

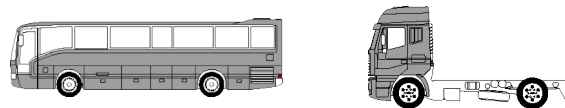
# 924-68

924-68 Variant with 568-409



A brand of BASF –  
We create chemistry

**Application:**



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

**Key Features:**

- prevents micro foam during the airless application
- no influence on the surface characteristic

**Remarks:**

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

- 352-216, slow 15 - 20°C
- 352-345, very slow 20 - 25°C
- 352-370, extra 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
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**Safety advice:**

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.






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.






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	<b>Pre Mix</b>	100% 924-68 + 1-3% 568-409 by volume.
	<b>Mixing Ratio</b>	3 : 1 : 1 by volume
	<b>Hardener</b>	922-138, -136, -139
	<b>Reducer</b>	352-216, -345, -370
	<b>Spray viscosity at 20°C</b>	DIN 4: 18-22 s

Application:	 Compliant - gravity feed cup	 HVLP spray gun	 Suction cup	 Airless/ Airmix	 Pressure pot dbl.-pump
<b>Application pressure</b>	<b>bar</b>			2	
<b>Material pressure</b>	<b>bar</b>			120-180	
<b>Nozzle size</b>				0.23-0.28	
<b>Voltage</b>	<b>kV</b>			50-80	
<b>Elect. Resistance</b>	<b>Ω</b>			700-1500	
<b>Number of coats</b>				1.5	
<b>Flash off at 20°C</b>	<b>min</b>			without	
<b>Film thickness</b>	<b>µm</b>			40-60	

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## Drying

	Overcoatable		Tack-free	Ready for masking	Ready to assemble	Sandable
	Min.	Max.				
<b>Object Temp. 20°C</b>		16 h	2 h	16 h	12 h	16 h
<b>Object Temp. 60°C</b>	30 min		30 min	30 min	30 min	30 min

## Remark

Pre-spray 1 light coat, then apply 1 wet coat for flow.  
Recoatable with itself for up to 16 hours after application, after force drying and 16 hours at 20°C the adhesion promoter 285-0 CV has to be sprayed first.

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