



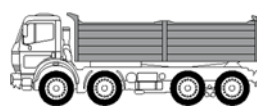
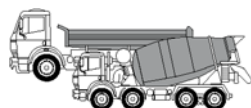
TECHNICAL INFORMATION

568-46

Glasureit CV Steel Primer Paste,
2-layer system

PF

Range of application:



construction machinery (steel), chassis painting, chassis (color change), container, steel and galvanized steel spare parts

Performance:

- suitable for large areas / surfaces
- can be applied directly on steel or galvanized steel
- tintable
- good coverage of shot blasted profile
- brilliant top coat appearance
- improves the hiding power

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/IIIB (c II)(540)530: The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. **The VOC content of this product is 530 g/l.**

Substrates:

- = very well suited
- = well suited
- = suited in some cases

Steel	Galvanized steel	Stainless steel	Aluminium	Anodized Aluminium	GRP / SMC	PP-EPDM	Glasureit CV - Primer	Glasureit 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

≈ ~540 m² / l / 1µm

Solid content

≈ 80 %

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568-46 Glasurit CV Steel Primer Paste 2-layer system

PF



Pre mix
AD 68 with 568-46

mix 568-46 (70 parts) with line 68 (30 Parts)



Mixing ratio

7 : 1 + 15 - 25% 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

25 - 35 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**

Application parameter	bar	2.2 - 2,5	2	2.5	2	2.5
Atomization pressure	bar	2.2 - 2,5	2	2.5	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 - 1.1
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	60 - 70				



Drying



**Over-
coatable**



Tack-free



**Ready for
masking**



**Ready to
assemble**



Sandable

min. max

Object temp.	20°C	60 min.	72 h	16 h
Object temp.	60°C	30 min.		30 min.

Remarks



The shelf life of the mixed product (Line 68 top coat and 568 - 46) is only 2 weeks.
The corrosion protection can only be achieved, if the required film thickness is applied (covering of sand blasting roughness, edges)
The adhesion on hot dipped galvanized steel has to be checked before.