



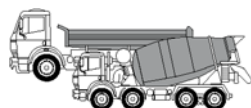
TECHNICAL INFORMATION

284-13

Glasurit 2K-CV-Chassis Filler
beige-grey

PF

Range of application:



chassis painting, container, construction machinery (steel), steel and galvanized steel spare parts

Performance:

- suitable on all Glasurit CV primer
- suitable for large areas / surfaces
- chromate free with good corrosion protection
- good coverage of shot blasted profile
- brilliant top coat appearance
- outstanding application characteristics
- tintable

Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm
The products are suitable for professional use only.

2004/42/IIIB (c I)(540)520: The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. **The VOC content of this product is 520 g/l.**

Substrates:

- = very well suited
- = well suited
- = suited in some cases

Steel	Galvanized steel	Stainless steel	Aluminium	Anodized Aluminium	GRP / SMC	PP-EPDM	Glasurit CV - Primer	Glasurit CV - Primer Filler / Filler	Powder coating	Coil-Coating	Plywood	Wood	OEM-PAint work	old paint work
●●	●				●●		●●		●	●	●●	●●	●	●●

Remarks:

The substrate should be clean, free of dust, rust, oil and grease
Aluminum-Chassis have be primed with a suitable primer



Painting process

CV 4, CV 11, CV Race 1

Spreading rate

≈ 404 m² / l / 1µm

Solid content

≈ 68 %





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	Mixing ratio	4 : 1 : 1 by volume		
	Hardeners	922-18 PRO / 922-16 PRO		
	Reducer	352-216, slow	15 - 20°C	
		352-345, very slow	20 - 25°C	
		352-370, extra slow	25 - 30°C	
	Viscosity DIN 4 / 20° C	25 s. DIN 4	Potlife 20 °C	2 h

Application parameter		 Compliant - gravity feed cup	 HVLP - Spray gun	 Suction cup	 Airless/Airmix (ESTA)	 Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.2 – 2.5	2.0	2.5	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0.8 – 1.5
Nozzle size	mm	1.6 – 1.8	1.5 – 1.7	1.5 – 1.7	0.28 – 0.33	1.0 – 1.1
Voltage	kV				50 - 80	
Elect. Resistance	Ω				300 - 500	
Spray coats		2	2	2	1 - 2	2
Flash - off	min.	without	without	without	without	without
Filmbuild	µm	60 - 70				

Drying		 Over-coatable	 Tack-free	 Ready for masking	 Ready to assamble	 Sandable
		min	max			
Object temp.	20°C	60 min	72* h	2 h	16 h	16 h
Object temp.	60°C	30 min.		30 min.	30 min.	45 min.

Remarks



Can be tinted with up to 10% of 68 Line Topcoat for the 2nd spray coat.
To plasticize the product, mix it 4 : 1 by volume (using the mixing stick) with 522-111 Softface Additive before adding hardener.
Can be overcoated with CV topcoats of Lines 68, 58, 55, 90.
For tinting see CV Primer Tinting Paste 568-408 !
Mixing ratio 5:1:1 by vol. = higher viscosity, e. g. for rough-blasted substrates.
On hot-dip galvanized steel, adhesion must be tested beforehand.
* Line 55 and 90 have to be applied within 1 working day.
With UP spray filler (see CV 11) Apply 1 full coat ~30 - 40µm.