

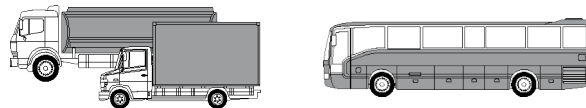


A brand of BASF –
We create chemistry

568-M 135

68 Line PLUS Efficient Topcoat

Application:



Key Features:

- very good appearance, flow and finish
- suitable for large and small areas
- very good UV and chemical resistance
- quick and easy application with 1,5 spray coats
- very good surface hardness
- good opacity

Remarks:

The substrate should be clean, free of dust, rust, oil and grease.
The complete color range for CV application is covered.

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
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Spreading rate 511 m²/l at 1 µm

Solid Content (rfu) ~ 58- 66 %

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/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.

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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Mixing Ratio 4 : 1 : 1 by volume



Hardener 922-138, -139, -136



Reducer 352-315, -320, -330



Spray viscosity at 20°C DIN 4: 20-23 s

Potlife at 20°C 1.5 h

Application:	Compliant - gravity feed cup	HVLV spray gun	Suction cup	Airless/ Airmix	Pressure pot dbl.-pump
Application pressure	1.8-2.2 bar	2 bar	2.5 bar	2 bar	2.5 bar
Material pressure				120-180 bar	0.8-1.5 bar
Nozzle size	1.3-1.4	1.5	1.7	0.23-0.28	1-1.1
Voltage				50-80 kV	
Elect. Resistance				700-1500 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	40-60 µm				

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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.
 Airless or Airmix: Use mixing clear 568-M 100 instead of 568-M 135.
 Best appearance in combination with hardener 922-139 slow Premium
 Potlife: ~1h with 922-136 / ~ 1,5h 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.
 Use Scotch Pad and pre-spray adhesion promoter 284-10 if painted surface was force dried at 60°C or dried at 20°C for 16h.

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.

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