



# BODY 634 PROLINE 4:1 FILLING PRIMER

Technical Data Sheet No 128

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 parts BODY 634 with 1 part BODY 625 PROLINE PROLINE PRIMER HARDENER

Thinner addition 15 - 20% :BODY 740 ACRYL NORMAL THINNER



Oven force drying 20-30 min / 60°C (140°F) panel temperature  
Air dry 1 - 2h / 23°C (73°F)  
IR drying 5 - 8 min distance: 60 - 70cm

## Surface

On old, sanded paint work

Unsanded cataphoresis OEM panels (E-COAT)

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body 960 Wash Primer

P 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 first wiped dry and then air dried



Make sure you always use appropriate face protection and good ventilation

## Product Application: As a HS sanding primer.

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



4:1 mix with BODY 625 PROLINE HARDENER FOR PRIMERS  
Pot life: 55-70min / 23°C (73°F)



Non force dry  
120 - 150 µm (4.7-5.9mil)  
Air dry 1 - 2h / 23°C  
20-30min / 60°C (140°F) panel temperature



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



Short wave 5 - 8 min  
Lamp distance: 60 - 70cm



Ready to spray:  
26-34 s  
D I N 4 @ 23°C (73°F)



P 400 - P 500  
Flat bed sander



Compliant Spray gun  
1.5-1.8 mm  
1.5 - 2 bar (22-29psi) inlet pressure  
2x coats = 120-150µm (4.7-5.9mil)



P 600 - P 1000  
Sanding by hand, wet



HVLP Spray gun  
1.5 - 1.7 mm  
1.5 - 2 bar (22-29psi) inlet pressure  
2x coats = 120-150µm (4.7-5.9mil)



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



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



Always wear protective equipment



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 10 min flash off time apply the second coat.*



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  
 1 - 1.5h / 23°C (73°F)

Make sure the surface isn't 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 BODY 625  
 PROLINE HARDENER FOR PRIMERS  
 Potlife: 55-70min @ 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



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



Ready to spray:  
 16 - 18 s  
 D I N 4 @ 20°C (68°F)



Always wear protective  
 equipment



Compliant Spray gun  
 1.3 - 1.4 mm  
 1.5 - 2 bar (22-29psi) inlet pressure  
 1 - 2 coats = 30 - 35µm (1.2-1.4mil)



Follow the application  
 instructions mentioned in  
 this TDS



HVLP Spray gun  
 1.3 - 1.4 mm  
 1.5 - 2 bar (22-29psi) inlet pressure  
 1 - 2 coats = 30 - 35µm (1.2-1.4mil)

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

1 pass »» Apply 1 coat of 20-30µm (0.8-1.2mil) and 20-30 minutes after the application we can paint and clear coat as usual.



4:1 mix with H 729  
NORMAL HARDENER  
Pot life: 45 min @23°C  
(73°F)



20 - 30min / 23°C (73°F)  
Final flash off time

**Flash Point:**  
27°C / 80°F

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

**Solid Content (No thinner):**  
74% 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 490 g/L.  
2004/42/IIIB(c)(540)490

**Theoretical Coverage:**  
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).
- 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 634 application.

### 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.



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



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



Ready to spray:  
16 - 18 s  
D I N 4 @ 20°C (68°F)



Always wear protective equipment



Compliant Spray gun  
1.3mm - 1.4mm  
1.5 - 2 bar (22-29psi)  
inlet pressure  
1 - 2 coats = 20 - 30µm  
(0.8-1.2mil)



Follow the application instructions mentioned in this TDS



HVLP Spray gun  
1.3mm-1.4mm  
2 bar (29psi)  
atomization pressure

### Notes:

- On a "wet on wet" application H 729 hardener must be used (never 625 or 635).
- Never apply "wet on wet" over polyester fillers due to the fact that can be seen after clear coating.

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