



BODY 534 4:1 AUTO PRIMER

Technical Data Sheet No 118

VOC compliant with the regulations

2K Acrylic system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties even on plastic bumpers

General Technical Description



Mix 4 parts Body 534 AUTO PRIMER with 1 part AUTO 534 HARDENER FOR PRIMERS

Thinner addition 10 - 15%

Oven force drying 20-30 min / 60°C (140°F) panel temperature

Air dry 2-3 h / 23°C (73°F)



IR drying 6 min distance 60-70 cm

Surface

On old, sanded paint work

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body 960 Wash Primer

P 961 Etch Filling Primer

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 one coat, and after the 10 min flash off time apply the second full coat.



4:1 mix with AUTO 534 HARDENER FOR PRIMERS
Pot life: 55 min @23°C (73°F)



Non force dry
100 - 120 µm (4 - 4.7 mil)
2 - 3h /23°C (73°F)
20-30 min /60°C (140°F) panel temperature

Flash Point:
27°C / 80°F

Specific Gravity:
1.51 g/cm³

Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature



Addition 10-15% of thinner.



Short wave 6 min distance 60-70 cm

Solid Content (No thinner):
72% Weight

- Application only with the recommended hardeners and solvents



Ready to spray:
23 - 25 s
DIN 4 @ 20°C (68°F)



P 400 - P 500
Flat bed sander

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 490 g/L.
2004/42/IIB(c)(540)490

- It can be used by countries that do not adopt the VOC legislation as well.



Compliant Spray gun
1.5mm - 1.8 mm
2-3 bar (29 - 44 psi) inlet pressure
2x coats = 100 - 120 µm (4 - 4.7 mil)



P 400 - P 600
Sanding by hand, wet

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

- Do not use at temperatures below 15°C (59°F).



HVLP Spray gun
1.5mm - 1.7 mm
2 bar (29 psi) inlet pressure
2x coats = 100 - 120 µm (4 - 4.7 mil)



- HB BODY Color Solutions Basecoat
- HB BODY Color Solutions 2K
- HB BODY Clears

Cleaning of equipment:
Clean after final use with BODY 740 ACRYL NORMAL

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



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



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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