



# BODYFILL 300 3+1 FILLING PRIMER

Technical Data Sheet No 117

VOC compliant with the regulations

2K Acrylic system sanding primer

Excellent filling properties

Easy to sand

Excellent mechanical properties

## General Technical Description



Mix 3 parts BODYFILL 300 FILLING PRIMER with 1 part H 725 HARDENER FOR PRIMERS

Thinner addition 15%: BODY 740 ACRYL NORMAL THINNER

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

Air dry 1 - 1.5h/23°C (73°F)



IR drying 8-12 min distance: 60 - 70cm

## Surface

OEM surfaces

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body 960 Wash Primer

Bodyfill 961 Etch Filing 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:** Over filled and well prepared old paint surfaces  
2 passes »» Apply one coat, and after the 5 min flash off time apply the second full coat.



3:1 mix with H 725 HARDENER FOR PRIMERS  
Pot life: 45 min @ 23°C (73°F)



Non force dry 100-120µm (4 - 4.7 mil)  
1-1,5h / 23°C (73°F)  
20-30min / 60°C (140°F) panel temperature

**Flash Point:**  
25°C / 77°F

**Specific Gravity:**  
1.50 g/cm<sup>3</sup>



Addition 15% of thinner. Use BODY 740 NORMAL ACRYLIC THINNER



Short wave 8 - 12 min  
Lamp distance: 60 - 70cm

**Solid Content (No thinner):**  
74% Weight

## Remarks:

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



Ready to spray:  
22-24 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 495 g/L.  
2004/42/IIB(c)(540)495

- Application only with the recommended hardeners and solvents

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



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



P 600 - P 1000  
Sanding by hand, wet

**Theoretical Coverage:**  
5-6 m<sup>2</sup> / l at 100micron (4 mil) dry film thickness

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



HVLP Spray gun  
1.5 - 1.7 mm  
2 bar (29 psi) inlet pressure



Always wear protective equipment

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

## Storage Shelf life:

- Store in a cool place (+5°C - 25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers



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



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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