

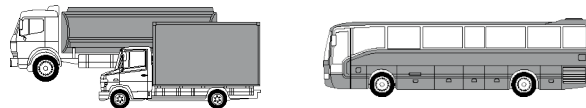


A brand of BASF –
We create chemistry

68-Line (568-M 135)

68- HS 2K CV Topcoat, glossy

Application:



all applications

Key Features:

- 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

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.

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-Paintwork	Old paint work
								●●					○	○



Spreading rate	536 m ² /l at 1 µm
Solid Content	~ 69 %

Safety advice:

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

The e 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.





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	Mixing Ratio	4 : 1 : 1 by volume
	Hardener	922-139, -138, -136
	Reducer	352-320, -330, -315
	Spray viscosity at 20°C	DIN 4: 18-22 s
	Potlife at 20°C	1.5 h

Application:		Compliant - gravity feed cup		HVLV spray gun		Suction cup		Airless/ Airmix		Pressure pot dbl.-pump
Application pressure	bar	2.2-2.5	2	2.5	2.5					
Material pressure	bar									0.8-1.5
Nozzle size		1.4	1.5	1.7						1-1.1
Number of coats		1.5	1.5	1.5						1.5
Flash off at 20°C	min	without	without	without						without
Film thickness	µm	40-60								

	Drying	Overcoatable		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

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Remark

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 of first coat. Pre-spray adhesion promoter 285-0 CV prior to multi-colour finishing if painted surface was baked or flashed off for 16 h. Airless or Airmix - Use 568-M 100 instead of 568-M 135.

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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