



# Chassis painting

## CV 4.1

Application: Chassis painting  
 Substrates: Steel , galvanised steel – 1- or 2-layer

### Pre-treatment

Cleaning – Sanding – Cleaning (see chapter A4)

### Body filling

839-20 + 948-36; 100 : 3 Sanding with P80 / P150

#### 1-layer-system

**DTM Topcoat**

**568-46** } 1:1  
 Topcoat: 68- }  
 Hardener: 922-138 } 7 : 1 +  
 Reducer.: 352-216 } 10-15%

Equipment : gravity-feed spraygun\*  
 Spray coats : **2 wet-on-wet**  
 Film thickness: **70 - 100 µm**  
 Flash-off : overnight air drying or  
 30 min. at 60°C  
 panel temp.

#### 2-layer-system

**Chassisfiller**

**568-46** } 70:30  
 Top coat: 68- }  
 Hardener: 922-138 } 7 : 1 +  
 Reducer.: 352-216 } 15-25%

Equipment : gravity-feed spraygun\*  
 Spray coats : **2 wet-on-wet**  
 Film thickness: **60 - 70 µm**  
 Flash-off : 60 min. at 20°C or  
 30 min. at 60°C  
 panel temp.

**Topcoat**

**68-**  
 Hardener: 922-138 } 4 : 1 : 1  
 Reducer : 352-216 }

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

**Remark**

To cover the roughness of the sand blasted areas the above mentioned film thickness has 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.