



# **Glasurit RATIO-TRUCK System**

## **Paint Systems for CV Finishing**

### **- Compact Version -**

**According to EU Decopaint Directive  
2004/42/IIIB**

**09/2022**



## Product list

A 1

### Cleaning agents

541-5	Glasurit Wax and Silicone Remover	SV20-0305
541-30	Glasurit Cleaner Plastics	SV20-0330
360-4	Glasurit Metal Cleaner	SV22-0380
700-1	Glasurit Cleaner	SV99-0378
700-10	Glasurit Degreasing and Cleaning Agent	SV99-0310

### Body fillers

839-15	Glasurit CV Flexible Body Filler, grey beige	SP69-7015
839-20	Glasurit Multi-purpose Body Filler, white	SP69-0020
839-45	Glasurit CV Flexible Body Filler, light grey	SP69-7045
1006-26	Glasurit HS Polyester Spray Filler	SP60-7026

### Undercoat materials

9-7	Glasurit CV Steel Primer, grey beige	AB09-7777
183-153	Glasurit Shop Primer, red brown,	AB83-8198
283-6150	Glasurit CV Wash Primer, yellow	AB83-6150
283-1870	Glasurit CV-Multi-Wash, beige,	AB83-1870
284-13	Glasurit 2K CV Chassis Surfacer, beige grey	AB84-7135
284-55	Glasurit 2K CV UHS Primer Filler, white	AB84-0U48
284-45	Glasurit CV Filler, white	AC84-0045
284-30	Glasurit CV RATIO-TRUCK Sanding Filler, light grey	AC84-7030
284-90	Glasurit CV Primer Filler white	AB84-0090
284-99	Glasurit CV Texture Filler, tintable	AC84-0502
285-0 CV	Glasurit Transparent Sealer CV, clear	AC85-0602
801-705	Glasurit CV-HS Primer Filler EP, light grey,	AC01-7875
801-715	Glasurit CV-HS Primer Filler EP, grey,	AC01-7815

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## Product list

A 1

### HS 2K CV topcoats

68-	Glasurit HS 2K CV Topcoat	AD68-
68- + 568-M 124 CV Matting Mixing Clear	Glasurit HS 2K CV Topcoat + CV Mixing Clear M124	AD68- / AZ68-0124
68-RAL 9006	Glasurit HS 2K CV Topcoat, direct-gloss, metallic, white aluminum	AE68-9006
58-	Glasurit HS 2K CV Chassis Paint, satin gloss MB 7350 nova grey, MB 9124 chassis black, MAN 9011 black	AD58-
568-M 135	HS 2K CV Mixing Clear	AZ68-1350
568-M 100	HS 2K CV Airless Mixing Clear	AZ68-0100
568-M 124	CV Matting Mixing Clear	AZ68-0124

### Daylight Colours

923-	Glasurit Daylight Fluorescent Paint, luminous yellow, orang luminous red	AD23-1026 AD23-2005 AD23-3024
923-49	Glasurit Protective Clear for Daylight Fluorescent Paint	AF 23-0049

### Metallic / solid-colour basecoats

90 CV PLUS-	Glasurit Basecoat, Metallic's / Solids mixed from mixing system,	AH/AJ90-
93-E 3 CV PLUS	Glasurit Adjusting Base	AZ93-0602
90-M 4 CV PLUS	Glasurit Waterborne Mixing Base	AK50-0602
90-M+A	Glasurit mixing base concentrates for the mixing system	
90-VE	Glasurit Deionised Water	AZ90-0101

### Clears

924-68	Glasurit HS 2K CV Clear	AF24-0068
924-168	Glasurit HS Bus Clear	AF24-0168

### Stone chip and underbody protection

1109-1240/4	Glasurit Stone Chip and Underbody Protection, black	FT90-9400
1109-1503/3	Glasurit Stone Chip and Underbody Protection, grey	FT90-7104

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## Product list

A 1

### Hardeners for body fillers

948-22	Glasurit Hardener for Glasurit 1006-26 HS Polyester Spray Filler	SB48-0220
948-36	Glasurit Hardener Paste, red	SB48-3360

### Hardeners for undercoats, epoxy primer fillers and etch primers

352-235	Glasurit Activator, slow	SC12-0235
965-55	Glasurit CV-Hardener EP for Glasurit CV HS- Primer Filler EP 801-705	SC65-0555
965-715	Glasurit CV EP Hardener for CV EP Primer Filler 801-715	SC65-0715

### 2K PU acrylic hardeners for undercoats and topcoats

922-16 PRO	Glasurit 2K CV Hardener, fast	SC22-0116
922-18 PRO	Glasurit 2K CV Hardener, normal	SC22-0118
922-180 PRO	Glasurit 2K CV Filler Hardener	SC22-0180
922-55 PRO	Glasurit 2K CV Primer Filler Hardener UHS	SC22-0U03
922-136	Glasurit 2K CV Topcoat Hardener, fast	SC22-0136
922-138	Glasurit 2K CV Topcoat Hardener, normal	SC22-0138
922-139	Glasurit 2K CV Topcoat Hardener, slow	SC22-0139

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## Product list

A 1

### 2K-Hardeners for daylight colours and protective clear

929-91	Glasurit 2K HS Toccoat Hardener, fast	SC29-0091
929-93	Glasurit 2K HS Toccoat Hardener, normal	SC29-0093
929-94	Glasurit 2K HS Toccoat Hardener, slow	SC29-0094

### Additives

568-17	Glasurit CV Multi-Colour Additive	AZ68-0012
568-20	Glasurit HAFLEX (Plastic Adhesion Promoter)	AZ68-0020
568-46	Glasurit Steel Primer Paste	AZ68-0046
568-96	Glasurit Express Reducer	AZ68-0906
522-111	Glasurit Softface Additive	AZ22-0111
568-405	Glasurit CV Texture Additive	AZ68-0405
568-407	Glasurit CV Brush and Roll Additive	AZ68-0407
568-408	Glasurit CV Primer Tinting Paste	AZ68-0408
568-409	Glasurit CV Airless Additive	AZ68-0409
568-412	Glasurit CV Thix Additive	AZ68-0412
568-720	Glasurit CV protective additive EP normal	AZ68-0720
568-745	Glasurit CV protective additive EP slow	AZ68-0745
360-100	Glasurit PRO Active wipes	AZ76-0100

### Reducers and thinners

352-310	Glasurit Reducer, extra fast	SV41-1310
352-315	Glasurit Reducer, fast	SV41-1315
352-320	Glasurit Reducer, medium	SV41-1320
352-330	Glasurit Reducer, slow	SV41-0333
352-340	Glasurit Reducer, extra slow	SV41-0344
352-500	Glasurit Blend-in Reducer	SV99-0500

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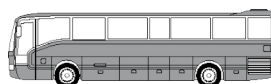
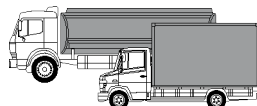
# TECHNICAL INFORMATION

839-15

Glasurit CV Flexible Body Filler  
grey-beige

**BF**

## Range of application:



## Performance:

- fast sandable
- good filling properties
- high flexible alignment for welding seams

## 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 (b)(250)219:** The EU limit value for this product (product category: IIB.b) in ready to use form is max. 250 g/l. **The VOC content of this product is 219 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
●●			●●		●			●	●	●	●	●●	●	●

## Remarks:

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



## Painting process

Spreading rate

Solid content ≈ 99 %

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BASF Coatings GmbH, Automotive Refinish Coatings Solutions Europe, Glasuritstrasse 1, 48165 Münster, Deutschland

09/2022



# TECHNICAL INFORMATION

839-15      Glasurit CV Flexible Body Filler  
grey-beige

**BF**



**Mixing ratio**      100 : 3



**Hardeners**      948-36



**Reducer**



**Viscosity**  
DIN 4 / 20° C

**Potlife 20 °C**

4 min.



**Drying**



**Over-  
coatable**

min      max



**Tack-free**



**Ready for  
masking**



**Ready to  
assemble**



**Sandable**

**Object temp.**      20°C

30 min.

**Object temp.**      60°C

## Remarks

!

Can be sanded after 30 min.

Highly flexible product, for example for welding seams on tankers.

On zinc, before body-filling, EP 801-715 CV Primer Filler (30 - 40 µm, 45 min. 60°C) or 284-13 CV primer filler (20 - 25 µm, 20 min. 60°C) must be applied as adhesion promoter.

Do not use on wash primer or acid-pre-treated surfaces!





# TECHNICAL INFORMATION

839-20

Glasurit Multi Purpose Body Filler  
white

BF

## Range of application:



## Performance:

- fast drying
- suitable on all substrates
- good filling properties
- fast sandable

## 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 (b)(250)180:** The EU limit value for this product (product category: IIB.b) in ready to use form is max. 250 g/l. **The VOC content of this product is 180 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
●●	●●	○	●●		●			●	●	●	●	●	●	●

## Remarks:

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



Painting process

Spreading rate

Solid content ≈ 96 %

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# TECHNICAL INFORMATION

839-20 Glasurit Multi Purpose Body Filler  
white

**BF**



**Mixing ratio**

100 : 2 - 3% by weight



**Hardeners**

948-36



**Reducer**



**Viscosity**  
DIN 4 / 20° C

**Potlife 20 °C**

4 min.



**Drying**



**Over-coatable**

min

max



**Tack-free**



**Ready for  
masking**



**Ready to  
assemble**



**Sandable**

**Object temp.** 20°C

20 - 30 min.

**Object temp.** 60°C

**Remarks**



Can be sanded after 20 - 30 min.

Not suitable for applications that require elasticity, e.g., welding seams.

Do not use on acid-hardening products or substrates pre-treated with acid.



# TECHNICAL INFORMATION

839-45

Glasurit CV Flexible Body Filler  
light grey

**BF**

## Range of application:



## Performance:

- suitable for large areas / surfaces
- high flexible alignment for welding seams
- long pot life
- temperature resistance up to 180°C

## 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 (b)(250)180:** The EU limit value for this product (product category: IIB.b) in ready to use form is max. 250 g/l. **The VOC content of this product is 180 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
●●			●●		●			●	●	●	●	●●	●	●

## Remarks:

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



Painting process

Spreading rate

Solid content ≈ 98 %

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# TECHNICAL INFORMATION

839-45 Glasurit CV Flexible Body Filler  
light grey

**BF**



**Mixing ratio** 100 : 3



**Hardeners** 948-36



**Reducer**



**Viscosity**  
DIN 4 / 20° C

**Potlife 20 °C**

20 min.



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

**Object temp.** 20°C

2,5 h

**Object temp.** 60°C

**Remarks**

!

Highly flexible product, for example for welding seams on tankers. Temperature resistant up to 180°C. On zinc, before body-filling, EP 801-715 CV Primer Filler (30 - 40 µm, 45 min. 60°C) or 284-13 CV primer filler (20 - 25 µm, 20 min. 60°C) must be applied as adhesion promoter. Do not use on wash primer or acid-pre-treated surfaces!



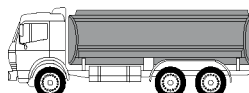
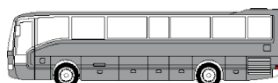
# TECHNICAL INFORMATION

1006-26

Glasurit UP Spray Filler, grey

**BF**

## Range of application:



## Performance:

- good filling properties
- fast drying
- fast sandable

## 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 (b)(250)249:** The EU limit value for this product (product category: IIB.b) in ready to use form is max. 250 g/l. **The VOC content of this product is 249 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.



## Painting process

### Spreading rate

≈ 551 m<sup>2</sup> / l / 1µm

**Solid content (RFU)** ≈ 72 % (≈ 73%)

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# TECHNICAL INFORMATION

1006-26

Glasurit UP Spray Filler, grey

**BF**



**Mixing ratio**

100 : 5 by volume



**Hardeners**

948-22



**Reducer**






max 2% 352-310 (by weight)



**Viscosity**  
DIN 4 / 20° C

**Potlife 20 °C**

30 min.

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		2.5		
Paint pressure	bar	--		-		
Nozzle size	mm	2.5 – 3.0		2.5 – 3.0		
Voltage	kV	-		-		
Elect. Resistance	Ω	-		-		
Spray coats		3 - 8		3 - 8		
Flash - off	min.					
Filmbuild	µm	> 200 max. 1000				



**Drying**



**Over-coatable**

min      max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

**Object temp. 20°C**

3 - 4 h

3 - 4 h

**Object temp. 60°C**

30 min.

30 min.

**Remarks**

!

Do not overcoat etch wash primer or acid pre treated substrates with 1006-26!

Use only dry sanding for 1006-26. Galvanized steel must be primed with 283-1870 and 284-13 (max. 30 - 40 µm). For temperature less than 15°C or to speed up the drying the amount of 948-22 can be increased up to 7,5 vol.%.

Cool storage, shelf life 8 month at 20°C.

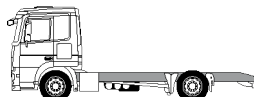


# TECHNICAL INFORMATION

## 1109-1240/4 Glasurit Stone Chip and Underbody protection, black

X

### Range of application:



structure effect, stone chip protection, underbody protection

### Performance:

- can be used on all Glasurit PU and EP CV primer fillers and fillers
- high flexible
- outstanding application characteristics

### 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/IIB (e)(840)32:** 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 32 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
								●●					●●	●●

### Remarks:

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



### Painting process

#### Spreading rate

≈ 379 m<sup>2</sup> / l / 1µm

#### Solid content

≈ 55 %

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# TECHNICAL INFORMATION

## 1109-1240/4 Glasurit Stone Chip and Underbody protection, black

X



Mixing ratio



Hardeners



Reducer



Viscosity  
DIN 4 / 20° C

Application parameter		Compliant - gravity feed cup	HVLP - Spray gun	Suction cup	Airless/Airmix	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2 – 2.5		2 – 2.5	2 - 4	2.5
Paint pressure	bar	-		-	120 - 180	2
Nozzle size	mm	3 - 4		3 - 5	0.41 – 0.5	3 - 4
Voltage	kV	-		-	-	-
Elect. Resistance	Ω	-		-	-	-
Spray coats		2 - 6		4 - 6	2 - 6	2 - 6
Flash - off	min.					
Filmbuild	µm	500-1000/ 40-50				



Drying



Over-coatable

min max



Tack-free



Ready for masking



Ready to assemble



Sandable

Object temp. 20°C

6 h

Object temp. 60°C

### Remarks



For usage as Stoneprotection filler the filmbuild is 40 - 50µm. Therefore the material can be thinned with max. 5% DE-water. Protect from frost.



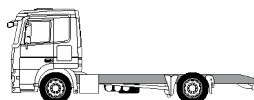


# TECHNICAL INFORMATION

## 1109-1503/3 Glasurit Stone Chip and Underbody protection, grey

X

### Range of application:



structure effect, stone chip protection, underbody protection

### Performance:

- high flexible
- can be used on all Glasurit PU and EP CV primer fillers and fillers
- outstanding application characteristics

### 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)25:** 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 25 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
								●●					●●	●●

### Remarks:

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



### Painting process

**Spreading rate** ≈ 395 m<sup>2</sup> / l / 1µm

**Solid content** ≈ 56 %

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09/2022



# TECHNICAL INFORMATION

1109-1503/3 Glasurit Stone Chip and Underbody protection, grey

X



Mixing ratio



Hardeners



Reducer



Viscosity  
DIN 4 / 20° C

Application parameter		Compliant - gravity feed cup	HVLP - Spray gun	Suction cup	Airless/Airmix	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2 – 2.5		2 – 2.5	2 - 4	2
Paint pressure	bar	-		-	120 - 180	2.5
Nozzle size	mm	3 - 4		3 - 5	0.41 – 0.5	3 - 4
Voltage	kV	-		-	-	-
Elect. Resistance	Ω	-		-	-	-
Spray coats		2 - 6		4 - 6	2 - 6	2 - 6
Flash - off	min.					
Filmbuild	µm	500 - 1000				



Drying



Over-coatable

min max



Tack-free



Ready for masking



Ready to assemble



Sandable

Object temp. 20°C

6 h

Object temp. 60°C

Remarks



Can be thinned with 3% water if required. Protect from frost.



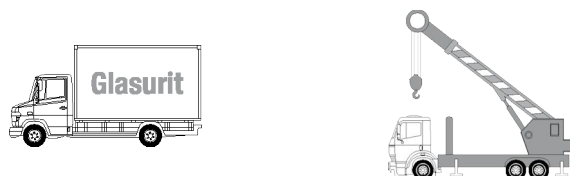
# TECHNICAL INFORMATION

183-153

Glasurit Shop Primer,  
red-brown

P

## Range of application:



construction machinery (steel), container

## Performance:

- fast to assemble
- fast drying
- weldable
- temporary corrosion protection

## 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 (c III)(780)714:** The EU limit value for this product (product category: IIB.c III) in ready to use form is max. 780 g/l. **The VOC content of this product is 714 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
●●	●●												●	●

## Remarks:

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



## Painting process

### Spreading rate

≈ 206 m<sup>2</sup> / l / 1µm

### Solid content (RFU)

≈ 38% (≈ 31%)

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# TECHNICAL INFORMATION

## 183-153 Glasurit Shop Primer, red-brown

P



**Mixing ratio**

4 : 1 by volume



**Hardeners**



**Reducer**

352-310, extra fast  
**352-310, extra fast**  
352-315, fastl

15 - 20°C  
**20 - 25°C**  
25 - 30°C



**Viscosity**  
DIN 4 / 20° C

22 - 25 s. DIN 4

Application parameter		Compliant - gravity feed cup	HVLP - Spray gun	Suction cup	Airless/ Airmix	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.5	2.0	2.5		2.5
Paint pressure	bar	-	-	-		0.8 - 1.5
Nozzle size	mm	1.6 - 1.8	1.7	1.7		1.0 - 1.1
Voltage	kV	-	-	-		-
Elect. Resistance	Ω	-	-	-		-
Spray coats		2	2	2		1 - 2
Flash - off	min.	10 - 15	10 - 15	10 - 15		10 - 15
Filmbuild	μm	20 - 25				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

**Object temp.** 20°C

10 min.

8 h

**Object temp.** 60°C

**Remarks**

!

The product is ready for application with a brush.  
Shop Primer cannot be directly over coated with topcoat or polyester products.  
All CV PUR Primer Filler/ Filler can be used to overcoat.  
Panels treated with 183-153 are very easy to weld.  
The adhesion on hot dipped galvanized steel has to be checked before.



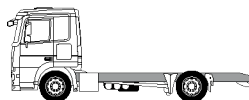
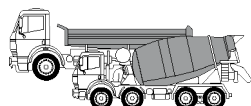
# TECHNICAL INFORMATION

9-7

Glasurit CV Steel Primer,  
grey-beige

PF

Range of application:



construction machinery (steel), chassis painting (steel/ aluminum), steel and galvanized steel spare parts

Performance:

- tintable
- very good corrosion protection
- good coverage of shot blasted profile
- high efficiency
- outstanding application characteristics

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/IIB (c I)(540)504:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. **The VOC content of this product is 504 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
●●	○									○		○	●●	●●

Remarks:

Aluminum-Chassis have be primed with a suitable primer.

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



Painting process

Spreading rate

≈ 440 m<sup>2</sup> / l / 1µm

Solid content (RFU)

≈ 72% (≈ 64%)

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# TECHNICAL INFORMATION

## 9-7 Glasurit CV Steel Primer, grey-beige

# PF



**Mixing ratio** 4 : 1 by volume



**Hardeners**



**Reducer** 568-96



**Viscosity** 18 - 20 s. DIN 4  
DIN 4 / 20° C

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	2.0	2.5	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0.8-1.5
Nozzle size	mm	1.6 – 1.8	1.7	1.7	0.28 – 0.33	1.0 – 1.1
Voltage	kV	-	-	-	50 - 80	-
Elect. Resistance	Ω	-	-	-	1500 - 2000	-
Spray coats		2	2	2	1 - 2	1.5 - 2
Flash - off	min.	without	without	without	without	without
Filmbuild	µm	50 - 60				



**Drying**



**Over-coatable**



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

min max

Object temp.	20°C	60 min.	72 h	1 h	16 h	16 h	16 h
Object temp.	60°C	30 min.		30 min.	30 min.	30 min.	45 min.

**Remarks**



For solvent-sensitive finishes do not use 352- reducers.  
For tinting see CV Primer Tinting Paste 568-408.  
When repainting old/ works paint coat, depending on the condition of the substrate, apply 1 spraycoat 20 - 30µm.



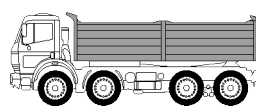
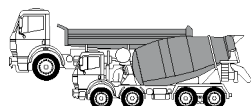
# TECHNICAL INFORMATION

568-46

Glasurit CV Steel Primer Paste,  
2-layer system

PF

## Range of application:



construction machinery (steel), chassis painting, chassis (color change), container, steel and galvanized steel spare parts

## Performance:

- suitable for large areas / surfaces
- can be applied directly on steel or galvanized steel
- tintable
- good coverage of shot blasted profile
- brilliant top coat appearance
- improves the 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 (c II)(540)530:** The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. **The VOC content of this product is 530 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
●●	●●	●			●		●		●	●			●	●

## Remarks:

Aluminum-Chassis have to be primed with a suitable primer

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



## Painting process

Spreading rate ≈ 540 m<sup>2</sup> / l / 1µm

Solid content ≈ 80 %

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# TECHNICAL INFORMATION

## 568-46 Glasurit CV Steel Primer Paste 2-layer system

**PF**



**Pre mix  
AD 68 with 568-46**

mix 568-46 (70 parts) with line 68 (30 Parts)



**Mixing ratio**

7 : 1 + 15 - 25% by volume



**Hardeners**

**922-138** / 922-136 or 922-139



**Reducer**

352-315, fast 15 - 20°C  
**352-320, medium** 20 - 25°C  
352-330, slow 25 - 30°C



**Viscosity  
DIN 4 / 20° C**

25 - 35 s. DIN 4

**Potlife 20 °C**

2 h

**Application parameter**



**Compliant -  
gravity feed  
cup**



**HVLP - Spray  
gun**



**Suction cup**



**Airless/  
Airmix**



**Pressure pot  
Dble.-Memb.  
Pump**

<b>Atomization pressure</b>	<b>bar</b>	2.2 - 2,5	2	2.5	2	2.5
<b>Paint pressure</b>	<b>bar</b>	-	-	-	120 - 150	0.8 - 1.5
<b>Nozzle size</b>	<b>mm</b>	1.6 - 1.8	1.7 - 1.9	1.7 - 1.9	0.28 - 0.33	1.0 - 1.1
<b>Voltage</b>	<b>kV</b>	-	-	-	50 - 80	-
<b>Elect. Resistance</b>	<b>Ω</b>	-	-	-	700 - 1500	-
<b>Spray coats</b>		2	2	2	1 - 2	2
<b>Flash - off</b>	<b>min.</b>	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
<b>Filmbuild</b>	<b>µm</b>	60 - 70				



**Drying**



**Over-  
coatable**



**Tack-free**



**Ready for  
masking**



**Ready to  
assemble**



**Sandable**

<b>Object temp.</b>	<b>20°C</b>	min.	max	
<b>Object temp.</b>	<b>60°C</b>	60 min.	72 h	16 h
		30 min.		30 min.

**Remarks**



The shelf life of the mixed product (Line 68 top coat and 568 - 46) is only 2 weeks.  
The corrosion protection can only be achieved, if the required film thickness is applied (covering of sand blasting roughness, edges)  
The adhesion on hot dipped galvanized steel has to be checked before.



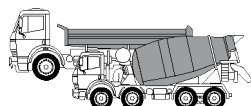
# TECHNICAL INFORMATION

284-13

Glasurit 2K-CV-Chassis Filler  
beige-grey

PF

## Range of application:



chassis painting, container, construction machinery (steel), steel and galvanized steel spare parts

## Performance:

- suitable on all Glasurit CV primer
- suitable for large areas/ surfaces
- very good corrosion protection
- good coverage of shot blasted profile
- brilliant top coat appearance
- outstanding application characteristics
- tintable

## 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 (c I)(540)508:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. **The VOC content of this product is 508 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
●●	●				●●		●●		●	●	●●	●●	●	●●

## Remarks:

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

Aluminum-Chassis have to be primed with a suitable primer.



## Painting process

### Spreading rate

≈ 435 m<sup>2</sup> / l / 1µm

### Solid content (RFU)

≈ 73% (≈ 61%)

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# TECHNICAL INFORMATION

## 284-13 Glasurit 2K-CV-Chassis Filler beige-grey

**PF**



**Mixing ratio** 4 : 1 : 1 by volume



**Hardeners** 922-18 PRO / 922-16 PRO



**Reducer** 352-315, fast 15 - 20°C  
352-330, slow 20 - 25°C  
352-340, extra slow 25 - 30°C



**Viscosity** 25 s. DIN 4 **Potlife 20 °C** 2 h  
DIN 4 / 20° C

Application parameter		Compliant - gravity feed cup	HVLP - Spray gun	Suction cup	Airless/ Airmix (ESTA)	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.2 – 2.5	2.0	2.5	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0.8 – 1.5
Nozzle size	mm	1.6 – 1.8	1.5 – 1.7	1.5 – 1.7	0.28 – 0.33	1.0 – 1.1
Voltage	kV				50 - 80	
Elect. Resistance	Ω				300 - 500	
Spray coats		2	2	2	1 - 2	2
Flash - off	min.	without	without	without	without	without
Filmbuild	µm	60 - 70				



**Drying**



**Over-coatable**



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

min max

<b>Object temp.</b>	<b>20°C</b>	60 min	72* h	2 h	16 h	16 h	16 h
<b>Object temp.</b>	<b>60°C</b>	30 min.		30 min.	30 min.	30 min.	45 min.

**Remarks**

!

Can be tinted with up to 10% of Line 68 Topcoat for the 2nd spray coat.  
To plasticize the product, mix it 4 : 1 by volume with 522-111 Softface Additive before adding hardener. Can be overcoated with CV topcoats of Lines 68, 58, 55.  
For tinting see CV Primer Tinting Paste 568-408.  
Mixing ratio 5:1:1 by vol. = higher viscosity, e. g. for rough-blasted substrates.  
On hot-dip galvanized steel, adhesion must be tested beforehand.  
\* Line 55 has to be applied within 1 working day.  
With UP spray filler apply 1 full coat ~30 - 40µm.



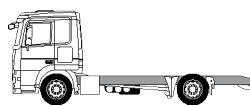
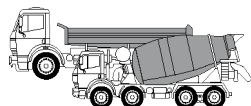
# TECHNICAL INFORMATION

284-55

Glasurit CV UHS Primer Filler  
PUR, white

PF

## Range of application:



Vehicle manufacturing, chassis, transportation

## Performance:

- Ultra High Solid 2K Primer Filler
- fast over coating
- white
- very good corrosion protection
- for usage on large or small areas
- over coating with topcoat 68 line

## 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 (c II)(540)355:** The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. **The VOC content of this product is 355 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
●●	●		●											

## Remarks:

Steel: shot blasting acc standard grade of cleanliness SA 2 ½.

The substrate should be clean, free of dust, rust, mill scale, old paintwork, oil and grease.



## Painting process

### Spreading rate

≈ 600 m<sup>2</sup> / l / 1µm

### Solid content

≈ 84% (ready for use ~ 78%)

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# TECHNICAL INFORMATION

284-55

Glasurit CV UHS Primer Filler  
PUR, white

PF



Mixing ratio

3:1 by Volume



Hardeners

922-55 PRO



Reducer

-



Viscosity  
DIN 4 / 20° C

~ 23 - 28 s. DIN 4

Potlife 20 °C

1 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	-	-	3 - 4	3 - 4
Paint pressure	bar	-			150 - 200	0,8 - 1,2
Nozzle size	mm	1,6 - 1,8	-	-	0,28	1,2 - 1,5
Voltage	kV					
Elect. Resistance	Ω		-	-		
Spray coats		1,5 - 2			1,5 - 2	1,5 - 2
Flash - off	min.	10 - 15	-	-	10 - 15	10 - 15
Filmbuild	µm	60 - 70				



Drying



Over-coatable

min max



Tack-free



Ready for masking



Ready to assemble



Sandable

Object temp.	20°C	1h	72h	-	-	-	-
Object temp.	60°C	30 Min.		-	-	1h	-

Remarks



Minimum ambient temperature during application: +15°C, +3°C above dew-point temperature.  
Application with 2K mixing system recommended.  
After adding hardener mix and stir intensely with an agitator.



# TECHNICAL INFORMATION

## 283-6150 Glasurit CV Wash Primer, yellow 3-layer-system

P

### Range of application:



busses, fire-fighting vehicle, boxes (aluminum), boxes, bulk loading vehicles (aluminum)

### Performance:

- suitable for large areas/ surfaces
- fast drying
- excellent corrosion protection

### 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 (c III)(780)730:** The EU limit value for this product (product category: IIB.c III) in ready to use form is max. 780 g/l. **The VOC content of this product is 730 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
●●	●●	●●	●●	●					○	○			○	○

### Remarks:

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

The pre-treated metallic surface must be coated on the same day to prevent renewed oxidation.



### Painting process

#### Spreading rate

≈ 189 m<sup>2</sup> / l / 1µm

#### Solid content (RFU)

≈ 32% (≈ 22%)

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# TECHNICAL INFORMATION

283-6150 Glasurit CV Wash Primer, yellow,  
3-layer-system

**P**



**Mixing ratio**

2 : 1 + 10% by volume



**Hardeners**

**352-235 / 352-228**



**Reducer**

352-315, fastl 15 - 20°C  
**352-320, medium** 20 - 25°C  
352-330, slow 25 - 30°C



**Viscosity**  
DIN 4 / 20° C

22 - 25 s. DIN 4

**Potlife 20 °C**

8 h

Application parameter		Compliant - gravity feed cup	HVLP - Spray gun	Suction cup	Airless/ Airmix (ESTA)	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.2 – 2.5	2.0	2.5	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0.8 – 1.5
Nozzle size	mm	1.6	1.6	1.7	0.28	1.0 – 1.1
Voltage	kV	-	-	-	-	-
Elect. Resistance	Ω	-	-	-	-	-
Spray coats		1.5	1.5	1.5	1.5	1.5
Flash - off	min.	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
Filmbuild	µm	12 - 15				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

**Object temp. 20°C**

20-30 min. 8 h

**Object temp. 60°C**

**Remarks**

!

Do not overcoat with polyester products. To be used only in 3-stage systems with CV PUR Primer Filler / Filler. Apply filler within one working day (8 hours). 352-228 suitable for repair and small parts. Do not use on blasted substrates. Especially when finishing aluminum substrates, use material that has just been mixed. On hot-dip galvanized steel, adhesion must be tested beforehand.



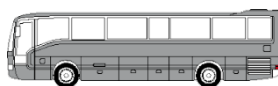


# TECHNICAL INFORMATION

283-1870 Glasurit CV-Multi-Wash  
beige

P / PF

## Range of application:



busses, fire-fighting vehicle, boxes (aluminum), boxes, bulk loading vehicles (aluminum)

## Performance:

- good levelling and flow
- suitable for large surfaces
- quick drying
- excellent corrosion protection
- tintable with max. 3% 568-408
- 2-layer system with topcoat 68 line
- 3-layer system i. e. with 284-30, -45, -90

## 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 (c III)(780)729:** The EU limit value for this product (product category: IIB.c III) in ready to use form is max. 780 g/l. **The VOC content of this product is 729 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
●●	●●	●●	●●	●	○				○	○			○	○

## Remarks:

The substrate should be clean, free of dust, rust, oil and grease.  
The pre-treated metallic surface must be coated on the same day to prevent renewed oxidation.



## Painting process

Spreading rate ≈ 190 m<sup>2</sup> / l / 1µm

Solid content (RFU) ≈ 34% (≈ 22%)

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# TECHNICAL INFORMATION

283-1870 Glasurit CV-Multi-Wash  
beige

**P / PF**



**Mixing ratio** 2 : 1 + 10 - 20% by volume



**Hardeners** 352-235 / 352-228



**Reducer** 352-320, medium 15 - 20°C  
352-320, medium 20 - 25°C  
352-330, slow 25 - 30°C



**Viscosity** 22 - 26 s. DIN 4 **Potlife 20 °C** 8 h  
DIN 4 / 20° C

Application parameter		Compliant - gravity feed cup	HVLP - Spray gun	Suction cup	Airless/ Airmix (ESTA)	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.2 – 2.5	2.0	2.5	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0,8 - 1,5
Nozzle size	mm	1.4 – 1.8	1.5	1.6	0.23	1.0 – 1.1
Voltage	kV	-	-	-	-	-
Elect. Resistance	Ω	-	-	-	-	-
Spray coats		1.5 – 2.5*	1.5 – 2.5*	1.5 – 2.5*	1.5 – 2*	1.5 – 2*
Flash - off	min.	matt	matt	matt	matt	matt
Filmbuild	µm	15 – 20*				



**Drying**



**Over-coatable**  
min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

**Object temp.** 20°C 30 min. 8 h  
**Object temp.** 60°C 10 min.

## Remarks



Do not overcoat 283-1870 directly with polyester- or epoxy-products, basecoat line 90 CV PLUS or line 55.

\* 1,5 - 2 coats (15-20µm) for 3-layer system or 2 - 2,5 spray coats (20-25µm) for 2-layer system with topcoat line 68.

Apply filler or topcoat within one working day (8 hours). 352-228 only suitable for repair and small parts. Do not use on blasted substrates. On anodized alu and hot-dip galvanized steel, adhesion must be tested beforehand.



# TECHNICAL INFORMATION

284-90 Glasurit CV Primer Filler ,PU

PF

## Range of application:



busses, fire-fighting vehicle, boxes, bulk loading vehicles

## Performance:

- 284-90 in white (greyshade 08)
- tintable
- can be used on many substrates
- very good appearance and flow
- good corrosion protection
- all-purpose
- can be over coated with Glasurit Topcoat Line 58, 68, 55

## 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/IIB (c I)(540)480:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. **The VOC content of this product is 480 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
●●	●●	●●	●	●	●		●●	●●	●●	●●	●●	●●	●●	●●

## Remarks:

\*Suitable for commercial vehicle repair and aluminum add-on parts. Due to the large number of different aluminum alloys, the coating of large areas of vehicles (e. g. dropsides) or the close-to-production line coating of vehicles must be tested from a technological standpoint beforehand. 283-1870 Wash Primer can be used in advance without separate testing. The substrate should be clean, free of dust, rust, oils and grease. The pre-treated metallic surface must be coated on the same day to prevent renewed oxidation.



## Painting process

### Spreading rate

≈ 528 m<sup>2</sup> / l / 1µm

### Solid content (RFU)

≈ 80% (≈ 70%)

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09/2022



# TECHNICAL INFORMATION

284-90

Glasurit CV Primer Filler White ,PU

PF



**Mixing ratio**

3 : 1 + 10 - 30% by volume



**Hardeners**

**922-180 PRO**



**Reducer**

352-315, fast  
**352-320, medium**  
352-330, slow

15 - 20°C  
**20 - 25°C**  
25 - 30°C



**Viscosity**  
DIN 4 / 20° C

18 - 28 s. DIN 4

**Potlife 20 °C**

1,5 h

Application parameter		Compliant - gravity feed cup	HVLV - Spray gun	Suction cup	Airless/Airmix (ESTA)	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.2 - 2.5	2.0	2.5	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0.8 - 1.5
Nozzle size	mm	1.4 - 1.6	1.7	1.7	0.28 - 0.33	1.0 - 1.1
Voltage	kV	-	-	-	50 - 80	-
Elect. Resistance	Ω	-	-	-	1300 - 1600	-
Spray coats		2	2	2	2	2
Flash - off	min.	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
Filmbuild	µm	50 - 70				



**Drying**



**Over-coatable**



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

		min	max				
Object temp.	20°C	60 min.	72 h	6 h	16 h	16 h	16 h
Object temp.	60°C	30 min.		30 min.	30 min.	30 min.	45 min.

**Remarks**

!

2nd spraycoat maximum 10% tintable with 68- topcoat.  
284-90 may not be mixed with 568-17 (potlife!).  
Softface additive 522-111 before adding hardener, mixing ratio 4:1.  
For tinting see CV Primer Tinting Paste 568-408.  
On hot-dip galvanized steel, adhesion must be tested beforehand.  
Mixing ratio for smooth/flat surfaces (best flow) 3:1 +30%, 2 spraycoats, nozzle size 1.4 mm.



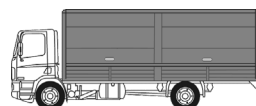
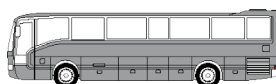
# TECHNICAL INFORMATION

801-705

Glasurit CV HS Primer Filler EP  
light grey

PF

## Range of application:



busses, fire-fighting vehicle, boxes, bulk loading vehicles, boxes (aluminum)

## Performance:

- suitable on all metal substrates
- very good levelling
- good filling properties
- all-purpose
- outstanding corrosion protection
- light grey (greyshade 05), tintable with 568-408
- overcoating with 68 Line, 90 CV PLUS or 55 Line\*

## 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/IB (c I)(540)455:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. **The VOC content of this product is 455 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
●●	●●	●●	●●	●	●●				●●	●●	●●	●●	●	●

## Remarks:

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

\* For overcoating with 90 CV PLUS or 55 Line flash off of 1h at 20°C (not less) is mandatory.

\*\* Because of the variety of metal alloys and manufacturing processes, it is recommended to carry out a preliminary adhesion test before application.



## Painting process

### Spreading rate

≈ 477 m<sup>2</sup> / l / 1µm

**Solid content (RFU)** ≈ 78% (≈ 66%)

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# TECHNICAL INFORMATION

801-705 Glasurit CV HS Primer Filler EP  
light grey

PF



**Mixing ratio** 4 : 1 : 1 by volume



**Hardener** 965-55



**Reducer** 352-315, fast 15 - 20°C  
352-320, medium 20 - 25°C  
352-330, slow 25 - 30°C



**Viscosity** 18 - 22 Sec. DIN 4 **Potlife 20 °C** 8 h  
DIN 4 / 20° C

Application parameter		Compliant - gravity feed cup	HVL P - 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 - 150	0.8 – 1.5
Nozzle size	mm	1.4 – 1.6	1.5	1.7	0.28 – 0.33	1.0 – 1.1
Voltage	kV				50 - 80	
Elect. Resistance	Ω				600 - 900	
Spray coats		2	2	2	1,5 - 2	1,5 - 2
Flash - off	min.	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
Filmbuild	µm	50 - 70				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

<b>Object temp.</b>	<b>20°C</b>	60 min.	72 h	3 h	16 h	16 h	See remarks
<b>Object temp.</b>	<b>60°C</b>	30 min.		30 min.	30 min.	30 min.	60 min.

**Remarks**

!

Minimum ambient temperature during application and drying: +15°C (for overcoating with 90 CV PLUS or 55 Line flash off at least at 20°C mandatory). The first coat has to be a light closed coat followed after flash off by a second full wet coat. For blasted substrates take care of the roughness depth. There is no need to sand 801-705 because of the very good levelling. If sanding is required: 1 h at 60°C object temperature or 16 h at 20°C (minimum 18°C room temperature). For tinting see CV Primer Tinting Paste 568-408.  
Before applying polyester products 801-705 has to be dried for at least 45 min. 60°C (object temperature). The adhesion on hot dipped galvanized steel has to be checked before.





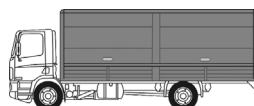
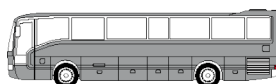
# TECHNICAL INFORMATION

801-715

Glasurit CV EP Primer Filler  
grey (L 04)

PF

## Range of application:



busses, fire-fighting vehicle, boxes, bulk loading vehicles, boxes (aluminum)

## Performance:

- suitable on many metal substrates
- very good levelling
- good filling properties
- multi-purpose
- outstanding corrosion protection
- grey (greyscale 04), tintable with 568-408
- overcoating with Line 68, 58, 90 CV PLUS or 55 Line\*

## 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/IB (c I)(540)493:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. **The VOC content of this product is 493 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
●●	●●	●●	●●	●●	●●				●●	●●	●●	●●	●	●

## Remarks:

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

\* For overcoating with 90 CV PLUS or 55 Line flash off of 1h at 20°C (not less) is mandatory.

\*\* Because of the variety of metal alloys and manufacturing processes, it is recommended to carry out a preliminary adhesion test before application.



## Painting process

### Spreading rate

≈ 430 m<sup>2</sup> / l / 1µm

**Solid content (RFU)** ≈ 77% (≈ 63%)

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# TECHNICAL INFORMATION

801-715 Glasurit CV EP Primer Filler  
grey (L 04)

PF



**Mixing ratio** 4 : 1 : 1 by volume



**Hardener** 965-715



**Additive** 568-720 normal 15 - 25°C  
568-745 slow 25 - 30°C



**Viscosity** DIN 4 / 20° C 19 - 22 Sec. DIN 4 **Potlife 20 °C** 8 h

Application parameter		Compliant - gravity feed cup	HVL P - 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 - 150	0,8 - 1,5
Nozzle size	mm	1,4 - 1,6	1,5	1,7	0,28 - 0,33	1,0 - 1,1
Voltage	kV				50 - 80	
Elect. Resistance	Ω				600 - 900	
Spray coats		2	2	2	1,5 - 2	1,5 - 2
Flash - off	min.	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
Filmbuild	µm	50 - 70				



**Drying**



**Over-coatable**



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

		min	max				
Object temp.	20°C	60 min.	72 h	3 h	16 h	16 h	See remarks
Object temp.	60°C	30 min.		30 min.	30 min.	30 min.	50 – 60 min.

## Remarks

!

Minimum ambient temperature during application and drying: +15°C.

For overcoating 801-715 with 90 CV PLUS or Line 55 flash off at least 1h at 20°C mandatory, maximum flash off time: within one working day (for over coating with 68 line 72h).

Do not adjust 801-715 with 352-reducers, only 568-720 or 568-745!

The first spray coat has to be a closed coat followed after flash off by a second full wet coat.

On blasted substrates take care of covering the surface roughness.

801-715 provides a good wet on wet finish, however, if sanding is required:

drying of 50-60 min at 60°C object temperature or 16h at 20°C is necessary.

For tinting see TDS of CV Primer Tinting Paste 568-408.

Before applying polyester products 801-715 has to be dried for at least 45 min. 60°C (object temperature). Adhesion on hot dipped galvanized steel has to be checked before.

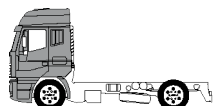


# TECHNICAL INFORMATION

## 285-0 CV Glasurit Transparent-Sealer CV clear

F

### Range of application:



sign writing, cabs (color change), multi - color painting, 68 Line, powder coated profiles/ boxes

### Performance:

- tintable
- brilliant top coat appearance
- fast drying

### 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 (c II)(540)502:** The EU limit value for this product (product category: IIIB.c II) in ready to use form is max. 540 g/l. **The VOC content of this product is 502 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
					○		●●	●●	●●	●●	○	●●	●●	●●

### Remarks:

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



### Painting process

#### Spreading rate

≈ 406 m<sup>2</sup> / l / 1µm

#### Solid content (RFU)

≈ 66 % (≈ 53%)

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# TECHNICAL INFORMATION

## 285-0 CV Glasurit Transparent-Sealer CV clear

F



**Mixing ratio**

2 : 1 + 30% by volume



**Hardeners**

**922-18 PRO** or 922-16 PRO



**Reducer**

352-310, extra fast

15 - 20°C

**352-315, fast**

**20 - 25°C**

352-320, medium

25 - 30°C



**Viscosity**  
DIN 4 / 20° C

17 s. DIN 4

**Potlife 20 °C**

3 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	2.0	2.5		
Paint pressure	bar	-	-	-		
Nozzle size	mm	1.4	1.5	1.7		
Voltage	kV	-	-	-		
Elect. Resistance	Ω	-	-	-		
Spray coats		1	1	1		
Flash - off	min.					
Filmbuild	µm	20 - 25				



**Drying**



**Over-coatable**



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

min max

**Object temp. 20°C**

15 min.

2 h

**Object temp. 60°C**

**Remarks**



Transparent Sealer 285-0 CV can be tinted with (up to 10% of) 68 Line Topcoat.



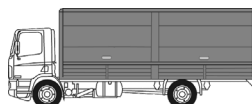
# TECHNICAL INFORMATION

284-30

Glasurit CV RATIO-TRUCK  
Sanding Filler, light grey

F

## Range of application:



busses, cabs (refurbishing), boxes, busses (repair)

## Performance:

- suitable on all Glasurit CV primer and primer filler
- good filling properties
- outstanding application characteristics
- excellent sandable
- tintable
- suitable for large areas / surfaces

## 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 (c I)(540)517:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. **The VOC content of this product is 517 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
●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●

## Remarks:

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



## Painting process

### Spreading rate

≈ 426 m<sup>2</sup> / l / 1µm

### Solid content (RFU)

≈ 75% (≈ 64%)

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09/2022



# TECHNICAL INFORMATION

284-30

Glasurit CV RATIO-TRUCK  
Sanding Filler, light grey

F



Mixing ratio

4 : 1 : 1 by volume



Hardeners

922-18 PRO or 922-16 PRO



Reducer

352-320, medium  
**352-320, medium**  
352-330, slow

15 - 20°C  
**20 - 25°C**  
25 - 30°C



Viscosity  
DIN 4 / 20° C

18 - 22 s. DIN 4

Potlife 20 °C

2 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	2.0	2.5	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0.8 – 1.5
Nozzle size	mm	1.6 – 1.8	1.7	1.7	0.28 – 0.33	1.0 – 1.1
Voltage	kV	-	-	-	50 - 80	-
Elect. Resistance	Ω	-	-	-	1700 - 2000	-
Spray coats		2	2	2	2	2
Flash - off	min.	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
Filmbuild	µm	70 - 90				



Drying



Over-coatable

min max



Tack-free



Ready for masking



Ready to assemble



Sandable

Object temp.	20°C	72* h	2 h	16 h	16 h	16 h
Object temp.	60°C		45 min.	45 min.	45 min.	45 min.

Remarks

!

Dry sanding after 16 h at 20°C or 45 min. at 60°C. Can be tinted by adding up to 10% of 68 Line Topcoat. To plasticize the product, mix it 4 : 1 by volume with 522-111 Softface Additive before adding hardener.

For tinting see CV Primer Tinting Paste 568-408.

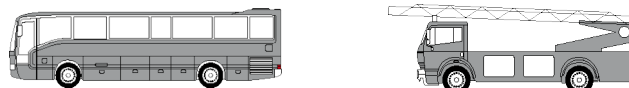
\*Sanded areas have to be overcoated within 72h with 68 Line, within one working day with 55 line, otherwise the adhesion promoter 285-0 CV has to be used.

# TECHNICAL INFORMATION

## 284-45 Glasurit CV Filler, PUR

F

### Range of application:



busses, plastic painting, cabs (color change), boxes, daylight fluorescent paint

### Performance:

- suitable on all Glasurit CV primer and primer filler
- 284-45 in white (greyscale 08)
- good adhesion to various plastics
- brilliant top coat appearance
- good leveling
- filler for daylight fluorescent paint and for 2 step colors
- tintable
- overcoatable with Glasurit topcoat Line 58, 68, 55

### 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 (c I)(540)456:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. **The VOC content of this product is 456 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
					●●	●	●●	●●	●●	●●	●●	●●	●●	●●

### Remarks:

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



### Painting process

#### Spreading rate

≈ 494 m<sup>2</sup> / l / 1µm

#### Solid content (RFU)

≈ 78% (≈ 66%)



# TECHNICAL INFORMATION

## 284-45 Glasurit CV Filler, PUR

**F**



**Mixing ratio**

2 : 1 + 10 - 30% by volume



**Hardeners**

**922-180 PRO**



**Reducer**

352-320, medium

15 - 20°C

**352-330, slow**

**20 - 25°C**

352-340 extra slow

25 - 30°C



**Viscosity  
DIN 4 / 20° C**

17 - 21 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	2.0	2.5	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0.8 - 1.5
Nozzle size	mm	1.4 - 1.6	1.5	1.7	0.28 - 0.33	1.0 - 1.1
Voltage	kV	-	-	-	50 - 80	-
Elect. Resistance	Ω	-	-	-	600 - 800	-
Spray coats		1 ½	1 ½	1 ½	1 ½	1 ½
Flash - off	min.	without	without	without	without	without
Filmbuild	µm	50 - 70*				



**Drying**



**Over-coatable**



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

min max

Object temp.	20°C	60 min	72 h	2 h	16 h	16 h	16 h
Object temp.	60°C	30 min.		30 min.	30 min.	30 min.	45 min.

**Remarks**

**!**

Can be tinted by adding up to 10% of 68 Line Topcoat. To plasticize the product, mix it 4 : 1 by volume with 522-111 Softface Additive before adding hardener.

For tinting see CV Primer Tinting Paste 568-408.

For sanding the filmthickness should be 80 µm (50 - 60 µm after sanding) and the drying time has to be 45min 60°C or drying over night. Sandthroughs have to covered by using a suitable primer. Mixing ratio 2 : 1 + 30% if the product is used as an adhesion promoter on plastic or old paint work (20 - 30 µm)

\*If required 284-45 can be used as high bild filler up to 150 µm (3 - 4 coats).





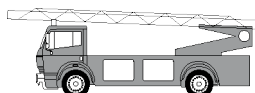
# TECHNICAL INFORMATION

284-99

Glasurit CV Texture Filler  
ACR, transparent

F

## Range of application:



firefighting truck, trams

## Performance:

- suitable on all Glasurit CV primer filler (PUR & EP)
- overcoatable with Topcoat 68 Line
- from fine to coarse textured effect application
- good sagging resistance
- quick drying properties
- to be tinted with 10% topcoat 68 Line
- semi glossy

## 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/IIB (c I)(540)346:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. **The VOC content of this product is 346 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:

284-99 to be used as textured effect given filler (i. e. on EP 801- or PUR 284-), afterwards overcoating with Topcoat 68 Line in requested color, for perfect color appearance it is necessary to tint 284-99 with 10% topcoat 68 Line, same color as requested on top of 284-99. 284-99 can be overcoated with 68 Line after 30 Min. at 60°C or 60 min. at 20°C. The substrate should be clean, free of dust, rust, oil and grease.



## Painting process

### Spreading rate

≈ 615 m<sup>2</sup> / l / 1µm

**Solid content (RFU)** ≈ 73 % (≈ 75%)

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09/2022



# TECHNICAL INFORMATION

F

284-99

Glasurit CV Texture Filler  
ACR, transparent



Mixing ratio

8 : 1 by volume



Hardeners

922-139 / -138



Reducer

352-320 / -315 (as necessary)



Viscosity  
DIN 4 / 20° C

high-viscous

Potlife 20 °C

1 h

Application parameter		Compliant - gravity feed cup	HVLP - Spray gun	Suction cup	Pressure-Pot	Pressure-Tank
Atomization pressure	bar	-	-	-	0.5 – 1.5	0.5 – 1.5
Paint pressure	bar	-	-	-	1 – 1.5	1 – 1.1.5
Nozzle size	mm	-	-	-	1.7 – 2.5	1.2 – 1.7
Voltage	kV	-	-	-	-	-
Elect. Resistance	Ω	-	-	-	-	-
Spray coats		-	-	-	1 – 2	1 – 2
Flash - off	min.	-	-	-	10 - 15	10 - 15
Filmbuild	µm	depends on textured effect				



Drying



Over-coatable



Tack-free



Ready for masking



Ready to assemble



Sandable

min max

Object temp.	20°C	60 min.	72 h	-	-	24-36 h	-
Object temp.	60°C	30 min.		-	-	60-90 min.	-

Remarks

!

The textured effect can be influenced by distance to substrate, spray equipment, nozzle size, atomization and material pressure. For colors with less hiding power: recommended to add reducer to 284-99 and pre-spray one or two coats flat, without textured effect (RP 1,4mm), afterwards use 284-99 (8:1 vol.) as textured filler + topcoat 68 Line.

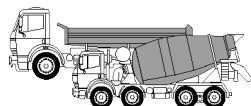


# TECHNICAL INFORMATION

## AD 58- Glasurit 2C HS CV Chassis Topcoat Satin gloss

T

### Range of application:



all applications where a reduced gloss is required, chassis (color change), chassis painting, container

### Performance:

- suitable on all Glasurit CV primer filler and filler
- good leveling
- high efficiency
- good hiding power
- Excellent surface hardness
- excellent UV resistance
- Colors MB 7350 nova gray, MB 9124 chassis black, MAN 9011 black

### 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 (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.**

### 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
								●●						

### Remarks:

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



### Painting process

**Spreading rate** ≈ 536 m<sup>2</sup> / l / 1µm

**Solid content** ≈ 67 %

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# TECHNICAL INFORMATION

## AD 58- Glasurit 2C HS CV Chassis Topcoat Satin gloss

T



**Mixing ratio**

4 : 1 : 1 by volume



**Hardeners**

**922-139**, 922-138 or 922-136



**Reducer**

352-315, fast 15 - 20°C  
**352-320, medium** 20 - 25°C  
 352-330, 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		1 ½	1 ½	1 ½	1 ½	1 ½
Flash - off	min.	without	without	without	without	without
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**



Gloss level is depending on the specific color master.  
 Recoatable with itself without intermediate sanding for up to 16 hours after application of first coat  
 Due to the reduced gloss level not suitable for blend in processes



# TECHNICAL INFORMATION

AD 68- Glasurit HS 2K CV Topcoat, glossy

T

## Range of application:



## Performance:

- suitable on all Glasurit CV primer filler and filler
- suitable for large areas / surfaces
- very good appearance and flow
- excellent UV resistance
- fast drying
- excellent surface hardness
- good hiding power

## Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm

The e products are suitable for professional use only.

**2004/42/IIB (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.**

## 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
								●●					○	○

## Remarks:

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

The complete color range for CV-application is covered

Best appearance in combination with hardener 922-139 slow Premium.



## Painting process

Can be used for all CV Painting Processes.

## Spreading rate

≈ 536 m<sup>2</sup> / l / 1µm

## Solid content

≈ 69 %

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# TECHNICAL INFORMATION

AD 68- Glasurit HS 2K CV Topcoat, glossy

T



**Mixing ratio**

4 : 1 : 1 by volume



**Hardeners**

922-139, 922-138 or 922-136



**Reducer**

352-315, fast 15 - 20°C  
**352-320, medium** 20 - 25°C  
 352-330, slow 25 - 30°C



**Viscosity**  
 DIN 4 / 20° C

18 - 22 s. DIN 4

**Potlife 20 °C**

1,5

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		1 ½	1 ½	1 ½	1 ½	1 ½
Flash - off	min.	without	without	without	without	without
Filmbuild	µm	40 - 60				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

<b>Object temp.</b>	<b>20°C</b>	16 h	2.5 h	16 h	12 h	16 h
<b>Object temp.</b>	<b>60°C</b>	30 min.	30 min.	30 min.	30 min.	30 min.

**Remarks**

!

Application: Pre-spray 1 thin grip coat with the finishing coat following immediately  
 Process times: ~ 45 min. with 922-136 / ~ 1h with 922-138 and ~ 2h with 922-139. Drying 30 min.  
 at 60°C with 922-138, 45 - 60 min. at 60°C with 922-139  
 Recoatable with itself without intermediate sanding for up to 16 hours after application.  
 Pre-spray adhesion promoter 285-0 CV prior to multi-colour finishing if painted surface was baked  
 or flashed-off for 16 h. Airless or Airmix - Use 568-M 100 instead of 568-M 135.



# TECHNICAL INFORMATION

AE 68 / RAL 9006 Glasurit HS 2K CV Topcoat,  
Silver direct gloss, RAL 9006

T

## Range of application:



all applications, dumptruck (aluminum), boxes, bulk loading vehicles

## Performance:

- suitable on all Glasurit CV primer filler and filler
- suitable for large areas / surfaces
- good leveling
- excellent UV resistance
- Excellent surface hardness

## 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/IB (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.**

## 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
								●●					○	○

## Remarks:

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



## Painting process

Spreading rate ≈ 536 m<sup>2</sup> / l / 1µm

Solid content ≈ 62 %

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# TECHNICAL INFORMATION

AE 68 / RAL 9006 Glasurit HS 2K CV Topcoat,  
white Aluminium

T

Silver direct gloss, RAL 9006



**Mixing ratio**

4 : 1 : 1 by volume



**Hardeners**

**922-136**, 922-138 or 922-139



**Reducer**

352-310, extra fast  
**352-310, extra fast**  
352-320, medium

15 - 20°C  
**20 - 25°C**  
25 - 30°C



**Viscosity**  
DIN 4 / 20° C

28 - 32 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		1 ½	1 ½	1 ½	1 ½	1 ½
Flash - off	min.	without	without	without	without	without
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: Pre-spray 1 thin grip coat with the finishing coat following immediately. Alternatively, apply several thin spray coats.  
Recoat with itself without intermediate sanding for up to 16 hours after application.  
After baking + 16 hours of air drying and prior to multi-colour finishing, the use of the adhesion promoter 285-0 CV is mandatory.

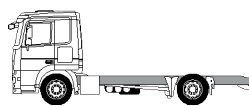
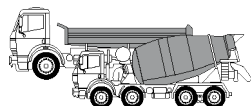


# TECHNICAL INFORMATION

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

T

### 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: IIIB.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
								●●						

### Remarks:

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

The complete color range for CV-application is covered.



### Painting process

**Spreading rate** ≈ 536 m<sup>2</sup> / l / 1µm

**Solid content** ≈ 67 %

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# TECHNICAL INFORMATION

## AD 68 / 568 M 124 Glasurit HS 2K CV Topcoat

T

### 568-M 124 CV Matting Mixing Clear



#### 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

352-315, fast 15 - 20°C  
352-320, medium 20 - 25°C  
352-330, 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

min max



#### Tack-free



#### Ready for masking



#### Ready to assemble



#### Sandable

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.

Recoat with itself without intermediate sanding for up to 16 hours after application.

Pre-spray adhesion promoter 285-0 CV prior to multi-colour finishing if painted surface was baked and flashed-off for 16 h.

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

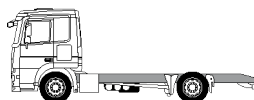


# TECHNICAL INFORMATION

## 568-46 (DTM) Glasurit CV Steel Primer Paste 1-layer system

T

### Range of application:



chassis painting, chassis (color change), container

### Performance:

- tintable
- suitable for large areas / surfaces
- good leveling
- can be applied directly on steel or galvanized steel
- high efficiency
- good corrosion protection

### 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 (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.**

### 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
●●	●●	●			●		●		●	●			●	●

### Remarks:

Aluminum-Chassis have to be primed with a suitable primer

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



### Painting process

**Spreading rate** ≈ 503 m<sup>2</sup> / l / 1µm

**Solid content** ≈ 80 %

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09/2022



# TECHNICAL INFORMATION

## 568-46 (DTM) Glasurit CV Steel Primer Paste 1 layer-system

T



**Pre mix**  
**AD 68 with 568-46**

mix 568-46 with line 68 in the ratio 1 : 1



**Mixing ratio**

7 : 1 + 10 - 15% by volume



**Hardeners**

**922-138**, 922-136 or 922-139



**Reducer**

352-315, fast 15 - 20°C  
**352-320, medium** 20 - 25°C  
352-330, slow 25 - 30°C



**Viscosity**  
**DIN 4 / 20° C**

30 - 40 s. DIN 4

**Potlife 20 °C**

2 h

**Application parameter**



**Compliant -  
gravity feed  
cup**



**HVLP - Spray  
gun**



**Suction cup**



**Airless/  
Airmix**



**Pressure pot  
Dble.-Memb.  
Pump**

		Compliant - gravity feed cup	HVLP - Spray gun	Suction cup	Airless/ Airmix	Pressure pot Dble.-Memb. Pump
<b>Atomization pressure</b>	<b>bar</b>	2.2 – 2.5	2	2	2	2.5
<b>Paint pressure</b>	<b>bar</b>	-	-	-	120 - 150	0,8 - 1,5
<b>Nozzle size</b>	<b>mm</b>	1.6 – 1.8	1.7 – 1.9	1.7 – 1.9	0.28 – 0.33	1.0 – 1.3
<b>Voltage</b>	<b>kV</b>	-	-	-	50 - 80	-
<b>Elect. Resistance</b>	<b>Ω</b>	-	-	-	700 - 1500	-
<b>Spray coats</b>		2	2	2	1 - 2	2
<b>Flash - off</b>	<b>min.</b>	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
<b>Filmbuild</b>	<b>µm</b>	70 - 100				



**Drying**



**Over-  
coatable**



**Tack-free**



**Ready for  
masking**



**Ready to  
assemble**



**Sandable**

min max

<b>Object temp.</b>	<b>20°C</b>	16 h	2 h	16 h	16 h	16 h
<b>Object temp.</b>	<b>60°C</b>	30 min.	30 min.	30 min.	30 min.	30 min.

**Remarks**

!

The shelf life of the mixed product (Line 68 top coat and 568 - 46) is only 2 weeks.  
The DTM version is not suitable for areas that are directly exposed to sunlight.  
The corrosion protection can only be achieved, if the required film thickness is applied (covering of sand blasting roughness, edges). Mixing of 568-46 can change the color.  
The adhesion on hot dipped galvanized steel has to be checked before.

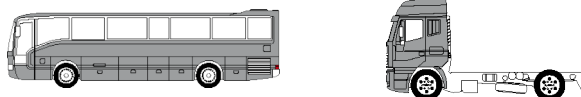


# TECHNICAL INFORMATION

## 90 CV PLUS Glasurit Basecoat Metallics/Solids 90 CV PLUS

T

### Range of application:



busses, cabs (color change), boxes, bulk loading vehicles, busses (repair)

### Performance:

- good leveling
- suitable for large areas / surfaces
- excellent UV resistance
- good hiding power
- outstanding application characteristics

### 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/IIB (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.**

### 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
-------	------------------	-----------------	-----------	--------------------	-----------	---------	----------------------	--------------------------------------	----------------	--------------	---------	------	----------------	----------------

### Remarks:

The complete color range for CV-application is covered

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

90 CV PLUS = Mixing Clear 90-M 4 CV PLUS + Reducer 93- E 3 CV PLUS



### Painting process

#### Spreading rate

≈ 130 m<sup>2</sup> / l / 1µm

#### Solid content

≈ 15 %

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# TECHNICAL INFORMATION

## 90 CV PLUS Glasurit Basecoat Metallics/Solids 90 CV PLUS

T



**Mixing ratio**

2 : 1 by volume



**Hardeners**



**Reducer**

93-E3 CV PLUS








**Viscosity**  
DIN 4 / 20° C

20 - 30 s. DIN 4

**Potlife 20 °C**

8 h

Application parameter		 Compliant - gravity feed cup	 HVLP - Spray gun	 Suction cup	 Airless/ Airmix	 Pressure pot Dble.-Memb. Pump
Atomization pressure	bar		2.0			2.5
Paint pressure	bar	-	-			0.8 – 1.5
Nozzle size	mm		1.5			1.0 – 1.1
Voltage	kV					
Elect. Resistance	Ω					
Spray coats			2 + ½			2 + ½
Flash - off	min.		until matt			until matt
Filmbuild	µm	10 - 15				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

**Object temp. 20°C**

30 min 8 h

**Object temp. 60°C**

15 min.

**Remarks**

!

Use 700-1 to clean substrates after sanding.

Prespray one light spray coat, leave to flash-off until mat. Then finish with one wet coat, leave to flash-off until mat. Apply ½ spray coat (minimum distance to the panel: 50 cm) to match the effect. If required to reduce the viscosity afterwards use 93-E3 CV PLUS.





# TECHNICAL INFORMATION

## AE / AD 55 Glasurit Basecoat Metallics / Solids 55 Line for CV

T

### Range of application:



sign writing, busses, cabs (refurbishing), cabs (color change), boxes, busses (repair)

### Performance:

- suitable for large areas / surfaces
- good leveling
- excellent UV resistance
- good hiding power
- fast drying

### 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 (d)(420)790:** 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 790 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
								●●						

### Remarks:

The complete color range for CV-application is covered

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



### Painting process

#### Spreading rate

≈ 115 m<sup>2</sup> / l / 1µm

#### Solid content

≈ 25 %

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# TECHNICAL INFORMATION

## AE / AD 55 Glasurit Basecoat Metallics / Solids 55 Line for CV

T



**Mixing ratio**

2 : 1 by volume\*



**Hardeners**



**Reducer\*\***

352-315, fastl  
**352-315, fast**  
352-320, medium

15 - 20°C  
**20 - 25°C**  
25 - 30°C



**Viscosity  
DIN 4 / 20° C**

18 - 22 s. DIN 4

Application parameter		Compliant - gravity feed cup	HVLV - Spray gun	Suction cup	Airless/ Airmix	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.2 – 2.5	2	2.5		2.5
Paint pressure	bar	-	-	-		0.8 – 1.5
Nozzle size	mm	1.4	1.5	1.7		1.0 – 1.1
Voltage	kV	-	-	-		50 - 80
Elect. Resistance	Ω	-	-	-		600 - 1500
Spray coats		2 + ½	2 + ½	2 + ½		2 + ½
Flash - off	min.	until matt	until matt	until matt		until matt
Filmbuild	µm	10 - 15				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

**Object temp. 20°C**

10 min.

8 h

10 min.

30 min.

**Object temp. 60°C**

**Remarks**

!

Prespray one light spraycoat, leave to flash-off until mat. Then finish with one wet coat, leave to flash-off until mat. Apply ½ spraycoat (minimum distance to the panel: 50 cm) to match the effect.

\*To achieve best technical performance of the paint system it is recommended to add 2% hardener 922-138 (or -136) to 55 line basecoat.

\*\* for large areas and higher temperatures the use of reducer 352-330 slow or 352-340 extra slow is recommended for better overspray absorption.



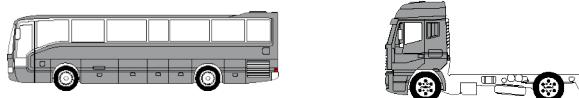
# TECHNICAL INFORMATION

924-68

Glasurit HS 2K CV Clearcoat

C

## Range of application:



busses, sign writing, metallic coating (Line 90), boxes, bus repair

## Performance:

- suitable for large areas/ surfaces
- good leveling
- excellent UV resistance
- outstanding application characteristics
- excellent gloss level

## 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 (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.**

## Remarks:

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



## Painting process

### Spreading rate

≈ 505 m<sup>2</sup> / l / 1µm

### Solid content (RFU)

≈ 61 % (≈ 56%)

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# TECHNICAL INFORMATION

924-68 Glasurit HS 2K CV Clearcoat

C



**Mixing ratio** 3 : 1 : 1 by volume



**Hardeners** 922-138 or 922-136



**Reducer** 352-320, medium 15 - 20°C  
352-330, slow 20 - 25°C  
352-340, extra slow 25 - 30°C



**Viscosity** DIN 4 / 20° C 18 - 22 s. DIN 4 **Potlife 20 °C** 2 h

Application parameter		Compliant - gravity feed cup	HVL P - Spray gun	Suction cup	Airless/ Airmix	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.2 – 2.5	2	2.5		2.5
Paint pressure	bar	-	-	-		0.8 – 1.5
Nozzle size	mm	1.3 - 1.4	1.5	1.7		1.0 - 1.1
Voltage	kV	-	-	-		50 - 80
Elect. Resistance	Ω	-	-	-		600 - 1500
Spray coats		1 ½	1 ½	1 ½		1 ½
Flash - off	min.	without	without	without		without
Filmbuild	µm	40 - 60				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

<b>Object temp.</b>	<b>20°C</b>	16 h	2 h	16 h	12 h	16 h
<b>Object temp.</b>	<b>60°C</b>	30 min.	30 min.	30 min.	30 min.	30 min.

**Remarks**



Pre-spray 1 light coat, then apply 1 wet coat for flow.  
Recoat with itself for up to 16 hours after application of first coat. After force drying and 16 hours air drying the adhesion promoter 285-0 CV has to be sprayed first.



# TECHNICAL INFORMATION

924-168

Glasurit HS 2K CV Bus Clear

C

## Range of application:



metallic coating, bus repair, busses

## Performance:

- suitable for large areas / surfaces
- good leveling
- excellent UV resistance
- excellent gloss level

## 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 (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.**

## Remarks:

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



## Painting process

### Spreading rate

≈ 510 m<sup>2</sup> / l / 1µm

### Solid content (RFU)

≈ 61 % (≈ 56%)

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# TECHNICAL INFORMATION

924-168 Glasurit HS 2K CV Bus Clear

C



**Mixing ratio**

3 : 1 : 1 by volume



**Hardeners**

922-139, 922-138 or 922-136



**Reducer**

352-330, slow



**Viscosity**  
DIN 4 / 20° C

18 - 20 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		2.5
Paint pressure	bar	-	-	-		0.8 – 1.5
Nozzle size	mm	1.2 – 1.4	1.3 – 1.5	1.7		1.0 - 1,1
Voltage	kV	-	-	-		50 - 80
Elect. Resistance	Ω	-	-	-		600 - 1500
Spray coats		2	2	2		2
Flash - off	min.	10 - 15	10 - 15	10 - 15		10 - 15
Filmbuild	µm	40 - 60				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

<b>Object temp.</b>	<b>20°C</b>	16 h	2 h	16 h	12 h	16 h
<b>Object temp.</b>	<b>60°C</b>	30 min.	30 min.	30 min.	30 min.	30 min.

**Remarks**

!

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



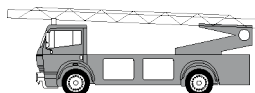
# TECHNICAL INFORMATION

923-

Glasurit Daylight Fluorescent paint  
RAL 1026/00T, RAL 2005/00T, RAL 3024/00T

T

## Range of application:



fire-fighting vehicle

## Performance:

- suitable for large areas / surfaces
- brilliant top coat appearance
- good leveling

## 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)839:** 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 839 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
								●●						

## Remarks:

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

Daylight fluorescent paints are special fluorescent paints for fire brigades (cf. DIN 14502, Part 3), police and municipal vehicles, etc.

The colors are miscible. In this case, a special authorization is needed according to para. 1 of s. 49a of the German Road Traffic Act.



## Painting process

### Spreading rate

≈ 430 m<sup>2</sup> / l / 1µm

### Solid content

≈ 62 %

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# TECHNICAL INFORMATION

923-

Glasurit Daylight Fluorescent paint  
RAL 1026/00T, RAL 2005/00T, RAL 3024/00T

T



**Mixing ratio**

4 : 1 + 10% by volume



**Hardeners**

**929-93** or 929-91 / 94



**Reducer**

352-315, fast 15 - 20°C  
**352-320, medium** 20 - 25°C  
352-330, slow 25 - 30°C



**Viscosity**  
DIN 4 / 20° C

30 s. DIN 4

**Potlife 20 °C**

4 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		
Paint pressure	bar	--	-	-		
Nozzle size	mm	1.3 – 1.6	1.3 – 1.5	1.7		
Voltage	kV	-	-	-		
Elect. Resistance	Ω	-	-	-		
Spray coats		4 - 5	4 - 5	4 - 5		
Flash - off	min.	10 - 15	10 - 15	10 - 15		
Filmbuild	µm	100				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

**Object temp.**

**20°C**

10 h

72 h

**Object temp.**

**60°C**

60 min.

**Remarks**

!

May only be used on homogeneous white undercoat, i. e. 284-45.

After oven drying and before application of 923-49 object has to cool down to ambient room temperature.

Apply Glasurit 923-49 Protective Clear over the Daylight Fluorescent Paint to slow down the bleach out/ dull process of the Daylight Fluorescent Paint. Because of the chemical composition of these specific pigments, the degradation through direct sunlight is accelerated massively.



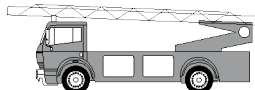
# TECHNICAL INFORMATION

923-49

Glasurit Protective clear  
for daylight colors

C

**Range of application:**



fire-fighting vehicle

**Performance:**

- suitable for large areas/ surfaces
- brilliant top coat appearance
- good leveling
- excellent UV resistance
- excellent gloss level

**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)612:** 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 612 g/l.**

**Remarks:**

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



**Painting process**

**Spreading rate**

≈ 321 m<sup>2</sup> / l / 1µm

**Solid content (RFU)** ≈ 39 % (≈ 37%)



# TECHNICAL INFORMATION

## 923-49 Glasurit Protective clear for daylight colors

C



**Mixing ratio** 2 : 1 + 10% by volume



**Hardeners** 929-93 or 929-94



**Reducer** 352-315, fastl 15 - 20°C  
352-320, medium 20 - 25°C  
352-330, slow 25 - 30°C



**Viscosity** 16 - 18 s. DIN 4 **Potlife 20 °C** 8 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		
Paint pressure	bar	-	-	-		
Nozzle size	mm	1.3 – 1.4	1.3 – 1.5	1.7		
Voltage	kV	-	-	-		
Elect. Resistance	Ω	-	-	-		
Spray coats		2	2	2		
Flash - off	min.	10 - 15	10 - 15	10 - 15		
Filmbuild	µm	50 - 70				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

**Object temp.** 20°C 10 h

**Object temp.** 60°C 60 min.

### Remarks



Resistant to UV radiation; removal of dust nibs or runs only after very good curing. Select hardener and reducer according to ambient temperature and size of object to be painted. IR drying – 8 min. shortwave, 10 – 15 min. medium wave.

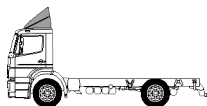


# TECHNICAL INFORMATION

522-111 Glasurit Softface Additive

Z

## Range of application:



Plasticizing agent for painting plastics

## Performance:

- good leveling
- high flexible
- easy to mix

## Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm  
The products are suitable for professional use only.

## Remarks:

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



## Painting process

Spreading rate

Solid content ≈ 70 %



## Pre mix

AD68, 284-... with 522-111

4 : 1 (4 parts base material e. g. 68 Line or 284-... and 1 part 522-111), use mixing stick. For other mixtures see corresponding TDS.

## Remarks



Useable in CV products 284-13, -30, -45, -90 and Glasurit CV Line 68.  
Products require longer drying times when containing Softface Additive.



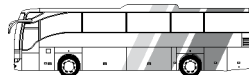
# TECHNICAL INFORMATION

568-17

Glasurit CV Multi-Colour Additive  
clear

Z

**Range of application:**



cabs (refurbishing), boxes, busses (repair), sign writing

**Performance:**

- good leveling
- fast to assemble
- Quick-drying for multicolor painting with 68 Line

**Special remarks:**

It cannot be ruled out that this product contains particles < 0.1 µm  
The products are suitable for professional use only.

**Remarks:**

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



**Painting process**

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BASF Coatings GmbH, Automotive Refinish Coatings Solutions Europe, Glasuritstrasse 1, 48165 Münster, Deutschland

09/2022



# TECHNICAL INFORMATION

## 568-17 Glasurit CV Multi-Colour Additive clear

**Z**



**Mixing ratio** 4 : 1 : 1 by volume



**Hardeners** 922-138 or 922-136



**Reducer** 568-17



**Viscosity**  
DIN 4 / 20° C

18 - 21 s. DIN 4

**Potlife 20 °C**

30 min.

Application parameter		Compliant - gravity feed cup	HVL P - Spray gun	Suction cup	Airless/ Airmix	Pressure pot Dble.-Memb. Pump
Atomization pressure	bar	2.2 – 2.5	2	2.5	-	2.5
Paint pressure	bar	-	-	-	-	0.8 - 1,5
Nozzle size	mm	1.4	1.5	1.7	-	1.0 - 1.1
Voltage	kV	-	-	-	-	-
Elect. Resistance	Ω	-	-	-	-	-
Spray coats		1 ½	1 ½	1 ½	-	1 ½
Flash - off	min.	without	without	without		without
Filmbuild	µm	40 - 60				



**Drying**



**Over-coatable**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

**Object temp.** 20°C  
**Object temp.** 60°C

120 min.

120 min.

120 min.

120 min.

### Remarks



Use paper with a sized face for masking. Application: See Painting Process.

Use adhesion promoter 285-0CV after 8 h at 20°C or oven drying.

568-17 can also be used in 924-68 and also with 284-13, -30 and -45. However the maximum amount of 568-17 should only be 50% of the used reducer (premix of 568-17 and 352-... 1:1). Do not use in 284-90!

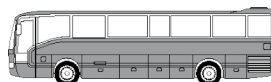
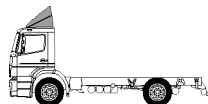
# TECHNICAL INFORMATION

568-20

Glasurit HAFLEX Additive  
(Adhesion promotor plastic)

Z

## Range of application:



plastic painting

## Performance:

- good adhesion to various plastics
- high efficiency
- use for example in 284-45

## Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm  
The products are suitable for professional use only.

## 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
						●●							●	●

## Remarks:

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



## Painting process

Spreading rate

Solid content ≈ 7 %





# TECHNICAL INFORMATION

## 568-20 Glasurit HAFLEX Additive (Adhesion promotor plastic)

**Z**



**Mixing ratio** 2 : 1 + 10% by volume (284-45)



**Hardeners** 922-180 PRO



**Reducer** 568-20



**Viscosity** 20 – 22 s DIN 4  
**DIN 4 / 20° C**

**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	2.0	2.5	2	2.5
Paint pressure	bar	-	-	-	120 - 150	0.8 - 1.5
Nozzle size	mm	1.4 - 1.6	1.5 - 1.7	1.7	0.28 - 0.33	1.0 - 1.1
Voltage	kV	-	-	-	60 - 70	-
Elect. Resistance	Ω	-	-	-	600 - 800	-
Spray coats		1 - 2	1 - 2	1 - 2	1	1 - 2
Flash - off	min.	without	without	without	without	without
Filmbuild	µm	20 - 30 *				



**Drying**



**Over-coatable**



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

min max

**Object temp.** 20°C 60 min. 72 h

**Object temp.** 60°C 30 min.

### Remarks

!

ABS, GRP, SMC, PC: 284-45 with 922-180 PRO and 352-320 / -330 (2 : 1 + 10%);

PA, PP-EPDM, 284-45 with 922-180 PRO and 568-20 (2 : 1 + 30%);

PP, PE: (adhesion can not be guaranteed) 284-45 with 922-180 PRO and 568-20 (2 : 1 + 30%);

\*Higher dry film thickness possible (50 - 60 µm)

Attention: Due to different raw material supplier the quality of the different plastics can be differ from time to time. The adhesion should be check before painting individually.



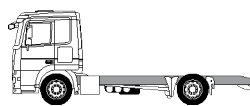
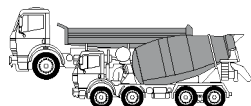
# TECHNICAL INFORMATION

568-96

Glasurit Express Reducer for 9-7  
clear

Z

## Range of application:



construction machinery (steel), chassis painting (steel / aluminum)

## Performance:

- suitable for large areas / surfaces
- fast drying

## Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm  
The products are suitable for professional use only.

## Remarks:

Aluminum-Chassis have be primed with a suitable primer  
Find addition information in the technical data sheet of 9-7



## Painting process

Spreading rate

Solid content ≈ 10 %



## Mixing ratio

4 : 1 by volume



## Hardeners



## Reducer

568-96  
**568-96**  
568-96

15 - 20°C  
**20 - 25°C**  
25 - 30°C



## Viscosity DIN 4 / 20° C

18 - 20 s. DIN 4

## Remarks



To be used in 9-7 only.

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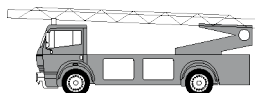
# TECHNICAL INFORMATION

568-405

Glasurit CV Texture Additive

Z

## Range of application:



all applications, structure effect

## Performance:

- suitable on all Glasurit CV primer filler and filler
- suitable for large areas / surfaces
- different structure effects can be achieved

## Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm  
The products are suitable for professional use only.

## 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
								●●						

## Remarks:

The substrate should be clean, free of dust, rust, oil and grease.  
Find addition information in the technical data sheet of the top coat.



## Painting process

### Spreading rate

≈ 536 m<sup>2</sup> / l / 1µm

### Solid content

≈ 41 %



# TECHNICAL INFORMATION

## 568-405 Glasurit CV Texture Additive

# Z



### Pre mix

Mixing according to mixing formula or mix Line 68 : 568-405 in ratio 1:1



### Mixing ratio

4 : 1 : 1 by volume



### Hardeners

**922-138**, 922-136 or 922-139



### Reducer

352-315, fast 15 - 20°C  
**352-320, medium** 20 - 25°C  
 352-330, 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.-Mem. Pump
Atomization pressure	bar	2.2 - 2,5	2	2.5	-	2.5
Paint pressure	bar	-	-	-	-	0.8 - 1.5
Nozzle size	mm	1.4	1.5	1.7	-	1.0 - 1.1
Voltage	kV	-	-	-	-	-
Elect. Resistance	Ω	-	-	-	-	-
Spray coats		1 ½	1 ½	1 ½	-	1 ½
Flash - off	min.	without	without	without		without
Filmbuild	µm	40 - 60				



### Drying



### Over-coatable

min max



### Tack-free



### Ready for masking



### Ready to assemble



### Sandable

**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



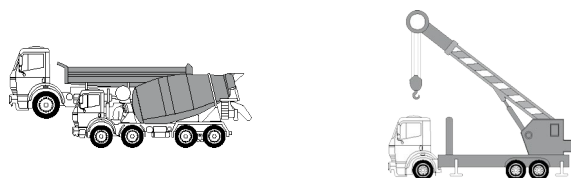
Mixing ratio for Line 68 and 568-405: max. 1 : 1.  
 Addition of 568-405: See also Line 68 mixing formulas.

# TECHNICAL INFORMATION

## 568-407 Glasurit CV Brush and Roll Additive

**Z**

### Range of application:



all applications

### Performance:

- allows application of the top coat with brush or roller
- suitable on all Glasurit CV primer filler and filler
- good leveling

### Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm  
The products are suitable for professional use only.

### Remarks:

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



### Painting process

#### Spreading rate

**Solid content** ≈ 5 %



#### Mixing ratio

4 : 1 : 5 - 15% by volume



#### Hardeners

922-138, 922-136 or 922-139



#### Reducer

568-407



#### Viscosity DIN 4 / 20° C

**Potlife 20 °C**

60 min.



#### Drying



#### Over-coatable

min max



#### Tack-free



#### Ready for masking



#### Ready to assemble



#### Sandable

**Object temp.**

20°C

3 h

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



2-3 applications with brush or roll. Intermediate drying 3 h 20°C.

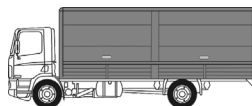
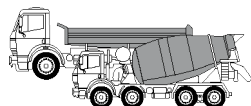


# TECHNICAL INFORMATION

## 568-408 Glasurit CV Primer Tinting Paste black

Z

### Range of application:



all applications

### Performance:

- brilliant top coat appearance
- colour strength
- can be used in PUR and EP primer and filler\*

### Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm  
The products are suitable for professional use only.

### Remarks:

Aluminum-Chassis have to be primed with a suitable primer  
The substrate should be clean, free of dust, rust, oil and grease



### Painting process

Spreading rate

Solid content ≈ 56 %



### Pre mix

max. 10% by volume  
for CV undercoat materials 9-7, 284-13, 284-90, 284-30, 284-45, 801-705, 801-715

### Remarks



\*Detailed information on mixing ratio and process data can be found inside technical data sheets of Primer / Filler.  
For tinting see CV Primer Tinting Paste 568-408.  
Processing data of the mentioned undercoats do not change by adding 568-408.

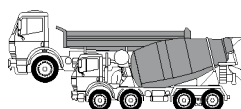
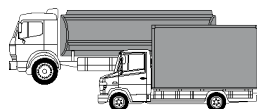


# TECHNICAL INFORMATION

568-409 Glasurit Airless Additive

Z

## Range of application:



## Performance:

- prevents foam formation during the airless application of Glasurit CV clearcoats
- no influence on the surface characteristic

## Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm  
The products are suitable for professional use only.

## Remarks:

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



## Painting process

Spreading rate

Solid content ≈ 13%



**Pre mix**  
**924-68 with 568-409**

100 parts paint material + 1 - 3% 568-409 for airless application.

## Remarks



568-409 avoids foam formation when CV Clearcoat is to be applied via Airless/ Airmix-application.  
Technical properties of the products in general remain.

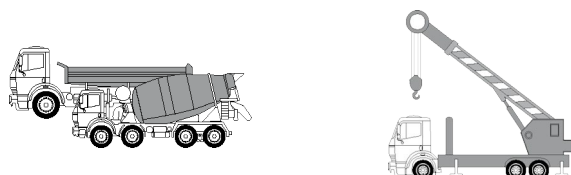


# TECHNICAL INFORMATION

## 568-412 Glasurit CV Thix Additive

Z

### Range of application:



### Performance:

- Improves sagging resistance of Line 68 on objects with difficult geometry
- Better edge covering on sharp edges / screws / rivets etc
- Exchange 568-412 one to one with reducer 352-
- Good levelling and topcoat finish

### Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm  
The products are suitable for professional use only.

### Remarks:

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



### Painting process

#### Spreading rate

Solid content ≈ 14%



#### Mixing ratio

4: 1 : 1 Vol.



#### Hardeners

922-138, 922-139 oder 922-136



#### Reducer

568-412



#### Viscosity DIN 4 / 20° C

~ 28 – 33 Sek.

Potlife 20 °C

< 60 Min.



#### 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.	30 min.

### Remarks



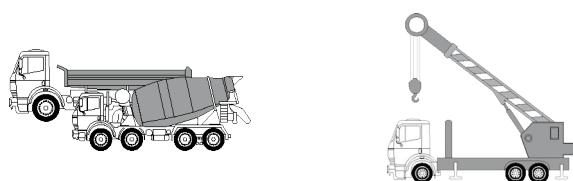
Line 68 with 568-412 is due to its slow evaporation rate suitable for large areas and vehicles, at higher temperatures 922-139 is recommended. For colors with less performance regarding edge covering, apply one thin but covered spray coat, follow flash-off time and a second spray coat. Follow recommended grey shade for colors to be applied.

# TECHNICAL INFORMATION

## 568-M 124 Glasurit CV Mixing Clear, mat

Z

### Range of application:



all applications where a reduced gloss is required

### Performance:

- suitable on all Glasurit CV primer filler and filler
- good matting effect
- excellent UV resistance
- good leveling
- all gloss levels can be achieved
- Gloss level can be adjusted via Color Online/Profit Manager

### Special remarks:

It cannot be ruled out that this product contains particles < 0.1 µm  
The products are suitable for professional use only.

### 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
								●●						

### Remarks:

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



### Painting process

Can be used in the Top coat 68 Line.

### Spreading rate

≈ 404 m<sup>2</sup> / l / 1µm

### Solid content

≈ 32 %



# TECHNICAL INFORMATION

## 568-M 124 Glasurit CV Mixing Clear, mat

**Z**



**Pre mix  
AD68 with 568M 124**

Line 68 u. 568-M 124 CV 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**

352-315, fast 15 - 20°C  
**352-320, medium** 20 - 25°C  
352-330, 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**

min max



**Tack-free**



**Ready for masking**



**Ready to assemble**



**Sandable**

<b>Object temp.</b>	<b>20°C</b>	16 h	2.5 h	16 h	12 h	16 h
<b>Object temp.</b>	<b>60°C</b>	30 min.	30 min.	30 min.	30 min.	30 min.

**Remarks**

**!**

A maximum addition 20% (5 : 1) with AD68 gives a gloss level of about 75 - 85% 60°.

568-M 124 must be stirred in with an air stirrer or alternatively a shaker.

Attention: The various topcoat hardener influences the gloss level; above mentioned gloss values refer to drying M124 with 922-139.

Adjust with hardener and reducer 5:1:1 Vol. with mixing stick.

568-M 124 can only be used in line 68.

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

## CV painting processes

### CV painting processes

#### 1. Which painting process for which vehicle?

**CV 1** Aluminium vehicles, 2-layer washprimer

**CV 1.1** Aluminium vehicles, 3-layer wet on wet

**CV 1.2** Buses, fire-fighting vehicles, 3-layer sanded

**CV 2** Aluminium vehicles, 2-layer EP 801-705

**CV 2.1** Buses, fire-fighting vehicles, 3-layer EP 801-705

**CV 2.2** Aluminium vehicles, 2-layer EP 801-715

**CV 2.3** Buses, fire-fighting vehicles, 3-layer EP 801-715

**CV 3** Chassis painting

**CV 3.1** 2K-Chassis painting, DTM or 2-layer

**CV 3.2** 2K-Chassis & Transport, 284-55 UHS

**CV 4** Plastics painting

**CV 5** Cab colour change (R68)

**CV 6** Chassis colour change

**CV 7** Powder-coated profiles

**CV 8** Multi-colour painting (R68)

**CV 9** Daylight Colours

**CV 10** UP- Spray filler 1006-26

**CV 11** Textured Paint

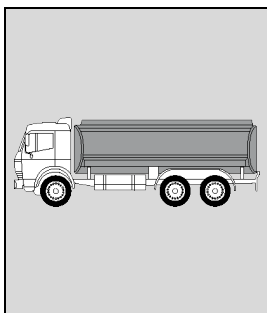
#### 2. CV painting processes “Race”

**CV Race 1** Repainting 284-13

**CV Race 2** Repainting 284-90

**CV Race 3** Repainting 283-1870

**CV Race 4** Repainting 283-6150



# Aluminium vehicles

## CV 1

### 2-layer

Application: Painting of Aluminium vehicles,

Substrates: Aluminium, hang-on parts made of steel or galvanised steel

#### Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

#### Body filling

839-20 + 948-36;

100 : 3

Sanding with P80 / P150

#### Primer filler

**283-1870**

Activator : 352-235

Reducer : 352-320

2 : 1 + 10-20%

Equipment : Gravity-feed spraygun\*  
Spray coats : 2 – 2½  
Film thickness: 20 - 25 µm  
Flash-off : at least 30 min. at 20°C  
max. 8 h at 20°C

#### Topcoat

**68-**

Hardener: 922-138

Reducer : 352-320

4 : 1 : 1

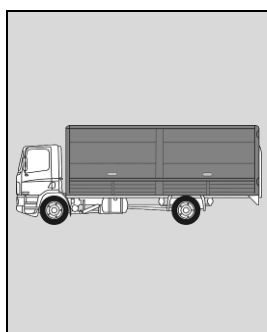
Equipment : Gravity-feed spraygun\*  
Spray coats : 1½  
Film thickness: 40 - 60 µm  
Drying : overnight air drying  
(16h at 20°C) or  
30 min. at 60°C

\* = 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.

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# Aluminium vehicles

## CV 1.1

### 3-layer wet on wet

Application: Painting of Aluminium vehicles,

Substrates: aluminium, Steel, galv. steel, stainless (Inox) steel,

#### Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

#### Body filling

839-20 + 948-36;

100 : 3

Sanding with P80 / P150

#### Primer filler

**283-1870**

Activator : 352-235  
Reducer : 352-320

2 : 1 + 10-20%

Equipment : Gravity-feed spraygun\*  
Spray coats : 1½ – 2  
Film thickness: 15 - 20 µm  
Flash-off : at least 30 min. at 20°C

#### Primer filler

**284-90**

Hardener:  
922-180 PRO  
Reducer : 352-320

3 : 1 + 30%

Equipment : Gravity-feed spraygun\*  
Spray coats : 2  
Film thickness: 50 - 70 µm  
Flash-off : at least 60 min. at 20°C  
30 min. at 60°C

(alternatively: wet-on-wet process with 284-45)

#### Surfacer

**284-45**

Hardener:  
922-180 PRO  
Reducer : 352-330

2:1+10-30%

Equipment : Gravity-feed spraygun\*  
Spray coats : 1 ½  
Film thickness: 50 - 70 µm  
Drying : 30 min. 60°C panel temp.  
or 1 h at 20°C

#### Topcoat

**68-**

Hardener: 922-138  
Reducer : 352-320

4 : 1 : 1

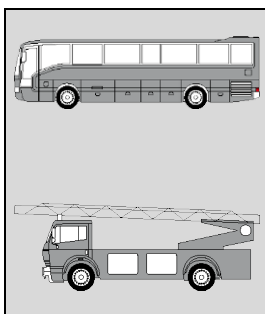
Equipment : Gravity-feed spraygun\*  
Spray coats : 1½  
Film thickness: 40 - 60 µm  
Drying : overnight air drying  
(16 h at 20°C) or  
30 min. at 60°C

\* = 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.





# Busses, fire fighting trucks CV 1.2

## 3-layer sanded

Application: Painting of high performance vehicles like:  
busses or fire fighting trucks,

Substrates: Steel, galv. steel, stainless (Inox) steel, aluminium

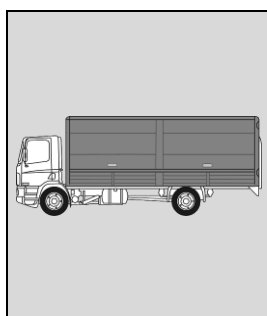
<b>Pre-treatment</b>	<b>Cleaning - Sanding - Cleaning</b> (See Technical Information Sheet A 4)		
<b>Body filling</b>	<b>839-20 + 948-36;</b>	<b>100 : 3</b>	<b>Sanding with P80/ P150</b>
<b>Primer</b>	<b>283-1870</b> Activator : 352-235 Reducer : 352-320	$2 : 1 + 10-20\%$	Equipment : Gravity-feed spraygun* Spray coats : $1\frac{1}{2} - 2$ Film thickness: <b>15 - 20 <math>\mu</math>m</b> Flash-off : at least 30 min. at 20°C max. 8 h at 20°C
<b>Sanding filler</b>	<b>284-30</b> Hardener: 922-18 PRO Reducer : 352-320	$4 : 1 : 1$	Equipment : Gravity-feed spraygun* Spray coats : <b>2</b> Film thickness: <b>70 - 90 <math>\mu</math>m</b> Drying : 45 min. 60°C panel temp. Sanding : dry with P400
<b>(alternatively: sanding process with 284-45)</b>			
<b>Surfacer</b>	<b>284-45</b> Hardener: 922-180 PRO Reducer : 352-330	$2:1+10-30\%$	Equipment : Gravity-feed spraygun* Spray coats : <b>1 <math>\frac{1}{2}</math> -2</b> Film thickness: <b>min. 80 <math>\mu</math>m</b> Drying : 45 min. 60°C panel temp. Sanding : dry with P400
<b>Note</b>	<b>Seal sand-throughs with 1 coat of 283-1870</b>		
<b>Topcoat</b>	<b>68-</b> Hardener: 922-138 Reducer : 352-320	$4 : 1 : 1$	Equipment : Gravity-feed spraygun* Spray coats : <b>1<math>\frac{1}{2}</math></b> Film thickness: <b>40 - 60 <math>\mu</math>m</b> Drying : overnight air drying (16 h at 20°C) or 30 min. at 60°C

\* = See product data sheet for other equipment.

<b>Safety instructions</b>	<ul style="list-style-type: none"> <li>It cannot be ruled out that this product contains particles &lt; 0.1 <math>\mu</math>m.</li> <li>The products are suitable for professional use only.</li> <li>For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.</li> </ul>
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# Aluminium vehicles

## CV 2

### 2-layer

Application: Painting of Aluminium vehicles,

Substrates: Steel, galv. steel, stainless (Inox) steel, aluminium

#### Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

#### Body filling

839-20 + 948-36;

100 : 3

Sanding with P80 / P150

#### Primer filler

#### 801-705

Hardener: 965-55

Reducer : 352-320

4 : 1 : 1  
Mixing stick

Equipment : Gravity-feed spraygun\*

Spray coats : 2

Film thickness: 50 - 70 µm

Flash-off : 1 h at 20°C or

Drying : 30 min. at 60°C

#### Topcoat

#### 68-

Hardener: 922-138

Reducer : 352-320

4 : 1 : 1  
Mixing stick

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

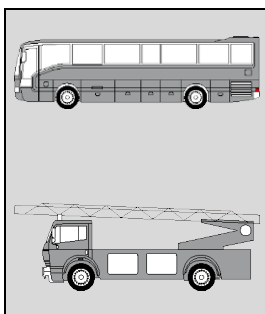
\* = See product data sheet for other equipment.

#### Note

Use separate feed lines for 801-705 and 68 Line.

#### 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.



## Busses, fire fighting trucks CV 2.1

**Application:** Painting of high performance vehicles like:  
busses or fire fighting trucks,

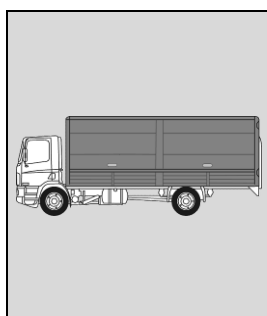
**Substrates:** Steel, galv. steel, stainless (Inox) steel, aluminium

<b>Pre-treatment</b>	<b>Cleaning - Sanding - Cleaning</b> (See Technical Information Sheet A 4)		
<b>Body filling</b>	<b>839-20 + 948-36</b>	<b>100 : 3</b>	<b>Sanding with P80/ P150</b>
<b>Primer filler</b>	<b>801-705</b> Hardener: 965-55 Reducer : 352-320	 <b>4 : 1 : 1</b> Mixing stick	Equipment : Gravity-feed spraygun* Spray coats : <b>2</b> Film thickness: <b>50 - 70 µm</b> Drying : 30 min. at 60°C
<b>Sanding filler</b>	<b>284-30</b> Hardener: 922-18 PRO Reducer : 352-320	 <b>4 : 1 : 1</b>	Equipment : Gravity-feed spraygun* Spray coats : <b>2</b> Film thickness: <b>70 - 90 µm</b> Drying : 45 min. 60°C panel temp. Sanding : dry with P400
<b>(alternatively: wet-on-wet process with 284-45 or 284-90)</b>			
<b>Surfacer</b>	<b>284-45</b> Hardener: 922-180 PRO Reducer : 352-330	 <b>2:1+10-30%</b>	Equipment : Gravity-feed spraygun* Spray coats : <b>1 ½</b> Film thickness: <b>50 - 70 µm</b> Drying : 30 min. 60°C panel temp. or 1 h at 20°C
<b>Note</b>	<b>Seal sand-throughs with 1 coat of 801-705</b>		
<b>Topcoat</b>	<b>68-</b> Hardener: 922-138 Reducer : 352-320	 <b>4 : 1 : 1</b>	Equipment : Gravity-feed spraygun* Spray coats : <b>1½</b> Film thickness: <b>40 - 60 µm</b> Drying : overnight air drying (16 h at 20°C) or 30 min. at 60°C

\* = See product data sheet for other equipment.

<b>Safety instructions</b>	<ul style="list-style-type: none"> <li>It cannot be ruled out that this product contains particles &lt; 0.1 µm.</li> <li>The products are suitable for professional use only.</li> <li>For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.</li> </ul>
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# Aluminium vehicles

## CV 2.2

### 2-layer

Application: Painting of Aluminium vehicles,

Substrates: Steel, galv. steel, stainless (Inox) steel, aluminium

#### Pre-treatment

Cleaning - Sanding - Cleaning

#### Body filling

839-20 + 948-36;

100 : 3

Sanding with P80 / P150

#### Primer filler

### 801-715

Hardener: 965-715

Additive : 568-745

4 : 1 : 1  
Mixing stick

Equipment : Gravity-feed spraygun\*

Spray coats : 2

Film thickness: 50 - 70 µm

Drying : 1 h at 20°C

#### Topcoat

### 68-

Hardener: 922-138

Reducer : 352-320

4 : 1 : 1  
Mixing stick

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

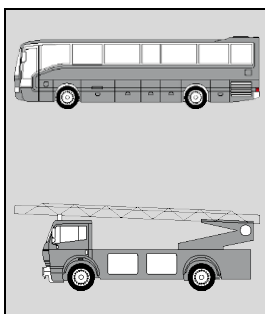
\* = See product data sheet for other equipment.

#### Note

Use separate feed lines for 801-715 and 68 Line.

#### 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.

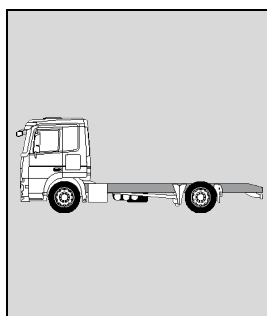


# Busses, fire fighting trucks CV 2.3

**Application:** Painting of high performance vehicles like:  
busses or fire fighting trucks,

**Substrates:** Steel, galv. steel, stainless (Inox) steel, aluminium

Pre-treatment	Cleaning - Sanding - Cleaning		
Body filling	839-20 + 948-36	100 : 3	Sanding with P80/ P150
Primer filler	<div>801-715</div> <div>Hardener: 965-715</div> <div>Additive : 568-745</div>	<div>4 : 1 : 1</div> <div>Mixing stick</div>	<div>Equipment : Gravity-feed spraygun*</div> <div>Spray coats : 2</div> <div>Film thickness: 50 - 70 µm</div> <div>Drying : 1h 20°C</div>
Filler	<div>284-45</div> <div>Hardener: 922-180 PRO</div> <div>Reducer : 352-330</div>	<div>2:1+10-30%</div>	<div>Equipment : Gravity-feed spraygun*</div> <div>Spray coats : 2</div> <div>Film thickness: 50 - 70 µm</div> <div>Drying : 45 min. 60°C object temp. for sanding or 1h at 20°C wet on wet</div>
Note	Seal sand-throughs with 1 coat of 801-715		
Topcoat	<div>68-</div> <div>Hardener: 922-138</div> <div>Reducer : 352-320</div>	<div>4 : 1 : 1</div>	<div>Equipment : Gravity-feed spraygun*</div> <div>Spray coats : 1½</div> <div>Film thickness: 40 - 60 µm</div> <div>Drying : overnight air drying (16 h at 20°C) or 30 min. at 60°C</div>
* = See product data sheet for other equipment.			
Note	Use separate feed lines for 801-715 and 68 Line.		
Safety instructions	<div><div></div><div><ul style="list-style-type: none"><li>It cannot be ruled out that this product contains particles &lt; 0.1 µm.</li><li>The products are suitable for professional use only.</li><li>For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.</li></ul></div></div>		



# Chassis painting

## CV 3

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**  
Activator : 352-235  
Reducer : 352-320

Equipment : gravity-feed spraygun\*  
Spray coats : 1½  
Film thickness: **12 - 15 µm**  
Flash-off : 20 -30 min. 20°C  
max 8 h at 20°C

**2 : 1 + 10%**

### Chassissurfacer

**284-13**  
Hardener: 922-18 PRO  
Reducer : 352-320

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

**4 : 1 : 1**

#### Alternative:

### Primer Filler

**284-90**  
Hardener: 922-180 PRO  
Reducer. : 352-320

Equipment : gravity-feed spraygun \*  
Spray coats : 2  
Film thickness: **50 - 70 µm**  
Flash-off : min 60 min. at 20°C  
or 30 min.at 60°C

**3 : 1 + 30%**

#### Alternative:

### Primer filler

**9-7**  
Additive : 568-96

Equipment : gravity-feed spraygun \*  
Spray coats : 2  
Film thickness: **50 - 60 µm**  
Flash-off : at least 60 min. at 20°C  
or 30 min. at 60°C

**4 : 1**

### Topcoat

**68-**  
Hardener: 922-138  
Reducer : 352-320

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

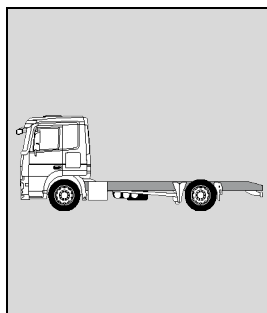
**4 : 1 : 1**

\* = 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.
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# 2K-Chassis painting

**CV 3.1**

## DTM or 2 layer

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**

Topcoat: 68-

1:1

7 : 1 +  
10-15%

Hardener: 922-138

Reducer: 352-320

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**

Top coat: 68-

70:30

7 : 1 +  
15-25%

Hardener: 922-138

Reducer: 352-320

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

Reducer: 352-320

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. at 60°C

### Remark

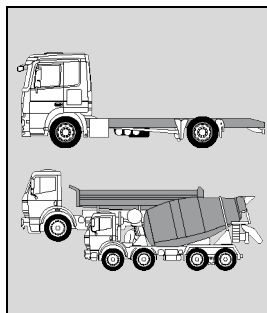
To cover the roughness of the sand blasted areas the above mentioned film thickness has to be achieved

\* = 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.





# Chassis- & Transport

## CV 3.2

Application: Chassis painting  
Substrates: Steel (blasted), aluminium, galv. steel parts

Pre-treatment

Cleaning, sanding, cleaning

Body filling

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

UHS Primerfiller

**284-55**

Hardener: 922-55 PRO

3 : 1

Equipment : Airmix\*  
Spray coats : 1,5 - 2  
Film thickness: 60 - 70 µm  
Flash-off : 60 min. at 20°C  
or 30 min. at 60°C

Topcoat

**68-**

Hardener: 922-138  
Reducer : 352-320

4 : 1 : 1

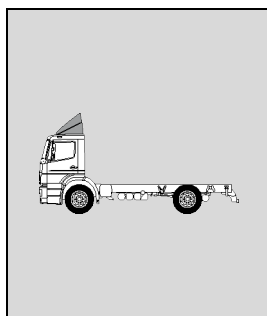
Equipment : gravity-feed spraygun\*  
Spray coats : 1,5  
Film thickness: 40 - 60 µm  
Drying : overnight air drying  
(16 h at 20°C) or  
30 min. at 60°C

\* = See product data sheet for other equipment.

Safety instructions

- 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.





# Plastics painting \*\*

CV 4

Application: Application of plastic parts of commercial vehicles  
Substrates: various plastic types

## Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

### 1) Plastic: ABS, PC, GRP, SMC

#### Surfacer

**284-45**

Hardener:  
922-180 PRO  
Reducer : 352-320

2:1+10-30%

Equipment : gravity-feed spraygun\*  
Spray coats : 1½  
Film thickness: 40 – 60 µm  
Drying : 60 Min. 20°C or  
30 min. at 60°C  
panel temp

### 2) Plastic: PA, PP-EPDM, PP T16 / T20, TPE

#### Adhesion promoter

**284-45**

Hardener:  
922-180 PRO  
Reducer : 568-20

2 : 1 + 30%

Equipment : gravity-feed spraygun\*  
Spray coats : 1  
Film thickness: ca. 20 - 30 µm  
Drying : 60 Min. 20°C or  
30 min. at 60°C

### 3) Plastic: PP, PE\*\* = The adhesion on PE and PP can't be guaranteed.

#### Adhesion promoter

**284-45**

Hardener:  
922-180 PRO  
Reducer : 568-20

2 : 1 + 30%

Equipment : gravity-feed spraygun\*  
Spray coats : 1  
Film thickness: ca. 20 - 30 µm  
Drying : 60 Min. 20°C or  
30 min. at 60°C

### Afterwards on 1, 2, or 3:

#### Topcoat

**68-**

Hardener: 922-138  
Reducer : 352-320

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. at 60°C

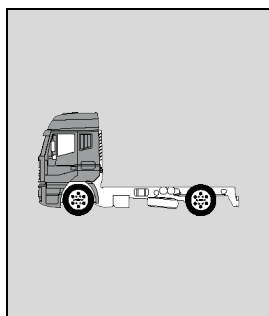
\* = See product data sheet for other equipment.

## Remark

\*\*Due to different raw material supplier the quality of the different plastics can be differ from time to time.  
The adhesion should be checked before painting.

## 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.



# Cab color change

## CV 5

Application: Cab color change

Substrates: Old paintwork

### Pre-treatment

### Cleaning - Sanding – Cleaning

(See Technical Information Sheet A 4)

### Adhesion promoter

#### 285-0 CV

Hardener: 922-18 PRO  
Reducer : 352-320

2 : 1 + 30%

Equipment : gravity-feed spraygun\*  
Spray coats : 1  
Film thickness: **approx. 20 - 25 µm**  
Flash-off : at least 15 min. at 20°C  
max. 2 h

Alternative to 285-0 CV:

284-45 (see product data sheet)

### Topcoat

#### 68-

Hardener: 922-138  
Reducer : 352-320

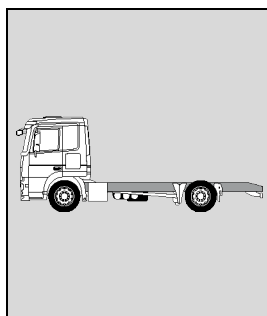
4 : 1 : 1

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

\* = 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.



# Chassis colour change

**CV 6**

Application: Chassis colour change  
Substrates: Old paintwork, Factory finish

## Pre-treatment

**Cleaning - Sanding - Cleaning** (See Technical Information Sheet A 4)

## Body filling

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

## Note

When you do not know how the original chassis paintwork will react to solvents, you should do a solvent resistance test using a cloth soaked in solvent to see if a reaction occurs.

## Adhesion promoter (not on bare metal)

### 285-0 CV

Hardener: 922-18 PRO  
Reducer : 352-320

**2 : 1 + 30%**

Equipment : gravity-feed spraygun\*  
Spray coats : **1**  
Film thickness: **approx. 20 - 25 µm**  
Flash-off : at least 15 min. at 20°C  
max 2 h

or

## Adhesion promoter

### Solvent-sensitive factory finish

### 9-7

Reducer : 568-96

**4 : 1**

Equipment : gravity-feed spraygun\*  
Spray coats : **1**  
Film thickness: **20 - 30 µm**  
Flash-off : at least 60 min. at 20°C or  
30 min. at 60°C

## Topcoat

### 68-

Hardener: 922-138  
Reducer : 352-320

**4 : 1 : 1**

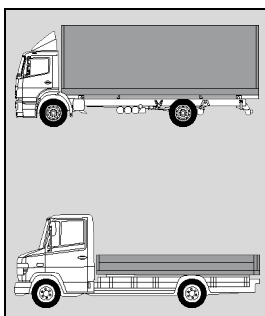
Equipment : gravity-feed spraygun\*  
Spray coats : **1½**  
Film thickness: **40 - 60 µm**  
Drying : overnight air drying  
(16 h at 20°C) or  
30 min. at 60°C

\* = 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.

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# Powder-coated profiles

## CV 7

Application: All kind of pre coated profiles and boxes

Substrates: powder coated substrates

### Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

### Adhesion promoter

#### 284-45

Hardener: 922-180 PRO  
Reducer : 352-320

} **2 : 1 + 30%**

Equipment : gravity-feed spraygun  
Spray coats : **1**  
Film thickness: **ca. 30 µm**  
Drying : min 30 min. at 20°C or max 72h

Alternative product to 284-45:

**285-0 CV (see product data sheet)**

### Topcoat

#### 68-

Hardener: 922-138  
Reducer : 352-320

} **4 : 1 : 1**

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

\* = See product data sheet for other equipment.

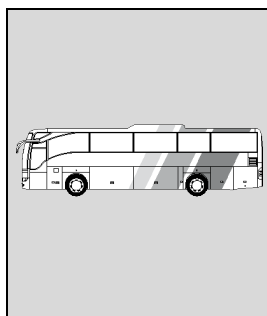
### Safety instructions

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BASF Coatings GmbH, Automotive Refinish Coatings Solutions Europe, Glasuritstrasse 1, 48165 Münster, Germany

09/2022



## Multi-colour painting

### CV 8

**Application:** Sign writing, Multi-colour painting with 68 Line and 568-17 CV Multi-Colour Additive

**Substrates:** CV primer filler / filler and old paintwork

#### Substrates

**With adhesion promoter:** Sanded, well-cured old paintwork

**Without adhesion promoter:** Dried undercoats (30 min. at 60°C or up to 16 h air-drying); when dried longer than this, the surfacer must be sanded with P 400 and cleaned with 541-5!

#### Adhesion promoter

##### 285-0 CV

Hardener:  
922-16 PRO  
Reducer : 352-310

2 : 1 + 30%

Equipment : gravity-feed spraygun\*  
Spray coats : 1  
Film thickness : **approx. 20 - 25 µm**  
Flash-off : at least 15 min. at 20°C  
max. 2 h

#### Topcoat

##### 68- \*\*

Hardener: 922-138  
or 922-136  
Reducer : 568-17

4 : 1 : 1

Equipment : gravity-feed spraygun \*  
Spray coats : **1½ - 2**  
Film thickness: **40 - 60 µm**  
Tape resistant: after 2 h at 20°C  
Potlife max. 30 min.

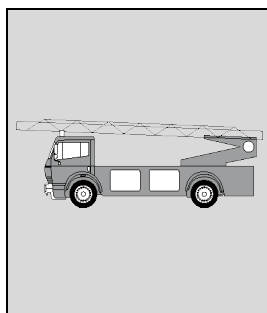
**\*\*after 16h airdrying use adhesion promoter 285-0 CV!**

\* = 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.

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# Daylight Colours

## CV 9

Application: Glasurit Fluorescent Paint  
Substrates: All CV primer filler / filler, old paint work coated with 284-45 or 284-90

### Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

### Primer

See painting process for the vehicle to be finished.

### Filler

**284-45**  
Hardener: 922-180PRO  
Reducer : 352-330  
Equipment : gravity-feed spray gun \*  
Spray coats : 1 ½  
Film thickness: 50 - 70 µm  
Drying : 30 min. 60°C panel temp. or 1 h 20°C

2 : 1 +10-30%

Alternative to 284-45:

### Primer Filler

**284-90**  
Hardener: 922-180 PRO  
Reducer. : 352-320  
Equipment : gravity-feed spraygun \*  
Spray coats : 2  
Film thickness: 50 - 70 µm  
Flash-off : min 60 min. at 20°C  
30 min.at 60°C

3 : 1 + 30%

### Daylight Colours

RAL 1026/00T  
RAL 2005/00T  
RAL 3024/00T

**923-**  
Hardener: 929-93  
Reducer. : 352-320  
Equipment : gravity-feed spray gun\*  
Spraycoats : 4 – 5  
Film thickness: min. 100 µm  
Flash off\*\* : min. 60 Min. 60°C or drying over night at 20°C

4 : 1 + 10%

### Protective Clear \*\*\*

**923-49**  
Hardener: 929-93  
Reducer. : 352-320  
Equipment : gravity-feed spraygun\*  
Spraycoats : 2  
Film thickness: 50 - 70 µm  
Drying : 60 min. at 60°C or 10 h at 20°C

2 : 1 + 10%

\* = See product data sheet for other equipment.

\*\* = If masking is not required, fluorescent paint may be sprayed without prior sanding after 1 hour already. For dry sanding with an Orbital sander use sanding paper P400.

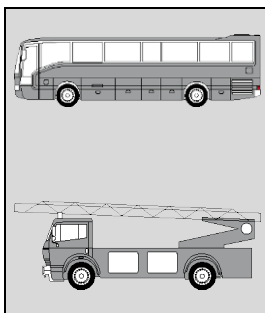
→ Sand-throughs must be blended in by means of **284-90** or **284-45**.

\*\*\* = Use only 923-49 as protective coat/ clear coat.

### 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.





## Glasurit<sup>®</sup>, UP – Spray Filler CV 10

Application: Painting process for extensive body filling

Substrates: Steel, galv. steel, stainless (Inox) steel, aluminium, powder-/coil-coated surfaces, plywood, GRP, SMC old paintwork

### Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

### Body filling

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

### 1.1 Aluminium, stainless steel (Inox), galv. Steel

#### Primer

#### 283-6150

Activator: 352-235  
Reducer : 352-320

2 : 1 + 10%

Equipment : gravity-feed spraygun\*  
Spray coats : 1½  
Film thickness : 12 - 15 µm  
Drying : min. 20 - 30 at 20°C  
max. 8 h at 20°C

### 1.2 Steel

#### Primer filler

#### 284-13

Hardener:  
922-18 PRO  
Reducer : 352-320

4 : 1 : 1

Equipment : gravity-feed spraygun\*  
Spray coats : 1 full coat  
Film thickness: approx. 30 - 40 µm  
Drying : 30 min. at 60°C

### 2 Application of 1006-26 on primed substrates as mentioned in 1.1 and 1.2 (not directly on 283-6150) or directly on following substrates: Aluminium, Powdercoating, Coil Coating, Plywood, GRP, SMC, Old Paintwork

#### UP Spray Filler

#### 1006-26

hardener : 948-22  
reducer : 352-310

100 : 5  
additional 352-310 if required,  
max 2% weight

Equipment : gravity-feed spraygun\*  
Spray coats : 3 – 8  
Film thickness: 200 - 1000 µm  
Drying : 3 – 4 h. at 20°C or  
30 min at 60°C

\* = See product data sheet for other equipment.

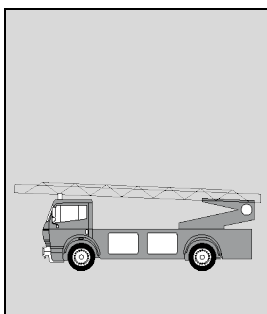
### 3 further process steps: Use the undercoat materials and top coats as described in the painting process of the corresponding vehicle

#### Safety instructions

- It cannot be ruled out that this product contains particles < 0.1 µm.
- The products are suitable for professional use only.
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# Textured Paint (fire fighting trucks) CV 11

**Application:** Painting of high performance vehicles like: fire fighting trucks with textured paint,

**Substrates:** PU-Primer Filler or PU-Filler

## Pre-treatment

**Cleaning - Sanding - Cleaning** (See Technical Information Sheet A 4)

### Primer

#### 283-6150

Hardener: 352-235  
Reducer : 352-320

2 : 1 + 10%

Equipment : Gravity-feed spraygun\*  
Spray coats : 2  
Film thickness: 12 - 15 µm  
Flash off : min. 20 – 30 at 20°C  
max. 8h 20°C

### Primer filler

#### 284-90

Hardener: 922-180 PRO  
Reducer : 352-320

3 : 1 +30%

Equipment : Gravity-feed spraygun\*  
Spray coats : 2  
Film thickness: 50 - 70 µm  
Flash off : 30 min. at 60°C or  
1h at 20°C

### Textured Filler

Pre-mix 284-99 with topcoat 68 line before adding hardener (90:10), same color

#### 284-99

Hardener: 922-138  
Reducer : -

8 : 1

Equipment : Pressure Pot\*  
Spray coats : 1 - 2  
Nozzle : 1,6 – 2,5 mm  
Material-  
Pressure : ~ 1,0 - 1,5 bar  
Atomisation-  
Pressure : ~ 0,5 - 1,5 bar  
Flash off : 60 min. 20°C or  
30 min. at 60°C

### Topcoat

#### 68-

Hardener: 922-138  
Reducer : 352-320

4 : 1 : 0,5-1

Equipment : Gravity-feed spraygun\*  
Spray coats : 1½  
Film thickness: 40 - 60 µm  
Drying : overnight air drying or  
30 min. at 60°C  
panel temp.

\* = See product data sheet for other equipment

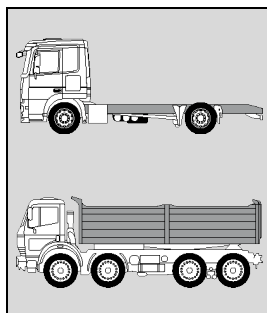
### Remarks:

284-99 needs to be prepared 90:10 with topcoat 68 Line before application. For colors with less hiding power: recommended to add reducer to 284-99 and pre-spray one or two coats flat, without textured effect (RP 1,4mm), afterwards use 284-99 (8:1) as textured filler + topcoat 68 line.

### Safety instructions

- It cannot be ruled out that this product contains particles < 0.1 µm.
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# Repair

# CV Race 1

Application: Chassis painting with 2K Chassissurfacer

Substrates: Steel, aluminium

## Pre-treatment

Cleaning – sanding - cleaning (See Technical Information Sheet A 4)

## Body filling

839-20 + 948-36; 100 : 3

Sanding with P80 / P150

## Primer only for aluminium

### 283-6150

Activator : 352-228

Reducer : 352-310\*\*

2 : 1 + 10%

Equipment : gravity-feed spraygun\*

Spray coats : 1½

Film thickness: 12 - 15 µm

Flash-off : min.20 - 30 at 20°C  
max 8 h at 20°C

## Chassissurfacer

### 284-13

Hardener: 922-18PRO

Additive : 568-17

Reducer : 352-310\*\*

4 : 1 : 0,5:0,5

Equipment : gravity-feed spraygun\*

Spray coats : 2

Film thickness: 60 - 70 µm

Flash-off : at least 30 min. at 20°C

## Topcoat

### 68-

Hardener: 922-136

reducer : 568-17

Potlife max 30 min.

4 : 1 : 1

Equipment : gravity-feed spraygun\*

Spray coats : 1½

Film thickness: 40 - 60 µm

Drying : air drying

\* = See product data sheet for other equipment.

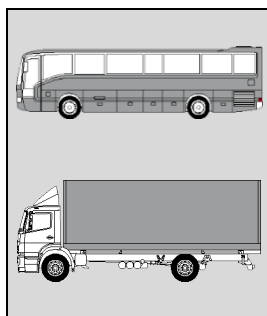
\*\*= Depending on size, object and ambient temperature

## Remark

The area that has to be painted should not exceed 3m².

## 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.



## Repair

## CV Race 2

Application: Repainting of boxes and busses

Substrates: Steel, galv. steel, stainless (Inox) steel, powder-/coil-coated surfaces, plywood, GRP, SMC,

### Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

### Body filling

839-20 + 948-36; 100 : 3

Sanding with P80 / P150

### Primer filler

#### 284-90

hardener: 922-180PRO

Reducer : 352-315

3 : 1 + 30%

Equipment : gravity-feed spraygun\*

Spray coats : 1½

Film thickness: 50 - 60 µm

Flash-off : at least 60 min. at 20°C

### Topcoat

#### 68-

hardener : 922-136

reducer : 568-17

Potlife max 30 min.

4 : 1 : 1

Equipment : gravity-feed spraygun\*

Spray coats : 1½

Film thickness: 40 - 60 µm

Drying : air drying

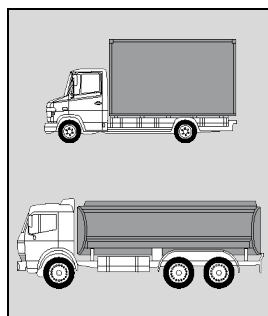
\* = See product data sheet for other equipment

### Remarks

The area that has to be painted should exceed 3m².

### 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.



# Repair

## CV Race 3

Application: Repainting of boxes and busses,

Substrates: Aluminium vehicles, hang-on parts made of steel or galvanised steel

### Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

### Body filling

839-20 + 948-36; 100 : 3

Sanding with P80 / P150

### Primer filler

#### 283-1870

Activator: 352-228\*\*

Reducer: 352-320

2 : 1 + 10-20%

Equipment : gravity feed spraygun\*

Spray coats : 2 – 2½

Film thickness: 20 - 25 µm

Flash-off : at least 15 min. at 20°C  
max. 8 h at 20°C

### Topcoat

#### 68-

hardener : 922-136

reducer : 568-17

Potlife max 30 min.

4 : 1 : 1

Equipment : gravity feed spraygun\*

Spray coats : 1½

Film thickness: 40 - 60 µm

Drying : air drying

\* = See product data sheet for other equipment.

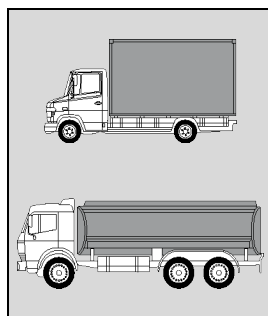
\*\*= Depending on size, object and ambient temperature

### Remarks

The area that has to be painted should exceed 3m².

### 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.



# Repair

## CV Race 4

Application: Repainting of boxes and busses  
Substrates: Aluminium vehicles, hang-on parts made of steel or galvanised steel

### Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

### Body filling

839-20 + 948-36; 100 : 3

Sanding with P80 / P150

### Primer filler

#### 283-6150

Activator : 352-228

Reducer : 352-310\*\*

2 : 1 + 10%

Equipment : gravity-feed spraygun\*

Spray coats : 1½

Film thickness: 12 - 15 µm

Flash-off : min. 20 min. at 20°C  
max 8 h at 20°C

### Sanding filler

#### 284-30

Hardener: 922-18 PRO

Additive : 568-17

Reducer : 352-310\*\*

4 : 1 : 0,5:0,5

Equipment : gravity-feed spraygun\*

Spray coats : 2

Film thickness: 70 - 90 µm

Drying : 30 min. at 60°C

Sanding : dry with P400

alternatively, to 284-30:

wet-on-wet process with 284-45

### Surfacer

#### 284-45

hardener :

922-180 PRO

Additive : 568-17

Reducer : 352-310\*\*

2:1+5%+5%

Equipment : gravity-feed spraygun\*

Spray coats : 2

Film thickness: 50 - 70 µm

Drying : 30 min. at 20°C

### Topcoat

#### 68-

hardener : 922-136

reducer : 568-17

Potlife max 30 min.

4 : 1 : 1

Equipment : gravity-feed spraygun\*

Spray coats : 1½

Film thickness: 40 - 60 µm

Drying : air drying

\* = See product data sheet for other equipment.

\*\*= Depending on size, object and ambient temperature

### Remarks

The area that has to be painted should exceed 3m².

### 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.



## Which products for which substrates?

D 1

		Rawmaterial base	Steel	Galv. steel*	Stainless steel	Aluminium	Anodised alum.	GRP/SMC	PP-EPDM	Glasurit® CV-Primer	Glasurit® CV-Primer-Filler / Filler	Powder	Coil-Coating	Plywood	Wood	Factory finish	Old paintwork
<b>Polyester-Body fillers</b>																	
Glasurit Ratio Body Filler	839-20	PE	●●	●●	○	●●		●			●	●	●	●	●●	●	●
CV Flexible Body Filler	839-15	PE	●●			●●		●			●	●	●	●	●●	●	●
CV Flexible Body Filler	839-45	PE	●●			●●		●			●	●	●	●	●●	●	●
HS Polyester Spray Filler	1006-26	PE	●			○		●●			●	●	●	●	●●	●●	●●
<b>Stone chip and underbody protection</b>																	
Underbody protection	1109-1503/3									●	●●					●●	●●
Underbody protection	1109-1240/4									●	●●					●●	●●
<b>Primer</b>																	
CV Shop Primer	183-153	PVB	●●	●●												●	●
CV Wash Primer	283-6150	PVB	●●	●●	●●	●●	●●					○	○			○	○
<b>Primer Filler</b>																	
CV Steel Primer	9-7	EP-E	●●										○		○	●●	●●
CV Multi Wash	283-1870	PVB	●●	●●	●●	●●	●					○	○			○	○
CV 2K UHS Primerfiller	284-55	PUR	●●	●		●											
CV 2K Chassis Surfacer	284-13	PUR	●●	●				●●		●●		●	●	●●	●●	●	●●
CV 2K PUR Primerfiller	284-90	PUR	●●	●●	●●	●	●	●●				●●	●●	●●	●●	●	●
CV HS Epoxy, light grey	801-705	EP	●●	●●	●●	●●	●	●●				●●	●●	●●	●●	●	●
CV HS EP Primerfiller, grey	801-715	EP	●●	●●	●●	●●	●	●●				●●	●●	●●	●●	●	●
Steel Primer Paste	568-46 / 70:30	PUR	●●	●●				●		●		●	●			●	●
<b>Surfacer</b>																	
CV Filler white	284-45	PUR						●●	●	●●	●●	●●	●●	●●	●●	●●	●●
CV Sanding Filler	284-30	PUR						●●		●●	●●	●●	●●	●●	●●	●●	●●
CV Textured Filler	284-99	PUR						●●		●●	●●	●●	●●	●●	●●	●●	●●
<b>Adhesion promoter</b>																	
Transparent Sealer CV	285-0 CV	PUR						○		●●	●●	●●	●●	○	●●	●●	●●
284-45 with 568-20	568-20	PUR						●●	●●		●●	●●	●●	●●	●●	●●	●●
<b>DTM Topcoat</b>																	
Steel Primer Paste (DTM)	568-46 / 1:1	PUR	●●	●●				●			●	●	●			●	●

●● = very well suited    ● = well suited    ○ = suited in some cases (Testing recommended)

\* = The adhesion on hot dipped galvanized steel has to be checked before

For detailed information pay attention to the Technical Information of the corresponding product.

### Key to abbreviations:

EP = epoxy/ polyamine  
EP E = epoxy ester  
CP = copolymer

PE = polyester  
PU = polyurethane/ isocyanate  
PU-AC = Polyurethan-Acrylat/ Isocyanat  
PVB = polyvinyl butyral/ phosphoric acid

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## Tinting guide for 68 Line solid colours

D 2

Tinting direction	Colour group									
	white	grey	yellow	beige	orange	red	bordeaux	brown	green	blue
<b>lighter</b>	T 002	T 002	T 002	T 002	T 002	T 002	T 002	T 002	T 002	T 002
<b>dirtier</b>	T 900	T 900	T 900	T 900	T 900	T 900	T 900	T 900	T 900	T 900
<b>darker</b>	T 900	T 900	T 900	T 900	T 200	T 330*	T 310	T 900	T 600	T 500 T 523
<b>bluer</b>	T 500 T 523	T 500 T 523	-	-	-	-	-	-	T 600	T 600
<b>greener</b>	T 600	T 600	T 600	T 600	-	-	-	-	T 600	T 600
<b>yellower</b>	T 100	T 100	T 141*	T 100	T 141*	T 141*	T 100	T 100	T 141*	-
<b>orange</b>	T 120	T 120	T 230	T 230	T 230	T 230	T 230	T 230	-	-
<b>redder</b>	T 311	T 311	T 230	T 311	T 330*	T 330*	T 330*	T 311	-	T 340
<b>more violet</b>	T 340	T 340	-	T 340	-	T 340	T 310	T 340	-	T 420

Use only the mixing bases contained in the relevant mixing formula.

\* Do not use in low concentration!



## 68 T ... Tinting bases

D 3

Tinting Base	Product code	Name	
		German	English
T 002	AD68-00ZX 0102	weiß	white
T 100	AD68-139K 0102	oxidgelb	oxide yellow
T 120	AD68-13L1 0102	signalgelb	signal yellow
T 141	AD68-136K 0102	zitrusgelb	lemon yellow
T 144	AD68-1144 0102	Sonnengelb	sun yellow
T 150	AD68-1150 0102	gelb	yellow
T 200	AD68-2200 0102	hellorange	light orange
T 230	AD68-2230 0102	reinorange	pure orange
T 310	AD68-32KH 0102	bordeaux	bordeaux
T 311	AD68-328Z 0102	oxidrot	oxide red
T 320	AD68-3320 0102	dunkelrot	dark red
T 330	AD68-3330 0102	rot	red
T 340	AD68-32LH 0102	weinrot	wine red
T 350	AD68-3350-0102	Neonpink	neon pink
T 420	AD68-4020 0102	lila	lilac
T 500	AD68-51TT 0102	dunkelblau	dark blue
T 523	AD68-51PT 0102	mittelblau	medium blue
T 531	AD68-5531 0102	blau	blue
T 600	AD68-60XM 0102	flaschengrün	bottle green
T 900	AD68-94H1 0102	blauschwarz	bluish black
T 920	AD68-9920 0102	gelbschwarz	yellowish black
T 940	AD68-9940 0102	schwarz	black
568-M 135	AZ68-1350 0105	HS 2K CV Mixing Clear	
568-M 100	AZ68-0100 0105	HS 2K CV Airless Mixing Clear	
568-M 124	AZ68-0124 0035	HS 2K CV Mixing Clear, mat	
922-139	SC22-0139	2K CV Topcoat Hardener Premiium	
922-138	SC22-0138	2K CV Topcoat Hardener normal	
922-136	SC22-0136	2K CV Topcoat Hardener fast	

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## Main products and resin bases

D 4

Product	Resin base	Abbreviation
839-15	unsaturated polyester	UPE
839-20	unsaturated polyester	UPE
839-45	unsaturated polyester	UPE
1006-26	unsaturated polyester	UPE
9-7	epoxy ester	EP E
183-153	polyvinylbutyral	PVB
283-6150	polyvinylbutyral	PVB
283-1870	polyvinylbutyral	PVB
284-13	polyurethane	PU
284-90	polyurethane	PU
284-45	polyurethane	PU
284-55	polyurethane	PU
284-30	polyurethane	PU
284-99	polyurethane	PU
285-0 CV	polyurethane	PU
801-705	epoxy	EP
801-715	epoxy	EP
568-46	polyurethane	PU
68-	polyurethane acrylate	PU AC
58-	polyurethane acrylate (gloss-reduced)	PU AC
90 CV PLUS	polyurethane, water-thinnable	PU, W
924-68	modified polyacrylate	PAC
924-168	modified polyacrylate	PAC

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## Temperature table for Glasurit products

D 5

This table shows reference material combinations based on market experience. However, customer-specific parameters (e.g. spraybooth, objects to be painted or atomizing technique) may require different hardener/reducer combination.

		Up to 15°C	from 15°C	from 20°C	from 25°C	from 30°C
9-7	Hardener					
	Reducer	568-96	568-96	568-96	568-96	568-96
283-6150	Hardener	352-235	352-235	352-235	352-235	352-235
	Reducer	352-310	352-320	352-320	352-330	352-330
283-1870	Hardener	352-235	352-235	352-235	352-235	352-235
	Reducer	352-315	352-320	352-320	352-330	352-330
801-705	Hardener	not	965-55	965-55	965-55	965-55
	Reducer	suitable	352-320	352-320	352-330	352-330
801-715	Hardener	not	965-715	965-715	965-715	965-715
	Reducer	suitable	568-720	568-745	568-745	568-745
284-13	Hardener	922-16 PRO	922-18 PRO	922-18 PRO	922-18 PRO	922-18 PRO
	Reducer	352-315	352-320	352-330	352-330	352-340
284-90	Hardener	922-180 PRO	922-180 PRO	922-180 PRO	922-180 PRO	922-180 PRO
	Reducer	352-320	352-320	352-320	352-330	352-340
284-30	Hardener	922-16 PRO	922-18 PRO	922-18 PRO	922-18 PRO	922-18 PRO
	Reducer	352-315	352-320	352-320	352-330	352-340
284-45	Hardener	922-180 PRO	922-180 PRO	922-180 PRO	922-180 PRO	922-180 PRO
	Reducer	352-315	352-320	352-330	352-330	352-340
568-46	Hardener	922-136	922-138	922-138	922-138	922-138
	Reducer	352-315	352-320	352-320	352-330	352-340
568-46 (DTM)	Hardener	922-136	922-138	922-138	922-138	922-138
	Reducer	352-315	352-320	352-320	352-330	352-340
68	Hardener	922-136	922-138	922-138	922-138	922-139
	Reducer	352-310	352-315	352-320	352-330	352-340
68-9006	Hardener	922-136	922-136	922-136	922-136	922-138
	Reducer	352-310	352-310	352-310	352-320	352-320
924-68	Hardener	922-136	922-138	922-138	922-138	922-138
	Reducer	352-315	352-320	352-330	352-330	352-340
924-168	Hardener	922-136	922-138	922-138	922-138	922-138
	Reducer	352-320	352-330	352-330	352-330	352-330

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## Gloss level with CV – Matting Mixing clear 568-M124









D 6

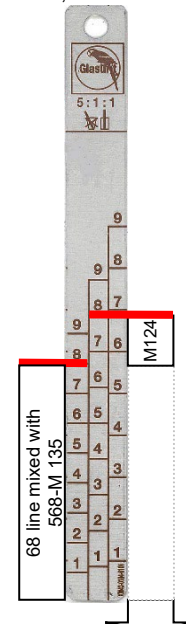
### General remarks on mat topcoats

Usage in Ready-Mixed  
Color, max. 5:1

Replace

The gloss level of a mat topcoat is influenced by:

-  filmbuild
-  color
-  hardener
-  reducer
-  painting process
-  flash off between coats
-  drying
  - air drying
  - oven drying
  - flash off before oven drying
-  Standard  
922-139 / 352-320 / air drying



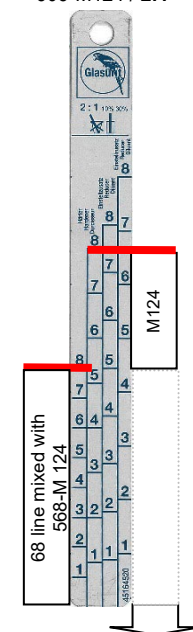
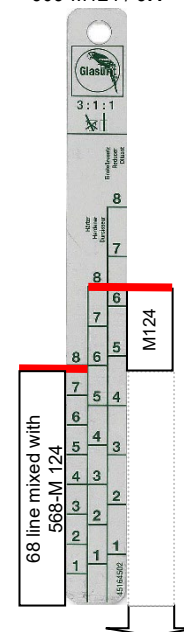
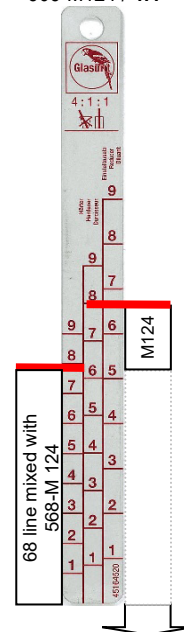
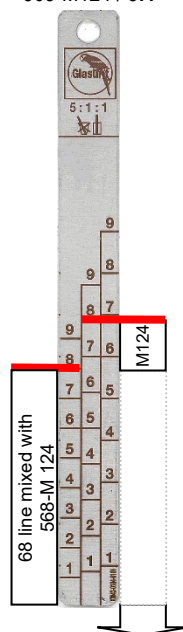
Gloss level	>85 E 60° < high gloss	75-85 E 60° < glossy	70-85 E 60° < glossy
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Replace mixing clear  
+ 568-M124 / 5:1

Replace mixing clear  
+ 568-M124 / 4:1




Replace mixing clear  
+ 568-M124 / 3:1

Replace mixing clear  
+ 568-M124 / 2:1



Gloss level	50-65 E 60° < semi glossy	35-50 E 60° < satin glossy	25-40 E 60° < satin matt	10-25 E 60° < matt
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### Important remarks

-  Before the usage of Glasurit® CV Matting Mixing Clear, 568-M 124 the product has to be stirred very well. That is also important if the mixing shelf was not in use for a longer time.
-  For the mixing clear 568-M 124 use agitator to stir in till homogeneously
-  Mixing ratio with hardener and reducer: **5 : 1 : 1**

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## Painting of Plastics

D 7

		284 - 45 2 : 1 +30% 922-180 PRO / 352-330	284 - 45 2 : 1 +30% 922-180 PRO / <b>568-20</b>
<b>SMC</b>	<b>Sheet molding compound</b>	●●	●●
<b>GRP</b>	<b>Glasfaser Reinforced Plastic</b>	●●	●●
<b>ABS</b>	<b>Acrylonitrile Butadiene Styren</b>	●●	●●
<b>ASA</b>	<b>Acrylonitrile Styrene Acrylate</b>	●●	●●
<b>PC</b>	<b>Polycarbonat</b>	●●	●●
<b>PC/ABS</b>	<b>PC/ABS Blend</b>	●●	●●
<b>PC/PBT</b>	<b>PC-Polybutylenterephthalat</b>	●●	●●
<b>PA</b>	<b>Polyamid</b>	●●	●●
<b>PS</b>	<b>Polystyrene</b>	-	-
<b>PP / EPDM</b>	<b>Polypropylen / Ethylen Propylen Dien Mixpolymerisat</b>		●
<b>PP / T16 / T20</b>			●
<b>TPE</b>	<b>Thermoplastic Elastomere</b>		●
<b>PP</b>	<b>Polypropylen</b>		○
<b>PE</b>	<b>Polyethylen</b>		○

●● = very well suited      ● = well suited      ○ = suited in some cases

**In Detail:** See Painting Process "Painting of Plastics"!

### **In general:**

Due to different raw material supplier the quality of the plastics can be different from time to time. Therefore, the adhesion should be checked before painting.

## Grey shades of different products with 568-408

D 8

	284-45	284-90	9-7	284-13	801-705	801-715	284-30
<b>L8 (RAL 9010)</b>							
MR ...: 568-408 by weight MR ...: 568-408 by volume	1000 : 0	1000 : 0					
<b>L7</b>							
MR ...: 568-408 by weight MR ...: 568-408 by volume	1000g : 0,8g 1000ml : 1,1ml	1000g : 0,7g 1000ml : 1,1ml					
<b>L6</b>							
MR ...: 568-408 by weight MR ...: 568-408 by volume	1000g : 1g 1000ml : 2ml	1000g : 1g 1000ml : 2ml					
<b>L5</b>							
MR ...: 568-408 by weight MR ...: 568-408 by volume	1000g : 3g 1000ml : 4ml	1000g : 3g 1000ml : 4ml		1000 : 0	1000 : 0		1000 : 0
<b>L4</b>							
MR ...: 568-408 by weight MR ...: 568-408 by volume	1000g : 7g 1000ml : 10ml	1000g : 7g 1000ml : 11ml		1000g : 4g 1000ml : 5ml	1000g : 2g 1000ml : 2,9ml	1000 : 0	1000g : 4g 1000ml : 6ml
<b>L3</b>							
MR ...: 568-408 by weight MR ...: 568-408 by volume	1000g : 14g 1000ml : 21ml	1000g : 13g 1000ml : 20ml	1000 : 0	1000g : 11g 1000ml : 15ml	1000g : 6,5g 1000ml : 9,4ml	1000g : 4g 1000ml : 5,8ml	1000g : 9g 1000ml : 16ml
<b>L2</b>							
MR ...: 568-408 by weight MR ...: 568-408 by volume	1000g : 32g 1000ml : 48ml	1000g : 32g 1000ml : 51ml	1000g : 36g 1000ml : 50ml	1000g : 36g 1000ml : 50ml	1000g : 19g 1000ml : 27,4mL	1000g : 16g 1000ml : 23,1ml	1000g : 24g 1000ml : 42ml
<b>~ L1</b>							
MR ...: 568-408 by weight MR ...: 568-408 by volume	1000g : 67g 1000ml : 100ml	1000g : 66g 1000ml : 100ml	1000g : 72g 1000ml : 100ml	1000g : 72g 1000ml : 100ml	1000g : 70g 1000ml : 100ml	1000g : 69g 1000ml : 100ml	1000g : 65g 1000ml : 100ml

The indicated colors are just reference points and are affected by the printer/screen setting. For colors with a mandatory gray shade as STEP #1, only the mixtures marked may be used.

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