



970 2K FILLSEALER

Technical Data Sheet No 123

VOC compliant with the regulations

2K Acrylic system fillsealer ideal for sanded areas and where putty was been applied

Excellent as adhesion intermediator over non sanded old paints

No need to sand it within 10-12 hours of the application. After the 12 hours period it has to be sanded.

General Technical Description



Mix 2 parts BODY 970 FILLSEALER with 1 part H 729 HARDENER NORMAL

Thinner addition 20%:
• BODY 740 ACRYL NORMAL THINNER

Surface

On old, non sanded paint work

OEM surfaces

Thermoplastic Coatings - TPA

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 first wiped dry and then air dried



Make sure you always use appropriate face protection and good ventilation

Product Application: Fillsealer Transparent Primer

2 passes »» Apply one coat, and after the 15-20 min flash off time apply the second full coat.



2:1 mix with H 729 HARDENER NORMAL
Pot life: 2-3hrs @ 23°C (73°F)



15 -20min / 23°C (73°F)
Final flash off time

Flash Point:
28°C / 82°F



Addition 20% of thinner
Use BODY 740 ACRYL NORMAL THINNER



Non force dry -
4-6h / 23°C (73°F)
20-30 min / 60°C (140°F)
panel temperature

Specific Gravity:
1.30 g/cm³

Solid Content (No thinner):
75% Weight



"WET ON WET"
APPLICATION
max 40 min / 23°C (73°F)

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

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and solvents
- 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)



Ready to spray:
16-19s
DIN 4 @ 20°C (68°F)



Short wave 8 – 12 min
distance 60-70cm



Compliant Spray gun
1.3 – 1.5 mm
2-3 bar (29-44psi)
inlet pressure
2x coats = 40-50µm
(1.6-2mil)



- HB BODY Color Solutions Basecoat
- HB BODY Color Solutions 2K
- HB BODY Clears

Theoretical Coverage:
6 m² / l at 50 micron (2mil)
dry film thickness

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.



HVLP 1.5 – 1.8 mm
2 bar inlet pressure
(29psi)



Always wear protective equipment



Follow the application instructions mentioned in this TDS

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

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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