



# P 980 1K PRIMER

Technical Data Sheet 107

1K NC system sanding primer  
 Excellent filling properties  
 Excellent mechanical properties  
 Fast drying  
 Easy to sand  
 VOC compliant with the regulations

## General Technical Description



Mix 4:1 with BODY 740 ACRYL NORMAL or 741 ACRYL SLOW THINNER / REDUCER



10 min / 60°C (140°F)  
 panel temperature  
 1 h / 23°C (73°F)



3 - 5 min  
 distance 60-70 cm

## Surface

On old, sanded paint work  
 Clean and sanded steel panels  
 HB Body Polyester Fillers

## 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 in thin layers over sanded areas only



4:1 mix with 740 ACRYL NORMAL / 741 ACRYL SLOW THINNER / REDUCER



Short wave 3 – 5 min  
 distance: 60-70cm



Ready to spray:  
 30-35 s  
 DIN 4 @ 20°C (68°F)



P 400 - P 500  
 Random orbital sander



Compliant Spray gun  
 1.5 – 1.8 mm  
 2 - 2.5 bar (29 - 36 psi)  
 inlet pressure  
 2x coats = 80 - 120 µm  
 (3.2-4.7mil)



P 600 – P 1000  
 Flat bed sander



HVLP Spray gun  
 1.5 - 1.7 mm  
 1.5 - 2 bar (22 - 29 psi)  
 inlet pressure  
 2x coats = 60 - 80 µm  
 (3.2-4.7mil)



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



Always wear protective equipment



5 - 10 min / 23°C (73°F)  
 Flash off between coats



Follow the application instructions mentioned in this TDS



1 h / 23°C (73°F)  
 10 min / 60°C (140°F)  
 panel temperature

**Flash Point:**  
 14°C / 57°F

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

**Solid Content (No thinner):**  
 62% 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 535 g/L.  
 2004/42/IIIB(c)(540)535

**Theoretical Coverage:**  
 6 m<sup>2</sup> / l at 80 micron (3.2mil)  
 dry film thickness

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

### Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended thinners / reducers
- It can also be used by countries that do not adopt the VOC legislation.
- Do not use at temperatures below 15°C (59°F).

### 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

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