



P 335 5:1 HS FILLING PRIMER

Technical Data Sheet No 103

2K Acrylic system sanding primer
Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter (#340 Plastofix)

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



Ready to spray:
27 - 34 s
DIN 4 @ 20°C (68°F)



P 400 - P 500
Flat bed sander



P 600 - P 1000
Sanding by hand, wet



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)



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



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



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.)

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



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



1 - 2 h / 23°C (73°F)

Specific Gravity:
1.48 g/cm³

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

Theoretical Coverage:
6 m² / l at 120 micron (4.7mil)
dry film thickness

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

Remarks:

- 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



Make sure you always
use appropriate face
protection and good
ventilation



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



5:1 mix with
H 725 HARDENER
FOR PRIMERS
Pot life: 55-70 min
@23°C (73°F)



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



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



Always wear
protective equipment



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

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