

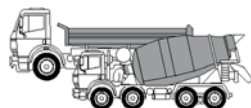


TECHNICAL INFORMATION

AD 68 / 568 M 124 Glasurit HS 2K CV Topcoat 568-M 124 CV Matting Mixing Clear

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Range of application:



all applications where a reduced gloss is required, construction machinery (steel), chassis painting, chassis (color change)

Performance:

- all gloss levels can be achieved
- suitable on all Glasurit CV primer filler and filler
- suitable for large areas / surfaces
- good leveling
- excellent UV resistance
- Excellent surface hardness
- good hiding power

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 (e)(840)830: The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/l. **The VOC content of this product is 830 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
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Remarks:

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

The complete color range for CV-application is covered



Painting process

Can be used for all CV Painting Processes.

Spreading rate

≈ 536 m² / l / 1µm

Solid content

≈ 67 %

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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Pre mix

Line 68 u. 568-M 124 Matt Mixing Clear 5 : 1 Vol.
exchange Mixing clear M 135 to 568-M 124
exchange Mixing clear M 135 to 568-M 124
and add 568-M 124 in mixing ratio 5 : 1

= Gloss 75-85 E / 60 °
= Gloss 70-85 E / 60 °

= Gloss 50-65 E / 60 °



Mixing ratio

5 : 1 : 1 by volume



Hardeners

922-139, 922-138 or 922-136



Reducer

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



Viscosity DIN 4 / 20° C

18 - 22 s. DIN 4

Potlife 20 °C

1.5 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	2.5
Paint pressure	bar	-	-	-	120 - 180	0.8 – 1.5
Nozzle size	mm	1.4	1.5	1.7	0.23 – 0.28	1.0 – 1.1
Voltage	kV	-	-	-	50 - 80	-
Elect. Resistance	Ω	-	-	-	700 - 1500	-
Spray coats		2	2	2	2	2
Flash - off	min.	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
Filmbuild	µm	40 - 60				



Drying



Over-coatable



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.

Remarks



Application: After the first thin coat a flash off of 10-15 min is required, after the second coat flash off until matt.

Attention: hardeners do affect gloss level, mentioned values of gloss with M124 based on drying 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.

For alternative gloss levels see handbook index block D labels.

Due to the reduced gloss level not suitable for blend in processes