



Product Training

Body Filler

A brand of

 **BASF**

We create chemistry



Body Filler

Sanding of baslac bodyfillers and primerfillers

Material	Sanding with orbital sander 	Manual wet sanding 
12-20	P 80 / P 150 P 240 overlapping area	
20-24	P 400	P 800
20-34	P 400	P 800
20-94	P 400	P 800
25-30	P 400	P 800
27-10		P 800



Bodyfiller

12-20 Bodyfiller Universal

12-20 is a coarse and fine bodyfiller with high solids, fast drying, easy to sand and good adhesion.

It is universally suitable for use on steel sheet, galvanised steel and aluminium.

Mix bodyfiller 12-20 and red hardener paste 56-20 well before use, do not exceed 3% of hardener, as excess peroxide will cause discoloration in the finish.



Bodyfiller

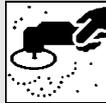
1. Application **Bodyfiller Universal 12-20**

	Mixing ratio	100% by weight 2-3% by weight	12-20 56-20
	Potlife	1 h / 20°C	

Bodyfiller

2. Drying / sanding

Bodyfiller 12-20

	Drying at 20°C	20 - 30 min.
	Infrared (short wave) (medium wave)	4 min. 5 - 10 min.
	Dry sanding Orbital sander	P80 / P150 Guide coat P240 body-filled area and old paintwork



Bodyfiller

The most common mistakes in handling Body Filler

Adding too little hardener

May result in defective curing and the resultant difficulties. Too much catalyst remaining unused may cause discoloration of the topcoat.

Adding too much hardener

Excessive addition of hardener will cause the peroxide to “bleed”, which results in staining of the topcoat.

Excessive film build

This might cause cracking during or after the curing process.



Bodyfiller

The most common mistakes in handling bodyfiller

Insufficient film build

This may cause the body filler to cure incompletely and to adhere insufficiently to the substrate. Another result of this mistake, too, may be a bleeding tendency which will be greatly reinforced – as it is in the event of incorrect addition of hardener – by applying the primer filler/surfacer and finish system wet on wet and by cutting short the flash-off times.



Bodyfiller

The most common mistakes in handling bodyfiller

Wrong bodyfiller temperature

Body filler temperatures of less than 15°C may have a negative impact on the knifing properties and the ductility of the material, thus impairing the surface quality. As a rule, the most common mistakes, i.e. excessive or insufficient addition of hardener, can be avoided by using dispenser systems. These dispenser systems should have an adjustable dispensing valve for the hardener and the body filler that will ensure that the two components are measured out correctly.

Apart from manually operated models, pneumatic dispensers are available, too.

If the hardener needs to be added manually, this is best controlled by means of scales.



Bodyfiller

For coarse or fine filling, apply the product evenly avoiding pores.

Pores and air trapped in the body filling product will sink after some time, becoming visible in the finish surface as crater-shaped holes.



Because of their hygroscopic (water-attracting) properties, polyester-based products may be processed using dry sanding systems only.

Water will soon cause blistering and damage to the paintwork



Blistering caused by wet sanding



Bodyfiller

Sanding Bodyfiller

For all sanding operations, the correct sequence of grit sizes must be respected.

Working on overlapping areas, using ever finer grit sizes from P80 to the finest type P400, ensures that the deeper sanding scratches will be worked over in each operation and thus removed. Sanding guide powder provides visual control over the removal of scratches

Bodyfiller

Sanding Body Filler



1. Coarse sanding



2. Transition



3. Sanding

