



# P 307 4:1 HS HS PRIMER

Technical Data Sheet No 138

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 4:1 with H 725 HARDENER FOR PRIMERS

Thinner addition 5-15%:  
• 740 ACRYL NORMAL THINNER / REDUCER  
• 741 ACRYL SLOW THINNER / REDUCER



20 - 30 min / 60°C-65°C (140°F-149°F) panel temperature

3-4h / 18°C - 22°C (64°F - 72°F)



8-12 min distance 60-70 cm

## Surface

On old, sanded paint work

Unsanded cataphoresis OEM panels (E-COAT)

Thermoplastic Coatings - TPA

Fiberglass

Clean and sanded steel panels

HB Body Polyester Fillers

HB Body Wash Primer

P961 Etch Primer

Over new and used plastic bumpers

## 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 10 min flash off time apply the second full coat.



4:1 mix with H 725 HARDENER FOR PRIMERS  
Pot life: 60 - 90 min @23°C (73°F)



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



Addition 5 - 15% of thinner / reducer  
Use 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / reducer



Short wave 8 – 12 min  
distance 60-70 cm



Ready to spray:  
22 - 35 s  
DIN 4 @20°C (68°F)



P 400 - P 500  
Flat bed sander



Compliant Spray gun  
1.5mm – 1.8 mm  
2 - 2.5 bar (29 - 36 psi) inlet pressure  
2x coats = 120-150 micron (4.7-5.9mil)



P 600 – P 1000  
Sanding by hand, wet



HVLP 1.5mm - 1.7 mm  
1.5 - 2 bar (22-29psi) inlet pressure  
2x coats = 120-150 micron (4.7-5.9mil)



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



10 min / 20°C - 22°C (68°F - 71°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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# P 307 4:1 HS FILLING PRIMER

Technical Data Sheet No 138

## Product Application: As a "wet on wet" primer

1 pass » A pply one light coat



4:1 mix with H 729  
HARDENER FOR  
PRIMERS NORMAL  
Pot life: 60 min  
@23°C (73°F)



30 - 40 min / 20 - 22°C  
(68°F - 71°F)  
Final flash off time

**Flash Point:**  
25°C / 77°F

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

### 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



Addition 50 - 60%  
of thinner. 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

**Solid Content (No thinner):**  
70% 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 420 g/L.  
2004/42/II(c)(540)420

### 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



Ready to spray:  
14-16 s  
DIN 4 @20°C (68°F)



Always wear  
protective equipment

**Theoretical Coverage:**  
5 - 6 m<sup>2</sup> / l at 120micron (4.7mil)  
dry film thickness

**Cleaning of equipment:**  
Clean after final use with  
740 ACRYL NORMAL THINNER /  
REDUCER



Compliant Spray gun  
1.5mm – 1.7 mm  
2 - 2.5 bar (29 - 36 psi)  
inlet pressure  
1x coats = 20-30 micron  
(0.8-1.2mil)



Follow the application  
instructions mentioned  
in this TDS



HVLP 1.3mm - 1.4mm  
1.5 - 2 bar (22-29psi)  
inlet pressure  
1x coats = 20-30 micron  
(0.8-1.2mil)

### 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

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