



TECHNICAL DATA SHEET No 115

## BODY 607 4:1 UHS FILLING PRIMER

### GENERAL TECHNICAL DESCRIPTION

2K acrylic system filling primer.  
Anti-sagging formula.  
Excellent filling properties.  
Outstanding mechanical resistance.  
Easy application procedure.

### SURFACE

On old, sanded paint work  
OEM surfaces  
Thermoplastic Coatings - TPA  
Fiberglass  
Clean and sanded steel panels  
Aluminium and galvanised surfaces  
HB BODY Polyester Fillers  
HB BODY Wash Primers  
P961 Etch Primer

### 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:



Mix 4 parts PRIMER with 1 part BODY 625, H725 or H729 HARDENER FOR PRIMERS

Pot life: 60 min / 23°C (73°F)



Addition 15 - 25% 740 NORMAL / 741 SLOW ACRYL THINNER / REDUCER



Ready to spray: 30 - 40 s  
DIN 4 / 20°C (68°F)



1.5 - 1.8 mm  
1.7 - 2.2 bar (25 - 32 psi)  
2x coats = 110 - 150 µm  
(4.3 - 5.9 mil)



10 min / 23°C (73°F)  
Flash off time



30 min / 60°C (140°F)  
panel temperature  
4 - 5 h / 23°C (73°F)



Short wave: 8 - 12 min  
Distance: 60 - 70 cm



P 320 – P 400



P 600 – P 1000  
Sanding by hand, wet



It can be painted over  
with all HB BODY paint  
systems

### SPECIFIC GRAVITY

1.62 ± 0.02 g/cm<sup>3</sup>

### SOLID CONTENT

77 ± 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 540g/L.

2004/42/IIIB(c)(540)540

### THEORETICAL COVERAGE

5 - 6 m<sup>2</sup> / l at 80 micron (3.2 mil) dry film thickness

### CLEANING OF EQUIPMENT

Clean after final use with 740 ACRYL NORMAL or 767 NITRO thinner / reducer

### REMARKS

- Application only with the recommended hardeners and thinners / reducers.
- Do not use at temperatures below 15°C (59°F).

### 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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SEPTEMBER 2024

**Undercoat Grey Shades (UGS) MIXING TABLE**

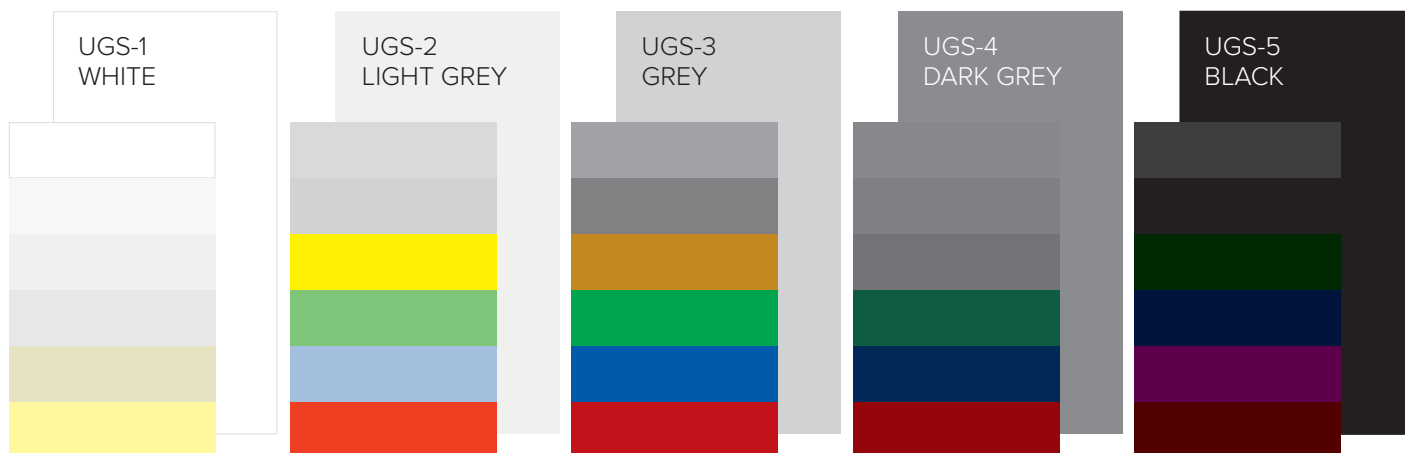
BODY 607 4:1 UHS FILLING PRIMER		MIX BY VOLUME		MIX BY WEIGHT (grams)			
		SHADE RATIO	MIX RATIO	100ml PRIMER	250ml PRIMER	500ml PRIMER	1000ml PRIMER
<b>UGS-1 WHITE</b>	WHITE	100%	4	163,80	409,50	819,00	1638,00
	GREY	-		-	-	-	
	BLACK	-		-	-	-	
<b>UGS-2 LIGHT GREY</b>	WHITE	80%	4	131,04	327,60	655,20	1310,40
	GREY	20%		32,46	81,15	162,30	324,60
	BLACK	-		-	-	-	
<b>UGS-3 GREY</b>	WHITE	-	4	-	-	-	-
	GREY	100%		162,30	405,00	811,50	1623,00
	BLACK	-		-	-	-	
<b>UGS-4 DARK GREY</b>	WHITE	-	4	-	-	-	-
	GREY	70%		113,61	284,03	568,05	1136,10
	BLACK	30%		46,86	117,15	234,30	468,60
<b>UGS-5 BLACK</b>	WHITE	-	4	-	-	-	-
	GREY	-		-	-	-	-
	BLACK	100%		156,20	390,50	781,00	1562,00

<b>HARDENER</b>	<b>H725</b>	1	24,05	60,13	120,25	240,50
	OR					
	<b>H729</b>		23,55	58,88	117,75	235,50
	OR					
	<b>625</b>		24,05	60,13	120,25	240,50

<b>THINNER (REDUCER)</b>	<b>740/741</b>	20%	17,73	44,33	88,65	177,20
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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.