



BODY 635 PROLINE 5:1 FILLING PRIMER

Technical Data Sheet No 129

Direct application over brand new and used OEM plastic bumpers without the use of an intermediate adhesion promoter (#340 Plastofix)

VOC compliant with the regulations

2K Acrylic system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties even on plastic bumpers.

General Technical Description



Mix 5 parts BODY 635 PROLINE PRIMER with 1 part BODY 635 PROLINE HARDENER

Thinner addition 20% :
BODY 740 ACRYL
NORMAL THINNER



Oven force drying
20-30 min / 60°C (140°F)
panel temperature

Air dry 1 -2h /23°C (73°F)
IR drying 5 - 8 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 960 Wash Primer

Bodyfill 961 Etch Filling Primer
Over new and used plastic bumpers

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: As a HS sanding primer.

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



5:1 mix with BODY 635 PROLINE HARDENER FOR PRIMERS
Pot life: 55-70 min @ 23°C (73°F)



Addition 20% of thinner. Use BODY 740 ACRYL NORMAL THINNER



Ready to spray:
30 - 40 s
D I N 4 @ 20°C (68°F)



Compliant Spray gun
1.5 - 1.8 mm
1.5 - 2 bar (22-29psi)
inlet pressure
2x coats = 120-150µm (4.7-5.9mil)



HVLP Spray gun
1.5 - 1.7 mm
1.5 - 2 bar (22-29psi)
inlet pressure
2x coats = 120-150µm (4.7-5.9mil)



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



Non force dry
120 - 150µm (4.7-5.9mil)
Air dry 1 -2h / 23°C (73°F)
20-30min / 60°C (140°F)
panel temperature



Short wave 5 – 8 min
Lamp distance:
60 - 70cm



P 400 – P 500
Flat bed sander



P 600 – P 1000
Sanding by hand, wet



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



Always wear protective equipment



Follow the application instructions mentioned in this TDS

Flash Point:
26°C / 79°F

Specific Gravity:
1.58 g/cm³

Solid Content (No thinner):
73% 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 450 g/L.
2004/42/IIB(c)(540)450

Theoretical Coverage:
6 m² / l at 120 micron (4.7 mil)
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 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 BODY 635 application.

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

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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