



TECHNICAL DATA SHEET No 123

P970 2:1 HS FILLSEALER

GENERAL TECHNICAL DESCRIPTION

2K acrylic system fillsealer, ideal for sanded areas and where putty has been applied.

Excellent as adhesion intermediary over non sanded old paints and OEM surfaces.

Seals the surface below.

Dual use: wet-on-wet fillsealer or HS sanding primer.

No need to sand within 48 hours from application. After this period it has to be sanded.

Available in transparent and tintable version, with HB BODY 2K Acrylic Paint.

SURFACE

Old, non sanded paint work (see remarks section below)
 Unsanded OEM panels (E-COAT)
 Clean and sanded steel panels
 HB BODY Polyester Fillers
 Thermoplastic Coatings - TPA

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: Wet-on-wet Fillsealer



2:1 mix with H729 HARDENER FOR PRIMERS NORMAL
 Pot life: 2 - 3 h / 23°C (73°F)



For a tinted primer add up to 15% 2K Acrylic Paint into part A, then mix with part B.



Addition 20% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 18 - 19 s DIN 4 / 20°C (68°F)



1.2 - 1.3 mm
 1.7 - 2.2 bar (25 - 32 psi)
 2x coats = 40 - 50 µm (1.6 - 2 mil)



It can be painted over with all HB BODY paint systems, starting from 40 min after application, up to 48h at 23°C (73°F). After 48 hours, light sanding is required.

PRODUCT APPLICATION: HS Sanding Primer



2:1 mix with H729 HARDENER FOR PRIMERS NORMAL
 Pot life: 2 - 3 h / 23°C (73°F)



For a tinted primer add up to 15% 2K Acrylic Paint into part A, then mix with part B.



Addition 10 ± 5% 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



Ready to spray: 19 - 22s DIN 4 / 20°C (68°F)



1.5 - 1.8 mm
 1.7 - 2.2 bar (25 - 32 psi)
 2x coats = 40 - 50 µm (1.6 - 2 mil)



15 - 20 min / 23°C (73°F)



10 - 12 h / 23°C (73°F)
 20 - 30 min / 60°C (140°F)
 panel temperature



10 - 15 min
 60 - 70 cm



P 320 - P 500



P 600 - P 800
 Sanding by hand, wet



It can be painted over with all HB BODY paint systems

SPECIFIC GRAVITY1.30 ± 0.02 g/cm³**SOLID CONTENT**

70± 2% 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

CLEANING OF EQUIPMENT6 m² / l at 50 micron (2 mil) dry film thickness**CLEANING OF EQUIPMENT**

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

REMARKS

- Fill-sealing unsanded old paintwork is not recommended for 1K alkyd paints.
- Application only with the recommended hardeners and thinners / reducers.
- When tinted with 2K Acrylic Paint, the final tone will differ slightly from the 2K original shade.
- Do not use at temperatures below 15°C (59°F).
- Do not apply the primer as 'wet on wet' on TPA surfaces.

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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OCTOBER 2025