## 284-45

284-45 Variant with P-A-912



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Application:



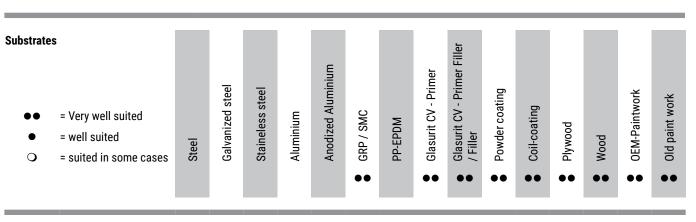
Key Features:

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

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

- tintable
- overcoatable with Glasurit topcoat Line 58, 68, 55

Remarks:



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.

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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	2:1 + 10 - 30% by volume
Ð	Hardener	922-180 Pro
) L	Reducer	352-320, -330, -340
<b>∏</b> ₅	Spray viscosity at 20°C	DIN 4: 17-21 s
	Potlife at 20°C	1.5 h

Application:	Compliant -	🖌 HVLP spray gun 🅈	N Suction cup		Pressure pot dblpump
Application pressure	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
Nozzle pressure					0.8-1.5 bar
Material pressure				120-150 bar	
Nozzle size	1.4-1.6	1.5	1.7	0.28-0.33	1-1.1
Voltage				50-80 kV	
Elect. Resistance				600-800 Ω	
Number of coats	1.5	1.5	1.5	1.5	1.5
Flash off at 20°C	without	without	without	without	without
Film thickness	50-70 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 ı	nin	30 min	30 min	30 min	45 min

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.

time has to be 45 min 60°C or 16 h 20 °C. Sandthroughs have to covered by using a suitable primer.

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