

# **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

Ready to spray:

DIN 4 @ 20°C (68°F)

Compliant Spray gun

2-3 bar (29-44psi)

1.5 - 1.8 mm

inlet pressure

(3.2-4.7mil)

30-35 s

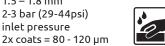


Short wave 3 – 5 min distance: 60-70cm



P 320 - P 500 Random orbital sander





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)

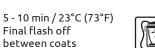


Solutions Basecoat • HB BODY Color

Solutions 2K

HB BODY Color

• HB BODY Clears





protective equipment



Flash Point: 14°C / 57°F

Specific Gravity:  $1.28 \, g / cm^3$ 

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/IIB(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



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

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