



P 360 2:1 HS FILLING PRIMER

Technical Data Sheet No 104

2K Acrylic system sanding primer

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

Excellent filling properties

Excellent mechanical properties even on plastic bumpers

Easy to sand

VOC compliant with the regulations

General Technical Description



Mix 2 parts
P 360 HS FILLING PRIMER with 1 part
H 725 HARDENER FOR PRIMERS

No Thinner / Reducer Addition



20 - 30 min
60°C (140°F)
panel temperature
3 - 4h / 23°C (73°F)



10-15 min
distance 60-70 cm

Surface

On old, sanded paint work

OEM surfaces

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body Wash Primer

P 961 Etch Primer

P 360 transparent can be used as a
Fill sealer as well

Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER

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 8-10 min flash off time apply the second full coat.



2:1 mix with H 725 HARDENER FOR PRIMERS
Pot life: 45 - 50 min @ 23°C (73°F)



100-120 micron (4 - 4.7mil)
3 - 4h / 23°C (73°F)
20 - 30 min / 60°C (140°F) panel temperature



No Thinner / Reducer Addition



10 - 15 min
distance 60-70 cm



Ready to spray:
22-26 s
DIN 4 @ 20°C (68°F)



P 400 - P 500
Flat bed sander



P 600 - P 1000
Sanding by hand, wet



Compliant Spray gun
1.5mm - 1.7 mm
2 - 2.5 bar (29 - 36 psi) inlet pressure
2x coats = 100-120 micron (4 - 4.7mil)



It can be painted over with
HB BODY Color Solutions
Basecoat Mix System
HB BODY Color Solutions
2K Acrylic Mix System
HB BODY Color Solutions
Aquadase Mix System



HVLP 1.5mm - 1.8 mm
1.3 - 2 bar (19-29psi) inlet pressure
2x coats = 100-120 micron (4 - 4.7mil)



Always wear protective equipment



Flash off time between coats
8 - 10 min / 23°C (73°F)
Flash off time
10 min / 23°C (73°F)



Follow the application instructions mentioned in this TDS

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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Product Application: Applied direct on plastic bumpers (PE - PP - ABS - TSOP etc.)

1 - 3 coats »» Apply 1 - 3 light coats.



Dry sanding
P 180 - P 220
(never with a scotch brite)



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



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER



2 - 3 h / 23°C (73°F)

Make sure the surface is air dried rather than wiped dry



Make sure you always use appropriate face protection and good ventilation



P 400 - P 500
Flat bed sander



2:1 mix with H 725 HARDENER FOR PRIMERS
Pot life: 55-70 min @23°C (73°F)



P 600 - P 1000
Sanding by hand, wet



Addition 50 - 60% of thinner / reducer. Use 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



It can be painted over with
HB BODY Color Solutions Basecoat Mix System
HB BODY Color Solutions 2K Acrylic Mix System
HB BODY Color Solutions Aquabase Mix System



Ready to spray:
14 - 15 s
DIN 4 @ 20°C (68°F)



Always wear protective equipment



Compliant Spray gun
1.5 - 1.8 mm
2 - 2.5 bar (29 - 36 psi) inlet pressure
1 - 3 coats = 20 - 30 µm (0.8-1.2mil)



Follow the application instructions mentioned in this TDS



HVLP Spray gun
1.5 - 1.7 mm
2 bar (29psi) inlet pressure
1 - 3 coats = 20 - 30 µm (0.8-1.2mil)

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Product Application: As a "wet on wet" primer

1- 2 passes »»» Apply one light coat, and after 15 - 20 min flash off time apply point and clear coat as usual



2:1 mix with
H 729 HARDENER for
PRIMERS NORMAL
Pot life: 45min
@23°C (73°F)



It can be painted over with
HB BODY Color Solutions
Basecoat Mix System
HB BODY Color Solutions
2K Acrylic Mix System
HB BODY Color Solutions
Aquabase Mix System

Flash Point:
25°C / 77°F

Specific Gravity:
1.35 g/cm³

Solid Content (No thinner):
69% Weight

VOC (2004/42/EC)

This product 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 470 g/L.
2004/42/II(c)(540)470

Theoretical Coverage:

10 m² / L at 80 micron (3.2mil)
dry film thickness

Cleaning of equipment:

Clean after final use with
740 ACRYL NORMAL THINNER /
REDUCER

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended hardeners and thinners / reducers
- 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 primer application.

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



Addition 50 - 60%
of thinner / reducer
Use 740 ACRYL
NORMAL or 741
ACRYL SLOW THINNER
/ REDUCER



Always wear
protective equipment



Ready to spray:
14-15 s
DIN 4 @ 20°C (68°F)



Follow the application
instructions mentioned
in this TDS

Notes:

- On a "wet on wet" application H 729 hardener must be used (never H 725).
- Never apply "wet on wet" over polyester fillers due to the fact that can be seen after clear coating.



Compliant Spray gun
1.3mm - 1.4mm
2 - 2.5 bar (29 - 36 psi)
inlet pressure
1 coat = 20-30 µm
(0.8-1.2mil)



HVLP 1.3mm-1.4mm
1.5 - 2 bar (22 - 29psi)
atomization pressure
1 coat = 20-30 µm
(0.8-1.2mil)



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

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