



TECHNICAL DATA SHEET No 123

P 970 2:1 HS FILLSEALER

GENERAL TECHNICAL DESCRIPTION

2K Acrylic system fillsealer ideal for sanded areas and where putty has been applied
 Excellent as adhesion intermediary over non sanded old paints and OEM surfaces
 Seals the surface below
 Dual use: wet-on-wet fillsealer or HS sanding primer
 No need to sand within 48 hours from application. After this period it has to be sanded
 Transparent
 Tintable with 2K Acrylic Paint

SURFACE

On old, non sanded paint work (see remarks)
 OEM surfaces
 Thermoplastic Coatings - TPA
 Clean and sanded steel panels
 Polyester Fillers

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: Wet-on-wet Fillsealer



2:1 mix with H729 HARDENER FOR PRIMERS NORMAL
 Pot life: 2 - 3 h / 23°C (73°F)



For a tinted primer add up to 15% 2K Acrylic Paint into part A, then mix with part B.



Addition 20% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 18 - 19 s DIN 4 / 20°C (68°F)



Compliant spray gun
 1.2 - 1.4 mm
 2 - 2.5 bar (29 - 36 psi)
 2x coats = 40 - 50 µm (1.6 - 2 mil)



1.2 - 1.3 mm
 1.5 - 2 bar (22 - 29 psi)
 2x coats = 40 - 50 µm (1.6 - 2 mil)



15 - 20 min / 23°C (73°F)



It can be painted over with all HB BODY Mix Systems, starting 40 min from application up to 48 hours at 23°C (73°F). After 48 hours it has to be sanded.

PRODUCT APPLICATION: HS Sanding Primer



2:1 mix with H729 HARDENER FOR PRIMERS NORMAL
 Pot life: 2 - 3 h / 23°C (73°F)



For a tinted primer add up to 15% 2K Acrylic Paint into part A, then mix with part B.



Addition 10 ± 5% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 19 - 22s DIN 4 / 20°C (68°F)



Compliant spray gun
 1.5 - 1.8 mm
 2 - 2.5 bar (29 - 36 psi)
 2x coats = 90 - 110 µm (3.5 - 4.3 mil)



1.5 - 1.7 mm
 1.5 - 2 bar (22 - 29 psi)
 2 coats = 90 - 110 µm (3.5 - 4.3 mil)



15 - 20 min / 23°C (73°F)



10 - 12 h / 23°C (73°F)
 20 - 30 min / 60°C (140°F) panel temperature



10 - 15 min
 60 - 70 cm



P 320 - P 500



P 600 - P 800 Sanding by hand, wet



It can be painted over with all HB BODY Mix Systems

FLASH POINT

28°C / 82°F

SPECIFIC GRAVITY1.30 g/cm³**SOLID CONTENT****(NO THINNER / REDUCER)**

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

THEORETICAL COVERAGE6 m² / l at 50 micron (2 mil) dry film thickness**CLEANING OF EQUIPMENT**Clean after final use with 740 ACRYL
NORMAL THINNER / REDUCER**REMARKS**

- Fill-sealing unsanded old paintwork is not recommended for 1K alkydic or delux paints
- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and thinners / reducers
- When tinted with 2K Acrylic Paint, the final tone will differ slightly from the 2K original shade
- Do not use at temperatures below 5°C (41°F)

STORAGE SHELF LIFE

- Store in a cool place (+5°C - +25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers



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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