



BODY PRO P 333 3:1 HS 2K PRIMER

Technical Data Sheet No 101

VOC compliant with the regulations

2K Acrylic system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties

General Technical Description



Mix 3 parts BODY PRO P 333 PRIMER with 1 part BODY PRO H 725 HARDENER FOR PRIMERS

Thinner addition 10 - 15% BODY 740 ACRYLIC THINNER NORMAL

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

OEM surfaces

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body 960 Wash Primer

Bodyfill 961 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 air dried rather than wiped dry



Make sure you always use appropriate face protection and good ventilation

Product Application: As HS sanding primer

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



3:1 mix with BODY PRO H 725 BODY HARDENER FOR PRIMERS
Pot life: 60 min @23°C (73°F)



Non force dry -
100-120 µm
1 - 1.5h / 23°C
20-30min / 60°C
panel temperature



Short wave 8 – 12 min
Lamp distance:
60 - 70cm



Addition 10-15% of thinner. Use BODY 740 NORMAL ACRYLIC THINNER



P 400 – P 500
Flat bed sander



Ready to spray:
22 - 24 s
DIN 4 @ 20°C



P 600 – P 1000
Sanding by hand, wet



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



Always wear protective equipment



HVLP Spray gun 1.5 – 1.7 mm
1.3 - 2 bar inlet pressure



Follow the application instructions mentioned in this TDS



10 min / 23°C
Final flash off time

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.)

1 - 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)



10 min / 23°C
Final flash off time

Flash Point:
25°C / 77°F

Specific Gravity:
1.50 g/cm³

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



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



Non force dry

Solid Content (No thinner):
75% 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 430 g/L.
2004/42/IIIB(c)(540)430

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.



Make sure you always
use appropriate face
protection and good
ventilation



P 400 – P 500
Flat bed sander

Theoretical Coverage:

5-6 m² / l at 100 micron dry film thickness

Cleaning of equipment:

Clean after final use with
Body 740 ACRYL NORMAL



3:1 mix with BODY
PRO H 725 HARDENER
FOR PRIMERS
Pot life: 60 min @ 23°C
(73°F)



P 600 – P 1000
Sanding by hand, wet



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



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



Ready to spray:
16 - 17 s
DIN 4 @ 20°C



Always wear
protective equipment



Compliant Spray gun
1.5 - 1.8 mm
3 - 4 bar inlet pressure
1 - 2 coats = 30 - 35 micron



Follow the application
instructions mentioned
in this TDS



HVLP Spray gun
1.8 mm
2 bar inlet pressure

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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