



Chassis painting

CV 4

Application: Chassis painting
Substrates: Steel, aluminium

Pre-treatment	Abrasive blast-cleaning (See Technical Information Sheet A 4)		
Body filling	839-20 + 948-36;	100 : 3	Sanding with P80 / P150

Pre-prime aluminium chassis with	283-6150	} 2 : 1 + 10%	Equipment : gravity-feed spraygun*
	Activator : 352-235 Reducer : 352-216		Spray coats : 1½ Film thickness: 12 - 15 µm Flash-off : at least 20 -30 min. 20°C max 8 h at 20°C

Chassis Surfacer	284-13	} 4 : 1 : 1	Equipment : gravity-feed spraygun*
	Hardener: 922-18 PRO Reducer : 352-216		Spray coats : 2 Film thickness: 60 - 70 µm Flash-off : at least 60 min. at 20°C 30 min. at 60°C

Alternative:

Primer Filler	284-90	} 3 : 1 + 30%	Equipment : gravity-feed spraygun *
	Hardener: 922-180 PRO Reducer. : 352-216		Spray coats : 2 Film thickness: 50 - 70 µm Flash-off : at least 60 min. at 20°C 30 min.at 60°C

Alternative:

Primer filler	9-7	} 4 : 1	Equipment : gravity-feed spraygun *
	Additive :568-96		Spray coats : 2 Film thickness: 50 - 60 µm Flash-off : at least 60 min. at 20°C 30 min. at 60°C

Topcoat	68-	} 4 : 1 : 1	Equipment : gravity-feed spraygun *
	Hardener: 922-138 Reducer : 352-216		Spray coats : 1½ Film thickness: 40 - 60 µm Drying : overnight air drying (16 h at 20°C) or 30 min.at 60°C

* = See product data sheet for other equipment.

Safety instructions	<ul style="list-style-type: none"> • 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.
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