



TECHNICAL INFORMATION

924-68 Glasurit HS 2K CV Clearcoat

C

Range of application:



busses, sign writing, metallic coating (line 90), boxes, busses (repair), bus repair

Performance:

- suitable for large areas / surfaces
- good leveling
- excellent UV resistance
- outstanding application characteristics
- excellent gloss level

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 (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.**

Remarks:

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



Painting process

CV 6, CV 9

Spreading rate

≈ 417 m² / l / 1µm

Solid content

≈ 54 %





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	Mixing ratio	3 : 1 : 1 by volume		
	Hardeners	922-138 or 922-136		
	Reducer	352-216, slow	15 - 20°C	
		352-345, very slow	20 - 25°C	
		352-370, extra slow	25 - 30°C	
	Viscosity DIN 4 / 20° C	18 - 22 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
Atomization pressure	bar	2.2 – 2.5	2	2.5					2.5	
Paint pressure	bar	-	-	-					0.8 – 1.5	
Nozzle size	mm	1.3 - 1.4	1.5	1.7					1.0 - 1.1	
Voltage	kV	-	-	-					50 - 80	
Elect. Resistance	Ω	-	-	-					600 - 1500	
Spray coats		1 ½	1 ½	1 ½					1 ½	
Flash - off	min.	without	without	without					without	
Filmbuild	µm	40 - 60								

		Drying				Tack-free		Ready for masking		Ready to assemble		Sandable
			min	max								
Object temp.	20°C		16 h	2 h	16 h	12 h	16 h					
Object temp.	60°C		30 min.	30 min.	30 min.	30 min.	30 min.					

Remarks ! Pre-spray 1 light coat, then apply 1 wet coat for flow.
 Recoatable with itself for up to 16 hours after application of first coat, after force drying and 16 hours air drying the adhesion promoter 285-0 CV has to be sprayed first.