

BODY 980 1K FILLING PRIMER

Technical Data Sheet No 106

1K NC system sanding primer

Excellent mechanical properties

Excellent filling properties

Easy to sand



General Technical



Mix 2:1 with BODY 740 **ACRYLIC THINNER** NORMAL / BODY 741 ACRYLIC SLOW

Surface

On old, sanded paint work

Clean and sanded steel panels

HB Body Polyester Fillers

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

Description



Oven force drying 10 min / 60-65°C (140-149°F) panel temperature Air dry - 30 min / 23°C (73°F) IR drying 3 - 5 min diastance 60-70 cm

Product Application: An HS sanding primer

2 passes »» Apply in thin layers over sanded areas only



2:1 mix with BODY 740 ACRYL NORMAL / BODY 741 ACRYL SLOW

Compliant Spray gun

3-4 bar inlet pressure

HVI P 1.5 – 1.7 mm

2 bar inlet pressure

2x coats = 80 - 120 micron

2x coats = 80 - 120 micron

1.5 - 1.8 mm





distance: 60 - 70cm

IR 3 - 5 min



P 320 - P 500 Random orbital sander



P 600 – P 1000 Flat bed sander



It can be painted over with: Synthetic Paints 2K Paints BC Solventborne BC Waterbased

Flash Point: 11°C / 52°F

Specific Gravity: $1.25 \, g / cm^3$

Solid Content (No thinner): 64% Weight

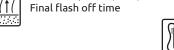
VOC (2004/42/EC)

Theoretical Coverage: 7 - 8 m² / l at 50 micron dry film thickness

Cleaning of equipment: Clean after final use with **Body 740 ACRYL NORMAL**

Remarks:

- · Allow for additional time for combi spray booths to reach the desired temperature
- · Application only with the recommended hardeners and solvents
- It should only be used by countries that do not adopt the VOC legislation.
- Do not use at temperatures below 15°C (59°F).
- Do not apply the primer as "wet on wet" on TPA surfaces



5 - 10 min / 23°C (73°F)



Non force dry -30 min / 23°C (73°F) 10 min / 60-65°C (140-149°F) panel temperature



Always wear protective equipment



Follow the application instructions mentioned in this TDS

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