

TECHNICAL DATA SHEET No 110

BODY 680 1K FILLING PRIMER

GENERAL TECHNICAL DESCRIPTION

1K NC (nitrocellulose) based sanding primer.

Excellent filling properties.

Resistant to mechanical stresses.

Easy to sand.

SURFACE

On old, sanded paint work
Clean and sanded steel panels
HB BODY Polyester Fillers

PRETREATMENT/CLEANING OF SUBSTRATE

The surface to be coated must be dry, clean, and free of grease and other contaminants. Ensure all substrates are thoroughly cleaned and dried at every step of the preparation process.

Clean the surface with 770 NORMAL / 771 FAST ANTISIL Degreaser

Use 2 clothes wipe on, wipe off. Always wipe cleaner off the surface as long is wet, with a clean, dry cloth.
Remove dust by air blowing and a tack cloth.

PRODUCT APPLICATION with 50% (2:1) Thinner: As HS sanding primer

Adittion 50% 740 NORMAL / 741 SLOW ACRYL OR 767 NITRO THINNER / REDUCER

Ready to spray: 27 - 29 s DIN 4 / 20˚C (68˚F)

1.5 – 1.8 mm
1.7 - 2.2 bar (25 - 32 psi)
2x coats = 80 - 100 µm (3.1 - 3.9 mil)

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

10 min / 60°C (140°F) panel temperature
1 - 2 h / 23°C (73°F)

Short wave 3 – 5 min distance 60 - 70 cm

P 320 – P 500

P 800 – P 1000
Sanding by hand, wet

It can be painted over with all HB BODY paint systems

REMARKS
It should only be used by countries that do not adopt the VOC legislation when applied in this ratio.

PRODUCT APPLICATION with 25% (4:1) Thinner: As HS sanding primer

Adittion 25% 740 NORMAL / 741 SLOW ACRYL OR 767 NITRO THINNER / REDUCER

Ready to spray: 60 - 65 s DIN 4 / 20˚C (68˚F)

1.5 – 1.8 mm
1.7 - 2.2 bar (25 - 32 psi)
2x coats = 100 - 140 µm (3.9 - 5.5 mil)

10 - 15 min / 23°C (73°F) Flash of time

10 min / 60°C (140°F) panel temperature
1 - 2 h / 23°C (73°F)

Short wave 3 – 5 min distance 60 - 70 cm

P 320 – P 500

P 800 – P 1000
Sanding by hand, wet

It can be painted over with all HB BODY paint systems

REMARKS

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/IIB(c) (540)540

BODY 680 1K FILLING PRIMER

SPECIFIC GRAVITY
1.25 ± 0.02 g/cm³

SOLID CONTENT
56 ± 1% Weight

THEORETICAL COVERAGE
5 - 6 m² / l at 80 micron (3.1 mil) dry film thickness

CLEANING OF EQUIPMENT
Clean after final use with 767 NITRO thinner / reducer

REMARKS

- Application only with the recommended thinners / reducers.
- Do not use at temperatures below 15°C (59°F).

STORAGE SHELF LIFE
Guaranteed shelf life of 24 months in unused original containers stored in a cool place (5 - 25°C) (41 - 77°F).



Always wear protective equipment



Follow the application instructions mentioned in this TDS

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