



TECHNICAL DATA SHEET No 104

P360 2:1 HS FILLING PRIMER

GENERAL TECHNICAL DESCRIPTION

Multi-purpose 2K acrylic primer.
Direct application over brand new and used OEM plastic parts without the use of an intermediate adhesion promoter.
Excellent mechanical properties even on plastic parts.
Superb "wet on wet" application.

SURFACE

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
Thermoplastic Coatings - TPA
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 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: As sanding primer



Mix 2 parts PRIMER with 1 part H725 HARDENER FOR PRIMERS
Pot life: 45 - 50 min / 23°C (73°F)



No thinner / reducer required



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



1.5 - 1.8 mm
1.7 - 2.2 bar (25 - 32 psi)
2x coats = 100 - 120 µm (3.9 - 4.7 mil)



10 min / 23°C (73°F)
Flash off time



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



Short wave 10 - 15 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 - P320



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 2 parts PRIMER with 1 part H725 HARDENER FOR PRIMERS
Pot life: 55 - 70 min / 23°C (73°F)



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



Ready to spray: 14 - 16 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



2 - 3 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

PRODUCT APPLICATION: As “wet on wet” primer. Apply one thin closed coat.


Mix 2 parts PRIMER with 1 part H729 HARDENER FOR PRIMERS NORMAL
Pot life: 45 min / 23°C (73°F)



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



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



1.2 - 1.4 mm
1.7 - 2.2 bar (25 - 32 psi)
1x coat = 20 - 25 µm (0.8 - 1.0 mil)



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



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 H725).
- Never apply “wet on wet” over polyester fillers. High risk of mapping appearance after clear coating.

SPECIFIC GRAVITY

1.35 ± 0.02 g/cm³

SOLID CONTENT

69 ± 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/II(c)(540)540

THEORETICAL COVERAGE

5 - 6 m² / l at 120 micron (4.7 mil) dry film thickness

CLEANING OF EQUIPMENT

Clean after final use with 740 ACRYL NORMAL or 767 Thinner / Reducer

REMARKS

- Application only with the recommended hardeners and thinners / reducers.
- Do not use at temperatures below 10°C (50°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 P360 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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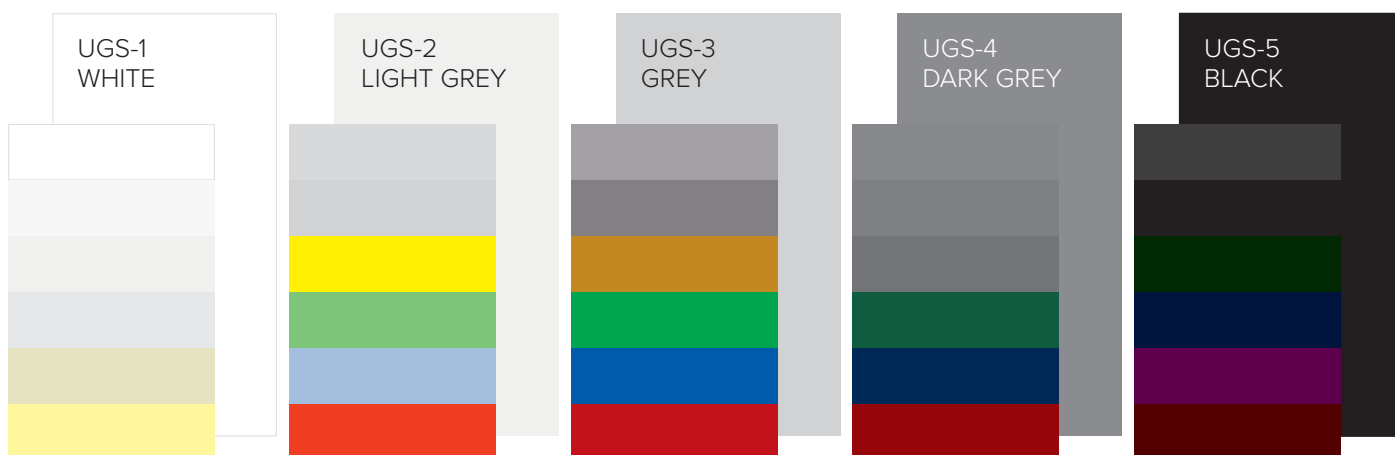
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Undercoat Grey Shades (UGS) MIXING TABLE

P360 2:1 HS FILLING PRIMER		MIX BY VOLUME		MIX BY WEIGHT (grams)			
		SHADE RATIO	MIX RATIO	100ml PRIMER	250ml PRIMER	500ml PRIMER	1000ml PRIMER
UGS-1 WHITE	WHITE	100%	2	136,60	341,50	683,00	1366,00
	GREY	-		-	-	-	-
	BLACK	-		-	-	-	-
UGS-2 LIGHT GREY	WHITE	70%	2	95,62	239,05	478,10	1366,00
	GREY	30%		40,00	100,00	200,00	400,00
	BLACK	-		-	-	-	-
UGS-3 GREY	WHITE	-	2	-	-	-	-
	GREY	100%		133,30	333,25	666,50	1333,00
	BLACK	-		-	-	-	-
UGS-4 DARK GREY	WHITE	-	2	-	-	-	-
	GREY	70%		93,31	233,28	466,55	933,10
	BLACK	30%		39,54	98,85	197,70	395,40
UGS-5 BLACK	WHITE	-	2	-	-	-	-
	GREY	-		-	-	-	-
	BLACK	100%		131,80	329,50	659,00	1318,00
HARDENER	H725		1	48,10	120,26	240,50	481,00
	OR						
	H729			47,10	117,76	235,50	471,00
THINNER (REDUCER)	740 / 741		0%	0,00	0,00	0,00	0,00

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.