



SYSTEM INFORMATION

Glasurit® - Infrared repair process

1. Application



Process for refinishing with infrared drying using a cassette heater with temperature regulation.

2. Properties

Infrared drying significantly shortens the drying time. That leads to a reduction of throughput times, lower energy costs, shorter process times and improved curing performance enabling you to continue working (such as polishing) earlier.

3. Additional information

We recommend this refinishing method especially for small vertical surfaces that can be dried with a cassette heater with temperature regulation in one drying cycle.

	Pre-treatment		
		Clean 1x	Glasurit 700-10 Degreasing and cleansing agent
		Wipe dry	
		P80 – P150	Sand damaged areas down to the bare metal
		Clean 1x	Glasurit 700-10 Degreasing and cleansing agent
		Wipe dry	
Please note: Alternatively, you may use 360-4 or 541-5.			

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		Body Filler			
		+ 2 – 3%	Glasurit 839-20/-20K Multi-Purpose Body Filler		
			Glasurit 948-36 Hardener Paste, red		
			Time	Temperature increase	Max. surface temperature
			4 min.	20°C / min.	80°C
			P80 / P150 coarse sanding		
			P240 / P320 fine sanding		
		Clean 1x	Glasurit 700-1 Cleaner		
	Wipe dry				
Please note: Depending on the damaged area, you can also use 839-25.					

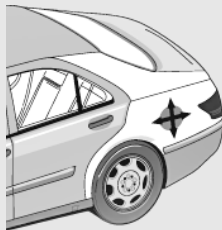
		Primer			
		1 : 1 + 30%	Glasurit 283-25 Etch Primer, beige		
			Glasurit 583-10 Activator		
			Glasurit 352-91 Reducer		
			HVLP 1.3 – 1.7 mm 2.0 bar		
		1	5 – 10 µm		
			Time	Temperature increase	Max. surface temperature
			4 min.	15°C / min.	60°C
Please note: After a flash-off time of > 24 h it is necessary to de-nib the surface.					

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	HS Primer Filler			
	4 : 1 : 1 mixing stick	Glasurit 285-555 /-655 /-505 HS Primer Filler		
		Glasurit 929-55 / -56 HS Filler Hardener		
		Glasurit 352-91 / -216 Reducer		
		HVLP 1.7 – 1.9 mm 2.0 bar		
	2	50 – 70 µm		
		Time	Temperature increase	Max. surface temperature
		4 min.	15°C / min.	60°C
		5 min.	20°C / min.	80°C
		P400		
	Clean 1x	Glasurit 700-1 Cleaner		
	Wipe dry			
Alternatively, all Glasurit 285- primer fillers can be used.				

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		Basecoat		
		2 : 1 mixing stick	Glasurit 90 Line Basecoat	
			Glasurit 93-E 3 Adjusting Base	
			HVLP 1.3 mm 2.0 bar	
		2 + ½	10 – 15 µm	
			Flash off until mat between spraycoats	
		Time	Temperature increase	Max. surface temperature
		4 min.	15°C / min.	60°C
<p>Please note: The flash-off time can be reduced by using blow equipment or by briefly increasing the temperature to up to 45°C.</p>				

		Clear		
		2 : 1 + 10% mixing stick	Glasurit 923-335 HS Multi Clear	
			Glasurit 929-33 / -34 VOC Hardener	
			Glasurit 352-91 / -216 Reducer	
			HVLP 1.3 mm 2.0 bar	
		½ + 1	40 – 50 µm	
		Time	Temperature increase	Max. surface temperature
		4 min.	15°C / min.	60°C
		4 min.	20°C / min.	90°C
<p>Please note: Apply clear to vertical surfaces only. Alternatively, all Glasurit 923- clears can be used.</p>				

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Cleaning	Glasurit 700-10 Degreasing and cleansing agent	 1x	 Wipe dry	Sand damaged areas down to the bare metal	 P80 - P150	Glasurit 700-10 Degreasing and cleansing agent	 1x	 Wipe dry	
Body Filler (Coarse + fine)	Glasurit 839-20/-20K Multi-Purpose Body Filler	Glasurit 948-36 Hardener Paste, red	 + 2-3%	 4 min.	 P80/P150 coarse sanding	 P240/P320 fine sanding	Glasurit 700-1 Cleaner	 1x	 Wipe dry
Primer	Glasurit 283-25 Etch Primer	Glasurit 583-10 Activator	Glasurit 352-91 Reducer	 1 : 1 + 30% mixing stick	 HVLP 1.3-1.7 mm 2.0 bar	 1 thin 5-10 µm	 4 min.		
Primer Filler	Glasurit 285-505 HS Primer Filler	Glasurit 929-55 / -56 HS Filler Hardener	Glasurit 352-91 / 216 Reducer	 4:1:1 mixing stick	 HVLP 1.7-1.9 mm 2.0 bar	 2	 9 min.	 P400	 P 800
Alternatively:	Glasurit 285- Primer Filler								
Basecoat	Glasurit 90 Line Basecoat	Glasurit 93-E 3 Adjusting Base	 2:1 mixing stick	 HVLP 1.3 mm 2.0 bar	 2 + ½	 Flash off until mat between spraycoats	 4 min.		
Clear	Glasurit 923-335 HS Multi Clear	Glasurit 929-33 / -34 VOC Hardener	Glasurit 352-91 / -216 Reducer	 2:1 + 10% mixing stick	 HVLP 1.3 mm 2.0 bar	 ½ + 1	 8 min.		

Safety advice:

The products are suitable for professional use only.

It cannot be ruled out that this product contains particles < 0.1 µm.

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