



BODY 980 1K FILLING PRIMER

Technical Data Sheet No 106

1K NC system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties

General Technical Description



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



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
distance 60-70 cm

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

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



IR 3 - 5 min
distance: 60 - 70cm



Ready to spray:
27-29 s Cup 4 @ 23°C
(73°F) - DIN 53211



P 320 - P 500
Random orbital sander



Compliant Spray gun
1.5 - 1.8 mm
3-4 bar inlet pressure
2x coats = 80 - 120 micron



P 600 - P 1000
Flat bed sander



HVLP 1.5 - 1.7 mm
2 bar inlet pressure
2x coats = 80 - 120 micron



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



5 - 10 min / 23°C (73°F)
Final flash off time



Always wear protective equipment



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



Follow the application instructions mentioned in this TDS

Flash Point:
11°C / 52°F

Specific Gravity:
1.25 g / cm³

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

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