

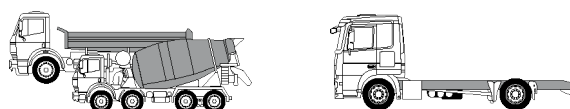
284-13

284-13 Variant with P-A-912



A brand of BASF –
We create chemistry

Application:



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

Remarks:

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

Substrates	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
●● = Very well suited	●●	●				●●		●●		●	●	●●	●●	●	●●
● = well suited															
○ = suited in some cases															

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.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at www.glasurit.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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Pre Mix

To plasticize the product, mix it 4 : 1 by volume with P-A-912 Flex Additive before adding hardener.



Mixing Ratio

4 : 1 : 1 by volume



Hardener

922-18 Pro, -16 Pro



Reducer

352-320, -330, -340



Spray viscosity at 20°C

DIN 4: 25 s

Potlife at 20°C

2 h

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				

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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.
 For tinting see variant with 568-408.
 Can be overcoated with CV topcoats of lines 68, 58, 55.*
 Mixing ratio 5:1:1 for rough-blasted substrates see variant.
 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.
 With UP spray filler apply 1 full coat ~30-40 µm.

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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