



BODY PRO P 334 4:1 HS 2K PRIMER

Technical Data Sheet No 102

Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter (#340 Plastofix)

VOC compliant with the regulations

2K Acrylic system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties even on plastic bumpers

General Technical Description



Mix 4:1 with BODY PRO H 725 HARDENER FOR PRIMERS

Thinner addition 15 - 20%
BODY 740 ACRYLIC THINNER NORMAL
BODY 741 ACRYLIC THINNER SLOW

Oven force drying – 20-30 min
60°C panel temperature

Air dry 1- 1.5h / 23°C



IR drying 8-12 min
distance 60-70 cm

Surface

On old, sanded paint work

Unsanded cathaphoresis OEM panels (E-COAT)

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body 960 Wash Primer

Bodyfill 961 Etch Filling Primer

Over new and used plastic bumpers

Pretreatment / Cleaning of substrate



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

Make sure the surface is air dried rather than wiped dry



Make sure you always use appropriate face protection and good ventilation

Product Application: As an HS sanding primer

2 passes »» Apply one coat, and after the 15 min flash off time apply the second full coat.



4:1 mix with BODY PRO H 725 HARDENER FOR PRIMERS
Pot life: 60 min @ 23°C (73°F)



Non force dry
1 - 1.5h / 23°C
20-30 min / 60-65°C panel temperature



Addition 15-20% of thinner.
Use BODY 740 NORMAL ACRYLIC THINNER / 741 SLOW ACRYLIC THINNER



Short wave 8 – 12 min
distance 60-70 cm



Ready to spray:
26 -32 s
DIN 4 @ 20°C



P 400 - P 500
Flat bed sander



Compliant Spray gun 1.5mm – 1.8 mm
3-4 bar inlet pressure
2x coats = 100 - 120 micron



P 600 – P 1000
Sanding by hand, wet



HVLP 1.5mm - 1.7 mm
2 bar atomization pressure
2x coats = 100 - 120 micron



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



Always wear protective equipment



10 min / 23°C
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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Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.)
 2 passes »» Apply one coat, and after the 15 min flash off time apply the second full coat.



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



5 -10 min / 23°C
 Final flash off time



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



Non force dry
 1h / 23°C

Make sure the surface is air
 dried rather than wiped dry



Make sure you always use ap-
 propriate face protection and
 good ventilation



P 400 – P 500
 Flat bed sander



4:1 mix with BODY PRO H725
 HB BODY 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 - 16 s
 DIN 4 @ 20°C



Always wear protective
 equipment



Compliant Spray gun 1.3 - 1.4 mm
 3-4 bar inlet pressure
 1 - 3 coats = 30 - 35 micron



Follow the application
 instructions mentioned in
 this TDS



HVLP Spray gun
 1.4 mm
 2 bar inlet pressure
 1 - 3 coats = 30 - 35 micron

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Product Application: As "wet on wet" primer

1 pass »» Apply 1 coat of (20-30µm) and 20-30 minutes after the application we can paint and clear coat as usual.



4:1 mix with BODY 720
NORMAL HARDENER
Pot life: 30 -45 min
@23°C (73°F)



20 30 min / 23°C
Final flash off time

Flash Point:
27°C / 80°F

Specific Gravity:
1.53 g/cm³

Solid Content (No thinner):
73% Weight

VOC (2004/42/EC)
This 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 m² / l at 120 micron 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.
- Do not apply the primer as 'wet on wet' on TPA surfaces

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 BODY P 334 application.

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



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 - 16 s
DIN 4 @ 20°C



Always wear protective equipment



Compliant Spray gun
1.3mm – 1.4mm
3-4 bar inlet pressure
1 coat = 20-30 micron



Follow the application instructions mentioned in this TDS



HVLP 1.4mm
2 bar inlet pressure
1 coat = 20-30 micron

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.

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