

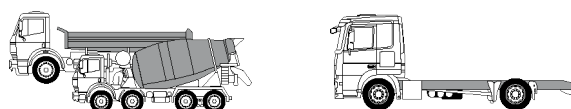
284-13

284-13 Variant for rough-blasted substrates (5:1:1)



A brand of BASF –
We create chemistry

Application:



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

Key Features:

- for rough-blasted substrates

Remarks:

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

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-Paintwork	Old paint work
●●	●				●●		●●		●	●	●●	●●	●	●●



Mixing Ratio

5 : 1 : 1 by volume



Hardener

922-18 Pro, -16 Pro



Reducer

352-320, -330, -340

Potlife at 20°C

2 h

Safety advice:

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)508: 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 508 g/l.

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BASF Coatings GmbH - Automotive Refinish Coatings Solutions Europe - Glasuritstrasse 1 - 48165 Münster - Germany

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Application:	Compliant - gravity feed cup	HVLP spray gun	Suction cup	Airless/ Airmix	Pressure pot dbl.-pump
Application pressure	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
Material pressure				120-150 bar	0.8-1.5 bar
Nozzle size	1.6-1.8	1.5-1.7	1.5-1.7	0.28-0.33	1-1.1
Voltage				50-80 kV	
Elect. Resistance				300-500 Ω	
Number of coats	2	2	2	1-2	2
Flash off at 20°C	without	without	without	without	without
Film thickness	60-70 µm				



Drying	Overcoatable		Tack-free	Ready for masking	Ready to assemble	Sandable
	Min.	Max.				
Object Temp. 20°C	60 min	72 h	2 h	16 h	16 h	16 h
Object Temp. 60°C	30 min		30 min	30 min	30 min	45 min

Remark

Can be tinted with up to 10% of 68 line topcoat for the 2nd spray coat.
To plasticize the product, see variant with P-A-912 Flex additive.
Can be overcoated with CV topcoats of lines 68, 58, 55.*
For tinting see variant with CV Primer Tinting Paste 568-408.
On hot-dip galvanized steel, adhesion must be tested beforehand.
* Has to be applied within 72h with 68 line, within one working day with 55 line.

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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