



# P 980 1K PRIMER

Technical Data Sheet 107

VOC compliant with the regulations

1K NC system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties

Fast drying

## General Technical Description



Mix 4:1 with BODY 740 ACRYL NORMAL / 741 ACRYL SLOW

Oven force drying  
10 min / 60°C (140°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

OEM surfaces

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: As a HS Sanding Primer

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



4:1 mix with BODY 740 ACRYL NORMAL / 741 ACRYL SLOW



Short wave 3 – 5 min  
distance: 60-70cm



Ready to spray:  
30-35 s  
DIN 4 @ 20°C (68°F)



P 320 - P 500  
Random orbital sander



Compliant Spray gun  
1.5 – 1.8 mm  
2-3 bar (29-44psi)  
inlet pressure  
2x coats = 80 - 120 µm  
(3.2-4.7mil)



P 600 – P 1000  
Flat bed sander



HVLP Spray gun  
1.5 - 1.7 mm  
2 bar (29psi)  
inlet pressure  
2x coats = 80 - 120 µm  
(3.2-4.7mil)



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



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



Always wear protective equipment



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



Follow the application instructions mentioned in this TDS

**Flash Point:**  
14°C / 57°F

**Specific Gravity:**  
1.28 g / cm<sup>3</sup>

**Solid Content (No thinner):**  
62% 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 535 g/L.  
2004/42/IIIB(c)(540)535

**Theoretical Coverage:**  
6 m<sup>2</sup> / l at 80 micron (3.2mil)  
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 also be used by countries that do not adopt the VOC legislation.
- Do not use at temperatures below 15°C (59°F).

## 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

For professional use only. The information displayed on this sheet has been carefully selected through a series of laboratory investigations. It is based on our best knowledge at the time of issue. The data is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check for newer updates or further information if needed for his intended purpose. The intellectual property of this product, trademarks and copyrights is protected. All rights reserved. The relevant Material Safety Data Sheet and warnings displayed on the label must be read carefully. We may modify and / or discontinue operation of all or portions of this information at any time in our sole discretion, without any notice and assume no responsibility to update the information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

Issue 5 / 2018, January 2018