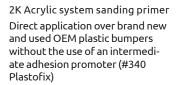


## P 335 5:1 HS FILLING PRIMER

Technical Data Sheet No 103



Excellent filling properties

Excellent mechanical properties even on plastic bumpers

Easy to sand

VOC compliant with the regulations

# General Technical Description



Mix 5 parts P 335 5:1 HS FILLING PRIMER with H 725 HARDENER FOR PRIMERS

Thinner / reducer addition 15 - 20% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



20-30 min / 60°C (140°F) panel temperature 2 - 3h / 23°C (73°F)



8-12 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 Wash Primer

P961 Etch Primer

Over new and used plastic bumpers

## 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



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 10min flash off time apply the second full coat.



5:1 mix with H 725 HARDENER FOR PRIMERS Pot life: 60-70 min @23°C (73°F)



100-120 μm (3.9-4.7mil) 2-3h / 23°C (73°F) 20-30 min / 60°C (140°F) panel temperature



Addition 15 - 20% of thinner / reducer
Use 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER /
REDUCER



Short wave 8 – 12 min distance 60 - 70cm



P 400 - P 500 Flat bed sander



P 600 – P 1000 Sanding by hand, wet

It can be painted over with

**HB BODY Color Solutions** 

**HB BODY Color Solutions** 

Basecoat Mix System

2K Acrylic Mix System HB BODY Color Solutions Aquabase Mix System



Compliant Spray gun 1.5mm – 1.8 mm 2 - 2.5 bar (29 - 36 psi) inlet pressure 2x coats = 100-120 µm (3.9-4.7mil)



HVLP Spray gun 1.5mm - 1.7 mm 1.5 - 2 bar (22 - 29 psi) inlet pressure 2x coats = 100-120 μm (3.9-4.7mil)



Always wear protective equipment



10min / 23°C (73°F) Flash off time

Ready to spray: 27 - 34 s

DIN 4 @ 20°C (68°F)



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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### P 335 5:1 HS FILLING PRIMER

Technical Data Sheet No 103



Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.) 1 - 2 passes ">> Apply one coat, and after 5 - 10 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 (73°F) Flash off time

Flash Point: 26°C / 79°F

Specific Gravity: 1.48 g/cm3

Solid Content (No thinner): 74% Weight



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 480 g/L. 2004/42/IIB(c)(540)480

Theoretical Coverage:  $6 \text{ m}^2 / \text{l}$  at 120 micron (4.7mil) dry film thickness

Cleaning of equipment: Clean after final use with **BODY 740 ACRYL NORMAL** THINNER / REDUCER

- · Allow for additional time for combi spray booths to reach the desired temperature
- · Application only with the recommended hardeners and thinners / reducers
- 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 primer

### 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



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

Make sure the surface

is first wiped dry and

Make sure you always

use appropriate face

protection and good

then air dried

ventilation

5:1 mix with



1 - 2 h / 23°C (73°F)



It can be painted over with HB BODY Color Solutions Basecoat Mix System **HB BODY Color Solutions** 2K Acrylic Mix System **HB BODY Color Solutions** Aquabase Mix System



Flat bed sander





Addition 50 - 60% of thinner / reducer. Use 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



P 600 - P 1000 Sanding by hand, wet



Always wear protective equipment



Ready to spray: 17 - 19 s DIN 4 @ 20°C (68°F)



Compliant Spray gun 1.3 - 1.4 mm 2 - 2.5 bar (29 - 36 psi) inlet pressure 1-2 coats = 30-35 micron (1.2-1.4mil)



Follow the application instructions mentioned in this TDS



**HVLP Spray gun** (1.2-1.4mil)

1.3 - 1.4 mm 1.5 - 2 bar (22 - 29 psi) inlet pressure 1 - 2 coats = 30-35 micron

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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