

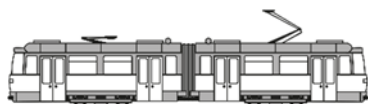


# TECHNICAL INFORMATION

## 802-3012 Glasurit EP CV-Primer RS beige-red

# P

### Range of application:



Vehicle manufacturing, chassis, transportation

### Performance:

- Approved on blasted steel (3-layer system) acc to DB TL918300 (Page 3 & Page 34)
- Tested and approved (3-layer system) acc to fire and smoke EN 45545-2 (Hazard Level 1-3)
- 802-3012 needs to be over coated with 284-45 and topcoat 68 line
- Cromate free outstanding corrosion protection
- Good topcoat finish and levelling
- Suitable for large areas / surfaces

### 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 (c II)(540)483:** 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 483 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:

Steel: shot blasting acc standard grade of cleanliness SA 21/2 DIN EN ISO 12944 part 4. The substrate should be clean, free of dust, rust, mill scale, old paintwork, oil and grease.

\* Aluminium: Due to the large number of different aluminum alloys, the coating of large areas of vehicles (e. g. dropsides) or the close-to-production line coating of vehicles must be tested from a technological standpoint beforehand.



Painting process

CV 14

Spreading rate

≈ 456 m<sup>2</sup> / l / 1µm

Solid content

≈ 64 %





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](http://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.








# TECHNICAL INFORMATION

## 802-3012 Glasurit EP CV-Primer RS beige-red

# P

	<b>Mixing ratio</b>	4 : 1 : 1 by volume		
	<b>Hardeners</b>	965-3012		
	<b>Reducer</b>	352-170	15 - 20°C	
		352-170	20 - 25°C	
		352-170	25 - 30°C	
	<b>Viscosity DIN 4 / 20° C</b>	~ 32 - 36 s. DIN 4	<b>Potlife 20 °C</b>	6 h

Application parameter		 Compliant - gravity feed cup	 HVLP - Spray gun	 Suction cup	 Airless/Airmix	 Pressure pot Dble.-Memb. Pump
<b>Atomization pressure</b>	<b>bar</b>	2.2 – 2.5	2.0	2.5	2	2.5
<b>Paint pressure</b>	<b>bar</b>	-	-	-	120 - 150	0.8 – 1.5
<b>Nozzle size</b>	<b>mm</b>	1.4 – 1.8	1.7	1.7	0.28 – 0.33	1.0 – 1.1
<b>Voltage</b>	<b>kV</b>	-	-	-	-	-
<b>Elect. Resistance</b>	<b>Ω</b>	-	-	-	-	-
<b>Spray coats</b>		2	2	2	1.5 - 2	1.5 - 2
<b>Flash - off</b>	<b>min.</b>	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
<b>Filmbuild</b>	<b>µm</b>	50 - 60				

	 Drying	 Over-coatable		 Tack-free	 Ready for masking	 Ready to assemble	 Sandable
		min	max				
<b>Object temp.</b>	<b>20°C</b>	12h	72h	-	-	-	-
<b>Object temp.</b>	<b>60°C</b>	90 Min.		-	-	-	-

**Remarks** **!** Minimum ambient temperature during application and drying: +15°C  
 Mixing ratio 4:1:1 for normal spray gun application,  
 adjust for Airmix or Airless 4:1 + ~5-10% with 352-170 EP.