

HB **BODY** AUTOMOTIVE
REFINISH



THE EXCLUSIVE EXPERIENCE

SERIES 6

UNDERBODY



BODY 640 CAVITY WAX

Special anticorrosive cavity wax oil with sound-deadening properties. It can be applied to all closed parts (doors, bonnet, running boards) and the external underbody of the vehicle. Easy penetration, resistant to high temperatures.



Shake well before using
2 - 3 min



UBS gun
5 - 6 bar (73-87psi) Pressure



Drying time
60 min/23°C (73°F)

Underbody material with sound deadening / sealing properties, optimum covering ability and excellent adhesion. Suitable for both the external underbody and internal parts of the car body. Can be overpainted.

BODY 650 STONE CHIP



Shake well before using
2 - 3 min



UBS gun
5 - 6 bar (73-87psi) Pressure
150 - 200 µm (5.9-7.9mil)



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



Drying time
2 h/23°C (73°F)
30 min/60°C (140°F)
panel temperature



Paint over
with all HB BODY
Mix Systems

SPRAYS



BODY 650 STONE CHIP

Fast-drying, synthetic rubber-based underbody material with sound-deadening / sealing properties, optimum covering ability, and excellent adhesion. Suitable for application to the internal or external parts of the underbody.



Spraying
20 - 30 cm thinly applied coats
within 5 - 10 min intervals



Application
2 - 3 coats approximately
20 - 30 µm



Drying time
Dust free 10 min/23°C (73°F)
Through drying 2 hours



Paint over
with all HB BODY
Mix Systems



After use turn bottle upside down and spray out a small quantity, for the cleaning of the nozzle.

High-quality alkyd-based anticorrosive primer, suitable for fast repair on small areas (spot repairs). It can be painted over with any HB BODY mix systems.

BODY 692 PRIMER



Spraying
20 - 30 cm
thinly applied coats



Flash off time
10 - 15 min
/23°C (73°F)



Application
2 - 3 coats
approximately
20 - 30 µm



Drying time
30 - 45 min
/23°C (73°F)



Paint over
with all HB BODY
Mix Systems



After use turn bottle upside down and spray out a small quantity, for the cleaning of the nozzle.





! for more information, please download the complete editions of TDS's on www.series-6.com

FILLERS

BODY 610 UNIVERSAL FILLER

2K universal polyester filler, which spreads smoothly suitable for all kinds of repairs. Suitable for application on all metal (aluminium, stainless, galvanized, zinc-coated) surfaces. Extremely easy sanding with P100 – P220 grit paper.



2 - 3% mix with
BPO Paste



Pot life
4 - 5 min
/23°C (73°F)



Drying time
20 - 30min
/23°C (73°F)



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 100 - P 220



Paint over
with HB BODY
acrylic Primers

BODY 611 MULTI FILLER

2K polyester multi-filler suitable for use on all metallic surfaces. An excellent soft filler that spreads smoothly and is very easy to sand with P100-P220 grit paper, giving a pinhole-free finish.



2 - 3% mix with
BPO Paste



Pot life
4 - 5 min
/23°C (73°F)



Drying time
20 - 30min
/23°C (73°F)



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 100 - P 220



Paint over
with HB BODY
acrylic Primers

BODY 615 FIBER FILLER

2K fiberglass polyester filler for bridging and filling of cavities. Also suitable for filling over corroded substrates. Resulting in a highly resistant surface. Sand with P80-P120 grit paper.



2 - 3% mix with
BPO Paste



Pot life
4 - 5 min
/23°C (73°F)



Drying time
20 - 30min
/23°C (73°F)



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 80 - P 120



Paint over
with HB BODY
acrylic Primers

BODY 617 NANO FIBER

2K Fiberglass polyester filler for bridging and filling holes and rust. Easier to apply compared to the classic fiber fillers. It Dries quickly and is easy to sand with P80 - P120 grit paper. Provides a highly resistant surface.



2 - 3% mix with
BPO Paste



Pot life
4 - 5 min
/23°C (73°F)



Drying time
20 - 30min
/23°C (73°F)



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 80 - P 120



Paint over
with HB BODY
acrylic Primers

PRIMERS



BODY 634 4:1 HS FILLING PRIMER

2K acrylic filling primer, suitable for spot panel repairs and general automotive refinishes. Excellent adhesion to all metals, unsanded OEM panels (E-COAT) and plastic parts without adhesion promoter. It can also be applied wet-on-wet. 4:1 mixing ratio with Hardeners for Primers BODY 625 or H729 NORMAL/FAST.

AS SANDING PRIMER



4:1 mix with
BODY 625
Hardener for Primers
Pot life 55 - 70 min
/23°C (73°F)



Addition 15 - 20% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
26 - 34 s
DIN 4/20°C (68°F)



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

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



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



Drying time
1 - 2h/23°C (73°F)
20 - 30 min/60°C (140°F)
panel temperature



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 400 - P 500



Wet Sanding
P 600 - P 1000



Paint over
with all HB BODY
Mix Systems

FOR PLASTIC PARTS



Dry sanding
P 180 - P 220
(never with
a scotch brite)



4:1 mix with BODY 625
Hardener for Primers
Pot life
55 - 70 min/23°C (73°F)



Addition 50 - 60% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
16 - 18 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.3 - 1.4 mm
2 - 2.5 bar (29-36 psi)
inlet pressure
2-3 coats = 60 - 80 µm
(2.4-3.1mil)

HVLP Spray gun
1.3 - 1.4 mm
1.5 - 2 bar (22-29 psi)
inlet pressure
2-3 coats = 60 - 80 µm
(2.4-3.1mil)



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



Drying time
1 - 2h/23°C (73°F)



Dry Sanding
P 400 - P 500



Wet Sanding
P 600 - P 1000



Paint over
with all HB BODY
Mix Systems

AS "WET ON WET"



4:1 mix with
H 729 NORMAL
Hardener for Primers
Pot life 45 min
/23°C (73°F)



Addition 50 - 60% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
16 - 18 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.3 - 1.4 mm
2 - 2.5 bar (29-36 psi) inlet pressure
1-2 coats = 20 - 30 µm (0.8-1.2mil)

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



Flash off time
20 - 30 min
/23°C (73°F)



Paint over
with all HB BODY
Mix Systems

NOTES

A.
On a "wet on wet" application H 729
HARDENER must be used
(Do not use 625 HARDENER).

B.
Never apply "wet on wet" over polyester
fillers. High risk of mapping appearance after
clear coating.



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BODY 635 5:1 HS FILLING PRIMER

2K acrylic filling primer, suitable for spot panel repairs and general automotive refinishes. Excellent adhesion to all metals and unsanded OEM panels (E-COAT). High-filling properties. 5:1 mixing ratio with BODY 625 Hardener for Primers.



5:1 mix with
BODY 635
Hardener for Primers
Pot life
55 - 70 min/23°C (73°F)



Addition 20% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



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



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

HVLP Spray gun 1.5 - 1.7 mm
1.5 - 2 bar (22-29 psi) inlet pressure
2x coats = 120 - 150 µm (4.3-5.9mil)



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



Drying time
1 - 2h/23°C (73°F)
20 - 30 min/60°C (140°F)
panel temperature



Short wave
5 - 8 min
Lamp distance
60 - 70 cm



Dry Sanding
P 400 - P 500



Wet Sanding
P 600 - P 1000



Paint over
with all
HB BODY
Mix Systems



BODY 607 4:1 UHS FILLING PRIMER

2k acrylic primer with excellent filling properties, fast drying and easy sanding. Easy to apply in thick layers even on vertical surfaces due to its high viscosity formula. 4:1 mixing ratio with BODY 625 Hardener for Primers.



4:1 mix with BODY 625
or H725, H729
Hardeners for Primers
Pot life
60 min/23°C (73°F)



Addition 20±5% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



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



Compliant Spray gun
1.5 - 1.8 mm
2 - 2.5 bar (29-36 psi)
inlet pressure
2x coats = 110 - 150 µm (4.3-5.9mil)

HVLP Spray gun 1.5 - 1.7 mm
1.5 - 2 bar (22-29 psi) inlet pressure
2x coats = 110 - 150 µm (4.3-5.9mil)



Flash off time
10 min/20-23°C
(68°F - 73°F)



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



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



Dry Sanding
P 320 - P 400



Wet Sanding
P 600 - P 1000



Paint over
with all
HB BODY
Mix Systems



BODY 680 1K FILLING PRIMER

A fast-drying 1K filling primer, suitable for all kinds of paints (synthetic - single coat or basecoat). Apply in thin layers, over sanded areas only.



2:1 mix with
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
27 - 29 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.5 - 1.8 mm
2 - 2.5 bar (29-36 psi) inlet pressure
2x coats = 60 - 80 µm (2.4-3.2mil)

HVLP Spray gun
1.5 - 1.7 mm
1.5 - 2 bar (22-29 psi) inlet pressure
2x coats = 60 - 80 µm (2.4 - 3.2mil)



Flash off time
5 - 10 min/23°C (73°F)



Drying time
1 - 2h/23°C (73°F)
10 min/60°C (140°F)
panel temperature



Short wave
3 - 5 min
Lamp distance
60 - 70 cm



Dry Sanding
P 320 - P 500



Wet Sanding
P 600 - P 1000



Paint over
with all
HB BODY
Mix Systems

CLEAR COATS



BODY 691 CLEAR UHS SR 2:1

High-build, 2K Ultra HS 2:1 clear coat with great levelling, high gloss, and superior coverage. Easy to apply for all types of refinishing (partial, full, and spot repair). Use with Hardeners for Topcoats H752 SLOW, H753 NORMAL, H754 FAST.



2:1 mix with H752 SLOW
H753 NORMAL, H754 FAST
Hardeners for Topcoats
Pot life > 6h 23°C (73°F)



Addition 10 - 20% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
16 - 17 s
DIN 4/20°C (68°F)



Compliant Spray gun 1.3 – 1.4 mm
2 - 3 bar (29-44 psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)



HVLP Spray gun 1.2 - 1.3 mm
2 bar (29psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)



Flash off time
10 - 15 min/23°C (73°F)



Drying time
16 - 20 h/23°C (73°F)
25 - 30 min/60°C (140°F)
panel temperature



Short wave
10 - 15 min
Lamp distance
60 - 70 cm

TEMPERATURE	PARTIAL REPAIR	FULL REPAIR
10-15°C (50-59°F)	H754 +10-20% 740	-
15-20°C (59-68°F)	H754 +10-20% 740 H753 +10-20% 740	H753 +10-20% 740
20-25°C (68-77°F)	H754 +10-20% 740 H753 +10-20% 740	H753 +10-20% 740
25-30°C (77-86°F)	H754 +10-20% 740 H754 +10-20% 741 H753 +10-20% 740 H752 +10-20% 740	H753 +10-20% 740 H753 +10-20% 741 H752 +10-20% 740
>30°C (86°F)	H753 +10-20% 740 H752 +10-20% 740	H752 +10-20% 740 H752 +10-20% 741



BODY 697 CLEAR HS SR 2:1

2K HS 2:1 clear coat with high gloss and fast hardening properties. Use with Hardener BODY 620 or Hardener for Topcoats H752 SLOW, H753 NORMAL, H754 FAST.



2:1 mix with BODY 620 Hardener
H752 SLOW, H753 NORMAL
H754 FAST Hardeners for Topcoats
Pot life > 7h 23°C (73°F)



Addition 0-5% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
13 - 16 s
DIN 4/20°C (68°F)



Compliant Spray gun 1.3 – 1.4 mm
2 - 3 bar (29-44 psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)



Flash off time
5 - 10 min/23°C (73°F)



Drying time
8 - 14 h/23°C (73°F)
20 - 30 min/60°C (140°F)
panel temperature



Short wave
8 - 10 min
Lamp distance
60 - 70 cm

HVLP Spray gun 1.2 - 1.3 mm
2 bar (29psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)





BODY 698 CLEAR HS SR 2:1

2K HS 2:1 clear coat with excellent levelling, high gloss, and long-lasting protection. Fast hardening properties for spot panels and full repairs. Easy to apply due to its high viscosity formula. Use with Hardener BODY 620 or Hardener for Topcoats H752 SLOW, H753 NORMAL, H754 FAST.



2:1 mix with BODY 620 Hardener
H752 SLOW, H753 NORMAL
H754 FAST Hardeners for Topcoats
Pot life > 4h 23°C (73°F)



Addition 5 - 15% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
17 - 19 s
DIN 4/20°C (68°F)



Compliant Spray gun 1.3 – 1.4 mm
2 - 3 bar (29-44 psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)



Flash off time
5 - 10 min/23°C (73°F)



Drying time
8 - 16 h/23°C (73°F)
20 - 30 min/60°C (140°F)
panel temperature



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

HVLP Spray gun 1.2 - 1.3 mm
2 bar (29psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)

APPLICATION WITH

BODY 620 / H754 FAST Hardener

TEMP.	ORANGE PEEL TEXTURE 1-2 PARTS	LEVELLING SURFACE 1-2 PARTS	FULL REPAIR
10-15°C (50-59°F)	H754/620 + 5-10% 740 20 min / 60°C (140°F)	H754/620 + 5-15% 740 20 min / 60°C (140°F)	H754/620 + 5-15% 740/741 20 min / 60°C (140°F)
15-25°C (59-77°F)			
25-30°C (77-86°F)	H754/620 + 5-10% 740/741 20 min / 60°C (140°F)	H754/620 + 5-15% 740/741 20 min / 60°C (140°F)	
>30°C (86°F)			

APPLICATION WITH

H753 NORMAL / H752 SLOW Hardener

TEMP.	ORANGE PEEL TEXTURE 1-2 PARTS	LEVELLING SURFACE 1-2 PARTS	FULL REPAIR
10-15°C (50-59°F)	H753 + 5-10% 740 30 min / 60°C (140°F)	H753 + 5-15% 740 30 min / 60°C (140°F)	H753 + 5-15% 740 30 min / 60°C (140°F)
15-25°C (59-77°F)			
25-30°C (77-86°F)	H752/H753 + 5-10% 740/741 30 min / 60°C (140°F)	H752/H753 + 5-15% 740/741 30 min / 60°C (140°F)	H752/H753 + 5-15% 740/741 30 min / 60°C (140°F)
>30°C (86°F)			



BODY 699 CLEAR HS SR 2:1

2K HS 2:1 clear coat. Due to its high gloss retention, excellent levelling, and fast hardening properties, it is suitable for spot panels and full automotive repairs. Use with Hardeners for Topcoats H752 SLOW, H753 NORMAL & H754 FAST.



2:1 mix with
H752 SLOW, H753 NORMAL,
H754 FAST
Hardener for Topcoats
Pot life > 4h 23°C (73°F)



Addition 0 - 10% of
740 ACRYL NORMAL
or 741 ACRYL SLOW
Thinner/Reducer



Ready to spray
15 - 16 s
DIN 4/20°C (68°F)



Compliant Spray gun
1.3 – 1.4 mm
2 - 3 bar (29-44 psi) inlet pressure
2x coats = 50 - 60 µm (2-2.4mil)



Flash off time
8 - 12 min /23°C (73°F)
(68°F - 73°F)



Drying time
14-18h/23°C (73°F)
20 - 30 min /60°C (140°F)
panel temperature



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

TEMP.	ORANGE PEEL TEXTURE 1-2 PARTS	LEVELLING SURFACE 1-2 PARTS	PARTIAL REPAIR	FULL REPAIR
10-15°C (50-59°F)	H754 20 min / 60°C (140°F)	H754 +max 10% 740 20 min / 60°C (140°F)	H754 +max 10% 740/741 20 min / 60°C (140°F)	H753 +max 10% 740 30 min / 60°C (140°F)
15-25°C (59-77°F)		H753 +max 10% 740 30 min / 60°C (140°F)		
25-30°C (77-86°F)	H754 +max 10% 740 20 min / 60°C (140°F)	H754 +max 10% 740/741 20 min / 60°C (140°F)	H754 +max 10% 740/741 20 min / 60°C (140°F)	H753 +max 10% 740/741 30 min / 60°C (140°F)
>30°C (86°F)		H753 +max 10% 740/741 30 min / 60°C (140°F)		
	H753 +max 10% 740 30 min / 60°C (140°F)	H753 +max 10% 740 30 min / 60°C (140°F)	H752 +max 10% 740/741 30 min / 60°C (140°F)	H752 +max 10% 741 30 min / 60°C (140°F)

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