

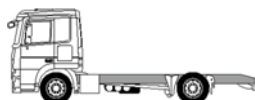


TECHNICAL INFORMATION

568-46 (DTM) Glasurit CV Steel Primer Paste 1-layer system

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Range of application:



chassis painting, chassis (color change), container

Performance:

- tintable
- suitable for large areas / surfaces
- good leveling
- can be applied directly on steel or galvanized steel
- high efficiency
- good corrosion protection

Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm

The products are suitable for professional use only.

2004/42/IIB (d)(420)419: The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/l. **The VOC content of this product is 419 g/l.**

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:

Aluminum-Chassis have be primed with a suitable primer

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



Painting process

CV 4.1

Spreading rate

≈ 503 m² / l / 1µm

Solid content

≈ 80 %

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Pre mix
AD 68 with 568-46

mix 568-46 with line 68 in the ratio 1 : 1



Mixing ratio

7 : 1 + 10 - 15% by volume



Hardeners

922-138, 922-136 or 922-139



Reducer

352-91, normal 15 - 20°C
352-216, slow 20 - 25°C
352-345, very slow 25 - 30°C



Viscosity
DIN 4 / 20° C

30 - 40 s. DIN 4

Potlife 20 °C

2 h

Application parameter



**Compliant -
gravity feed
cup**



**HVLP - Spray
gun**



Suction cup



**Airless/
Airmix**



**Pressure pot
Dble.-Memb.
Pump**

		Compliant - gravity feed cup	HVLP - Spray gun	Suction cup	Airless/ Airmix	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.2 - 2.5	2	2	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0,8 - 1,5
Nozzle size	mm	1.6 - 1.8	1.7 - 1.9	1.7 - 1.9	0.28 - 0.33	1.0 - 1.3
Voltage	kV	-	-	-	50 - 80	-
Elect. Resistance	Ω	-	-	-	700 - 1500	-
Spray coats		2	2	2	1 - 2	2
Flash - off	min.	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
Filmbuild	µm	70 - 100				



Drying



**Over-
coatable**



Tack-free



**Ready for
masking**



**Ready to
assemble**



Sandable

		min	max				
Object temp.	20°C	16 h	2 h	16 h	16 h	16 h	16 h
Object temp.	60°C	30 min.	30 min.	30 min.	30 min.	30 min.	30 min.

Remarks



The shelf life of the mixed product (Line 68 top coat and 568 - 46) is only 2 weeks.
The DTM version is not suitable for areas that are directly exposed to sunlight.
The corrosion protection can only be achieved, if the required film thickness is applied (covering of sand blasting roughness, edges). Mixing of 568-46 can change the color.
The adhesion on hot dipped galvanized steel has to be checked before.