

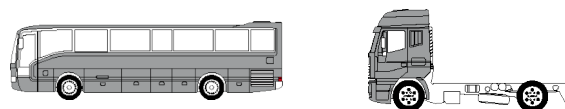
924-68

924-68 Variant with 568-409



A brand of BASF –
We create chemistry

Application:



busses, sign writing, metallic coating (line 90 CV PLUS), boxes, busses (repair), bus repair

Key Features:

- prevents micro foam during the airless application
- no influence on the surface characteristic

Remarks:

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

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
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Safety advice:

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.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at www.glasurit.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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	Pre Mix	100% 924-68 + 1-3% 568-409 by volume.
	Mixing Ratio	3 : 1 : 1 by volume
	Hardener	922-138, -136, -139
	Reducer	352-320, -330, -340
	Spray viscosity at 20°C	DIN 4: 18-22 s

Application:	Compliant - gravity feed cup	HVLP spray gun	Suction cup	Airless/ Airmix	Pressure pot dbl.-pump
Application pressure	bar			2	
Material pressure	bar			120-180	
Nozzle size				0.23-0.28	
Voltage	kV			50-80	
Elect. Resistance	Ω			700-1500	
Number of coats				1.5	
Flash off at 20°C	min			without	
Film thickness	µm			40-60	

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Drying

Overcoatable

Tack-free

Ready for masking

Ready to assemble

Sandable

Min. Max.

Object Temp. 20°C

16 h

2 h

16 h

12 h

16 h

Object Temp. 60°C

30 min

30 min

30 min

30 min

30 min

Remark

Pre-spray 1 light coat, then apply 1 wet coat for flow.
Recoatable with itself for up to 16 hours after application, after force drying and 16 hours at 20°C the
adhesion promoter 285-0 CV has to be sprayed first.

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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