: As an HS sanding primer

2 passes »»» Apply one coat, and after the 5 min flash off time apply the second full coat.

 <p>2:1 mix with BODY PRO H 725 HARDENER FOR PRIMERS Pot life: 45 - 50 min @ 23°C (73°F)</p>	 <p>Non force dry 100-120 micron 2 - 3h / 23°C (73°F) 20 - 30 min / 60°C (140°F) panel temperature</p>
 <p>No Thinner Addition</p>	 <p>IR 10 - 15 min distance 60-70 cm</p>
 <p>Ready to spray: 22-26 s DIN 4 @ 20°C (68°C)</p>	 <p>P 320 - P 500 Flat bed sander</p>
 <p>Compliant Spray gun 1.5mm - 1.8 mm 3-4 bar inlet pressure 2x coats = 100-120 micron (4 - 4.7mil)</p>	 <p>P 600 - P 800 Sanding by hand, wet</p>
 <p>HVLP 1.5mm - 1.7 mm 1.3 - 2 bar inlet pressure</p>	 <p>2K Autoemail Acrylic Paint SR HB BODY Basecoat HB BODY UHS Clears</p>
 <p>Flash off time between coats 8 - 10 min / 23°C (73°F) Final flash off time 10 min / 23°C (73°F)</p>	 <p>Always wear protective equipment</p>
	 <p>Follow the application instructions mentioned in this TDS</p>

**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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# BODYFILL 360 2:1 HS FILLING PRIMER

Technical Data Sheet No 104

## Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.)

1 - 3 coats »» Apply 1 - 3 light coats.



Dry sanding  
P 180 - P 220  
(never with a scotch brite)



5 - 10 min / 23°C (73°F)  
Final flash off time



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



Non force dry  
2 - 3 h / 23°C (73°F)

Make sure the surface is air dried rather than wiped dry



Make sure you always use appropriate face protection and good ventilation



P 400 – P 500  
Flat bed sander



2:1 mix with BODY PRO H 725 HARDENER FOR PRIMERS  
Pot life: 55-70 min  
@23°C (73°F)



P 600 – P 1000  
Sanding by hand, wet



Addition 50 - 60% of thinner.  
Use BODY 740 NORMAL ACRYLIC THINNER/741 SLOW ACRYLIC THINNER



2K Autoemail Acrylic Paint SR  
HB BODY Basecoat  
HB BODY UHS Clears



Ready to spray:  
14 - 15 s  
DIN 4 @ 20°C



Always wear protective equipment



Compliant Spray gun 1.8 mm  
3-4 bar inlet pressure  
1 - 3 coats = 20 - 30 µm



Follow the application instructions mentioned in this TDS



HVLP Spray gun  
1.8 mm  
2 bar inlet pressure

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# BODYFILL 360 2:1 HS FILLING PRIMER

Technical Data Sheet No 104

## Product Application: As "wet on wet" primer

1- 2 passes »» Apply one light coat, and after the 5 min flash off time apply the second full coat.



2:1 mix with BODY 720  
NORMAL HARDENER  
Pot life: 45min  
@23°C (73°F)



2K Autoemail Acrylic  
Paint SR  
HB BODY Basecoat  
HB BODY UHS Clears

**Flash Point:**  
25°C / 77°F

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

### 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).
- Do not apply the primer as 'wet on wet' on TPA surfaces



Addition 50 - 60%  
of thinner  
Use BODY 740 NORMAL  
ACRYLIC THINNER  
or BODY 741 SLOW  
ACRYLIC THINNER



Always wear  
protective equipment

**Solid Content (No thinner):**  
71% 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 470 g/L.  
2004/42/IIIB(c)(540)470

### 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 primer application.



Ready to spray:  
14-15 s  
DIN 4 @ 20°C



Follow the application  
instructions mentioned  
in this TDS

### Notes:

- On a "wet on wet" application 720 hardener must be used (never H 725).
- Never apply "wet on wet" over polyester fillers due to the fact that can be seen after clear coating.

**Theoretical Coverage:**  
10 m<sup>2</sup> / l at 80 micron dry film thickness

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

### Storage Shelf life:

- Store in a cool place (+5 to 25°C) and use within 12 months for best results.
- Guaranteed shelf life of 24 months in unused original containers



Compliant Spray gun  
1.3mm – 1.4mm  
3-4 bar inlet pressure  
1-2 coats = 20-30 µm



HVLP 1.3mm-1.4mm  
2 bar atomization  
pressure  
1-2 coats = 20-30 µm



15-20 min / 23°C (73°F)  
Final flash off time

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