



TECHNICAL DATA SHEET No 138

P 307 4:1 HS FILLING PRIMER

GENERAL TECHNICAL DESCRIPTION

High build 2K acrylic primer.
Superior filling and mechanical properties.
Excellent "wet on wet" application.
Easy sanding.

SURFACE

On old, sanded paint work
Unsanded cataphoresis OEM panels (E-COAT)
Fiberglass
Clean and sanded steel panels
HB BODY Polyester Fillers
HB BODY Wash Primer
P961 Etch Primer

PRETREATMENT/CLEANING OF SUBSTRATE



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

Make sure the surface is first wiped dry and then air dried.

PRODUCT APPLICATION: As sanding primer



Mix 4 parts PRIMER with 1 part H 725 HARDENER FOR PRIMERS
Pot life: 60 - 90 min / 23°C (73°F)



Addition 5 - 15% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 22 - 35 s
DIN 4 / 20°C (68°F)



1.5 - 1.8 mm
2 - 2.5 bar (29 - 36 psi)
2x coats = 120 - 150 µm (4.7 - 5.9 mil)



1.5 - 1.7 mm
2 bar (29 psi)
2x coats = 120 - 150 µm (4.7 - 5.9 mil)



10 min / 23°C (73°F)
Flash off time



3 - 4 h / 23°C (73°F)
20 - 30 min / 60°C (140°F)
panel temperature



Short wave 8 - 12 min
distance 60 - 70 cm



P 400 - P 500



P 600 - P 1000
Sanding by hand, wet



It can be painted over with all HB BODY Mix Systems

PRODUCT APPLICATION: As "wet on wet" primer



Mix 4 parts PRIMER with 1 part H 729 HARDENER FOR PRIMERS NORMAL
Pot life: 60 min / 23°C (73°F)



Addition 50 - 60% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 14 - 16 s
DIN 4 / 20°C (68°F)



1.3 - 1.4 mm
2 - 2.5 bar (29 - 36 psi)
1 - 2x coats = 20 - 30 µm (0.8 - 1.2 mil)



1.3 - 1.4 mm
1.5 - 2 bar (22 - 29 psi)
1 - 2x coats = 20 - 30 µm (0.8 - 1.2 mil)



30 - 40 min / 23°C (73°F)
Flash off time



It can be painted over with all HB BODY Mix Systems

Notes:

- On a "wet on wet" application H 729 HARDENER FOR PRIMERS must be used (never H 725).
- Never apply "wet on wet" over polyester fillers. High risk of mapping appearance after clear coating.

SPECIFIC GRAVITY1.44 ± 0.02 g/cm³**SOLID CONTENT****(NO THINNER)**

70 ± 1% 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 540 g/L.
2004/42/IB(c)(540)540

THEORETICAL COVERAGE5 - 6 m² / l at 120 micron (4.7 mil) dry film thickness**CLEANING OF EQUIPMENT**

Clean after final use with 740 ACRYL NORMAL thinner / reducer

REMARKS

- Application only with the recommended hardeners and thinners / reducers.
- 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 P 307 application.

STORAGE SHELF LIFE

Guaranteed shelf life of 24 months in unused original containers stored in a cool place (5 - 25°C) (41 - 77°F).



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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DECEMBER 2023