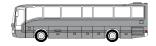
## 284-45

284-45 Variant with 522-111



Application:





busses, plastic painting, cabs (color change), boxes, daylight fluoroscent paint

**Key Features:** 

- 284-45 white (greyshade 08)
- · good adhesion to various plastics
- · brilliant top coat appearance
- · good leveling
- filler for daylight fluorocent paint and for 2 step colors
- tintable

• overcoatable with Glasurit topcoat Line 58, 68, 55

Remarks:

The substrate should be clean, free of dust, rust, oil and grease.

Substrates  • = Very well suited • = well suited • = suited in some cases	Steel	Galvanized steel	Staineless steel	Aluminium	Anodized Aluminium	GRP / SMC	PP-EPDM	Glasurit CV - Primer	Glasurit CV - Primer Filler / Filler	Powder coating	Coil-coating	Plywood	Mood	OEM-Paintwork	Old paint work	
						••	•	••	••	••	••	••	••	••	••	

## Safety advice:

It cannot be ruled out that this product contains particles < 0.1  $\mu m$ .

The products are suitable for professional use only.

2004/42/IIB (c I)(540)456: 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 456 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.

# 284-45

284-45 Variant with 522-111





Pre Mix

To plasticize the product, mix it 4:1 by

volume with 522-111 Softface Additive before adding hardener.



**Mixing Ratio** 

2:1 + 10 - 30% by volume



Hardener

922-180 Pro



Reducer

352-320, -330



Spray viscosity at 20°C

DIN 4: 17-21 s

Potlife at 20°C

1.5 h

Application:		Compliant - gravity feed cup	HVLP spray gun	Suction cup	Airless/ Airmix	Pressure pot dblpump
Application pressure	bar	2.2-2.5	2	2.5	2	2.5
Nozzle pressure	bar					0.8-1.5
Material pressure	bar				120-150	
Nozzle size		1.4-1.6	1.5	1.7	0.28-0.33	1-1.1
Voltage	kV				50-80	
Elect. Resistance	Ω				600-800	
Number of coats		1.5	1.5	1.5	1.5	1.5
Flash off at 20°C	min	without	without	without	without	without
Film thickness	μm	50-70				

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284-45

284-45 Variant with 522-111



$\bigcirc$	Drying	Overco	atable	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 r	nin	30 min	30 min	30 min	45 min	

#### Remark

Can be tinted by adding up to 10% of 68 line topcoat. For tinting see 284-45 variant with 568-408. For sanding the filmthickness should be 80  $\mu$ m (50 – 60  $\mu$ m after sanding) and the drying time has to be 45 min 60°C or 16 h 20 °C. Sandthroughs have to covered by using a suitable primer.

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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