



TECHNICAL INFORMATION

568-20 Glasurit HAFLEX Additive (Adhesion promotor plastic)

Z

Range of application:



plastic painting

Performance:

- good adhesion to various plastics
- high efficiency
- use for example in 284-45

Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm
The products are suitable for professional use only.

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-PAint work	old paint work
						●●							●	●

Remarks:

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



Painting process

CV 5

Spreading rate

≈ 408 m² / l / 1µm

Solid content

≈ 8 %

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Mixing ratio 2 : 1 + 10% by volume (284-45)



Hardeners 922-180 PRO



Reducer 568-20



Viscosity 20 – 22 s DIN 4 **Potlife 20°C** 2 h
DIN 4 / 20° C

Application parameter		Compliant - gravity feed cup	HVLP - Spray gun	Suction cup	Airless/ Airmix	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.2 – 2.5	2.0	2.5	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0.8 - 1.5
Nozzle size	mm	1.4 - 1.6	1.5 - 1.7	1.7	0.28 - 0.33	1.0 - 1.1
Voltage	kV	-	-	-	60 - 70	-
Elect. Resistance	Ω	-	-	-	600 - 800	-
Spray coats		1 - 2	1 - 2	1 - 2	1	1 - 2
Flash - off	min.	without	without	without	without	without
Filmbuild	µm	20 - 30 *				



Drying



Over-coatable



Tack-free



Ready for masking



Ready to assemble



Sandable

min max

Object temp. 20°C 60 min. 72 h

Object temp. 60°C 30 min.

Remarks



ABS, GRP, SMC, PC: 284-45 with 922-180 PRO and 352-216 / .345 (2 : 1 + 10%);

PA, PP-EPDM, 284-45 with 922-180 PRO and 568-20 (2 : 1 + 10%);

PP, PE: (adhesion can not be guaranteed) 284-45 with 922-180 PRO and 568-20 (2 : 1 + 10%);

*Higher dry film thickness possible (50 - 60 µm)

Attention: Due to different raw material supplier the quality of the different plastics can be differ from time to time. The adhesion should be check before painting individually.

See D-Part Tables Painting of different Plastics and/or Painting Process CV 5 for further details