

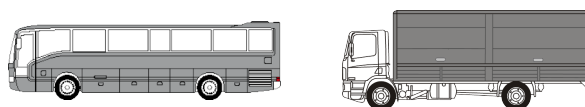
# 284-30

284-30 Variant with 522-111



A brand of BASF –  
We create chemistry

**Application:**



busses, cabs (refurbishing), boxes, busses (repair)

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
 • 352-216, slow 15 - 20°C  
 • 352-345, very slow 20 - 30°C

**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
●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●

**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)517:** 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 517 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](http://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 522-111 Softface Additive before adding hardener.


**Mixing Ratio**

4 : 1 : 1 by volume


**Hardener**

922-18 Pro, -16 Pro


**Reducer**

352-216, -345


**Spray viscosity at 20°C**

DIN 4: 18-22 s

**Potlife at 20°C**

2 h

Application:		Compliant - gravity feed cup	HVLV spray gun	Suction cup	Airless/ Airmix	Pressure pot dbl.-pump
<b>Application pressure</b>	bar	2.2-2.5	2	2.5	2	2.5
<b>Material pressure</b>	bar				120-150	0.8-1.5
<b>Nozzle size</b>		1.6-1.8	1.7	1.7	0.28-0.33	1-1.1
<b>Voltage</b>	kV				50-80	
<b>Elect. Resistance</b>	Ω				1700-2000	
<b>Number of coats</b>		2	2	2	2	2
<b>Flash off at 20°C</b>	min	10-15	10-15	10-15	10-15	10-15
<b>Film thickness</b>	µm	70-90				

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**Drying**

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

**Remark**

Dry sanding after 16 h at 20°C or 45 min. at 60°C. Can be tinted by adding up to 10% of 68 line topcoat. For tinting see variant with CV Primer Tinting Paste 568-408  
Sanded areas have to be overcoated within 72h with 68 Line, within one working day with 55 Line, otherwise the adhesion promoter 285-0 CV has to be used.

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