

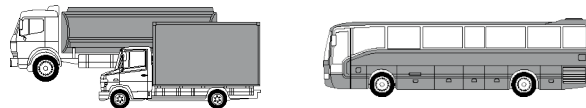


A brand of BASF –
We create chemistry

68-Line (568-M 135)

68- HS 2K CV Topcoat, glossy

Application:



all applications

Key Features:

- suitable on all Glasurit CV primer filler and filler
- suitable for large areas / surfaces
- very good appearance and flow
- excellent UV resistance
- fast drying
- excellent surface hardness
- good hiding power

Remarks:

The substrate should be clean, free of dust, rust, oil and grease.
The complete color range for CV-application is covered.
Best appearance in combination with hardener 922-139 slow Premium.

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

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-Paintwork	Old paint work
●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	○	○	○	○

Safety advice:

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

The e products are suitable for professional use only.

2004/42/IIIB (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.

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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Spreading rate 536 m²/l at 1 µm

Solid Content ~ 69 %



Mixing Ratio 4 : 1 : 1 by volume



Hardener 922-139, -138, -136



Reducer 352-216, -345, -91 CV



Spray viscosity at 20°C DIN 4: 18-22 s

Potlife at 20°C 1.5 h

Application:		Compliant - gravity feed cup	HVL spray gun	Suction cup	Airless/ Airmix	Pressure pot dbl.-pump
Application pressure	bar	2.2-2.5	2	2.5		2.5
Material pressure	bar					0.8-1.5
Nozzle size		1.4	1.5	1.7		1-1.1
Number of coats		1.5	1.5	1.5		1.5
Flash off at 20°C	min	without	without	without		without
Film thickness	µm	40-60				

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Drying

Overcoatable

Tack-free

Ready for masking

Ready to assemble

Sandable

Min. Max.

Object Temp. 20°C

16 h

2.5 h

16 h

12 h

16 h

Object Temp. 60°C

30 min

30 min

30 min

30 min

30 min

Remark

Application: Pre-spray 1 thin grip coat with the finishing coat following immediately Process times: ~ 45 min. with 922-136 / ~ 1h with 922-138 and ~ 2h with 922-139. Drying 30 min. at 60°C with 922-138, 45 - 60 min. at 60°C with 922-139 Recoatable with itself without intermediate sanding for up to 16 hours after application of first coat. Pre-spray adhesion promoter 285-0 CV prior to multi-colour finishing if painted surface was baked or flashed off for 16 h. Airless or Airmix - Use 568-M 100 instead of 568-M 135.

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