



TECHNICAL DATA SHEET No 128

## BODY 634 4:1 HS FILLING PRIMER

### GENERAL TECHNICAL DESCRIPTION

2K acrylic system sanding primer.  
Direct application over brand new and used OEM plastic parts without the use of an intermediate adhesion promoter.  
Excellent filling properties.  
Excellent mechanical properties even on plastic bumpers.  
Easy to sand.

### SURFACE

On old, sanded paint work  
Unsanded cataphoresis OEM panels (E-COAT)  
Fiberglass  
Clean and sanded steel panels  
HB BODY Polyester Fillers  
HB BODY Wash Primers  
P961 Etch Primer  
Over new and used plastic parts except pure Polyethylene (PE)

### 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 surface with 770 NORMAL / 771 FAST ANTISIL Degreaser  
Use 2 clothes wipe on, wipe off. Always wipe clean off the surface as long as wet, with clean, dry cloth.  
Remove dust by air blowing and a tack cloth.

### PRODUCT APPLICATION: As sanding primer



Mix 4 parts PRIMER with 1 part BODY 625 HARDENER FOR PRIMERS  
Pot life: 55 - 70 min / 23°C (73°F)



Addition 15 - 20% 740 NORMAL / 741 SLOW ACRYL THINNER / REDUCER



Ready to spray: 5 - 35 s  
DIN 4 / 20°C (68°F)



1.5 - 1.8 mm  
1.7 - 2.2 bar (25 - 32 psi)  
2x coats = 120 - 150 µm (4.7 - 5.9 mil)



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



20 - 30 min / 60°C (140°F)  
panel temperature  
1 - 2 h / 23°C (73°F)



Short wave 5 - 8 min  
distance 60 - 70 cm



P 400 - P 500



P 600 - P 1000  
Sanding by hand, wet



It can be painted over with all HB BODY paint systems

### PRODUCT APPLICATION: For plastic parts

Direct application without the need of an adhesion promoter



Dry sanding  
P240 - 320



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



Mix 4 parts PRIMER with 1 part BODY 625 HARDENER FOR PRIMERS  
Pot life: 55 - 70 min / 23°C (73°F)



Addition 50 - 60% 740 NORMAL / 741 SLOW ACRYL THINNER / REDUCER



Ready to spray: 16 - 18 s  
DIN 4 / 20°C (68°F)



1.3 - 1.5 mm  
1.7 - 2.2 bar (25 - 32 psi)  
2 - 3x coats = 60 - 80 µm (2.3 - 3.1 mil)



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



1 - 2 h / 23°C (73°F)



P 400 - P 500



P 600 - P 1000  
Sanding by hand, wet



It can be painted over with all HB BODY paint systems

## BODY 634 4:1 HS FILLING PRIMER

### PRODUCT APPLICATION: As "wet on wet" primer



Mix 4 parts PRIMER with 1 part H 729 HARDENER FOR PRIMERS NORMAL  
Pot life: 45 min / 23°C (73°F)



Addition 50 - 60% 740 NORMAL / 741 SLOW ACRYL THINNER / REDUCER



Ready to spray: 16 - 18 s  
DIN 4 / 20°C (68°F)



1.3 - 1.4 mm  
1.7 - 2.2 bar (25 - 32 psi)  
1 - 2x coats = 20 - 30 µm (0.8 - 1.2 mil)



20 - 30 min / 23°C (73°F)  
Flash off time



It can be painted over with all HB BODY paint systems

#### Notes:

- On a "wet on wet" application H729 HARDENER FOR PRIMERS must be used (never BODY 625 HARDENER).
- Never apply "wet on wet" over polyester fillers. High risk of mapping appearance after clear coating.

#### SPECIFIC GRAVITY

1.5 ± 0.02 g/cm<sup>3</sup>

#### SOLID CONTENT

74 ± 1% 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 540 g/L.  
2004/42/IIIB(c)(540)540

#### THEORETICAL COVERAGE

6 m<sup>2</sup> / l at 120 micron (4.7 mil) dry film thickness

#### CLEANING OF EQUIPMENT

Clean after final use with 740 ACRYL NORMAL thinner / reducer

#### REMARKS

- Application only with the recommended hardeners and thinners / reducers.
- 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 says clean. Then clean the surface with 770 A TISIL and the "wet on wet" procedure is followed without sanding prior to BODY 634 application.

#### 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

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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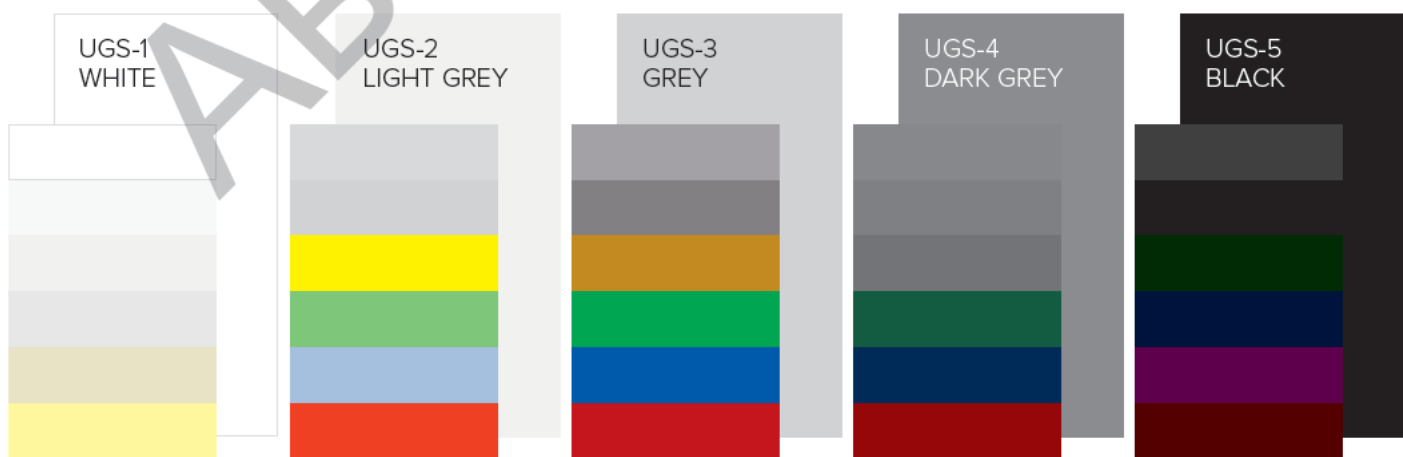
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## Undercoat Grey Shades (UGS) MIXING TABLE

BODY 634 4:1 HS FILLING PRIMER		MIX BY VOLUME		MIX BY WEIGHT (grams)			
		SHADE RATIO	MIX RATIO	100ml PRIMER	250ml PRIMER	500ml PRIMER	1000ml PRIMER
<b>UGS-1 WHITE</b>	WHITE	100%	4	150,20	375,50	751,00	1502,00
	GREY	-		-	-	-	-
	BLACK	-		-	-	-	-
<b>UGS-2 LIGHT GREY</b>	WHITE	80%	4	120,16	300,40	600,80	1201,60
	GREY	20%		29,74	74,35	147,70	297,40
	BLACK	-		-	-	-	-
<b>UGS-3 GREY</b>	WHITE	-	4	-	-	-	-
	GREY	100%		148,70	371,75	743,50	1487,00
	BLACK	-		-	-	-	-
<b>UGS-4 DARK GREY</b>	WHITE	-	4	-	-	-	-
	GREY	75%		111,53	28,83	557,65	1115,30
	BLACK	25%		37,15	2,88	185,75	371,50
<b>UGS-5 BLACK</b>	WHITE	-	4	-	-	-	-
	GREY	-		-	-	-	-
	BLACK	100%		148,60	71,50	743,00	1486,00
<b>HARDENER</b>		<b>625</b>	<b>1</b>	<b>24,5</b>	<b>60,13</b>	<b>120,25</b>	<b>240,50</b>
<b>THINNER (REDUCER)</b>		<b>740 / 741</b>	<b>m x 20%</b>	<b>73</b>	<b>44,33</b>	<b>88,65</b>	<b>177,20</b>

Follow recommended grey undercoat shades for faster paint covering, shorter time application, less consumption and better colour matching. Proceed with activation of UGS mixture with hardeners and thinners according to each primer's mixing specifications provided in its TDS.

## Undercoat Shade Indication Chart



The above colour guidelines are provided for user convenience and are not mandatory when using HB BODY Basecoat and 2K Acrylic Mix System products.