



Rail vehicles

CV 14

Application: i. e. painting / refurbishing or rail & train vehicles

Substrates: Blasted steel

- Approved for 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)

Pre-treatment

Steel: blasting acc standard grade SA 2 ½

Primer

801-3012

Hardener: 965-3012
Reducer : 352-170

4 : 1 : 1

Equipment : gravity-feed spraygun*
Spray coats : 2
Film thickness: 50 – 60 µm
Drying : 12h at 20° or
1,5h at 60°C

Surfacer

284-45

Hardener:
922-180 PRO
Reducer : 352-345

2 : 1 +10%

Equipment : gravity-feed spraygun*
Spray coats : 1½
Film thickness: 50 - 70 µm
Drying : 30 min. 60°C panel temp.
or 1 h at 20°C

Topcoat

68-

Hardener: 922-138
Reducer : 352-216

4 : 1 : 1

Equipment : gravity-feed spraygun*
Spray coats : 1½
Film thickness: 40 – 60 µm
Drying : overnight air drying
16 h at 20°C or
30 min. 60°C

Remark

To cover the roughness of the shot blasted areas and achieve proper corrosion resistance the above mentioned film thickness needs to be achieved.

* = See product data sheet for other equipment.

Safety instructions

- It cannot be ruled out that this product contains particles < 0.1 µm.
- The products are suitable for professional use only.
- For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.