



CV painting processes

CV painting processes

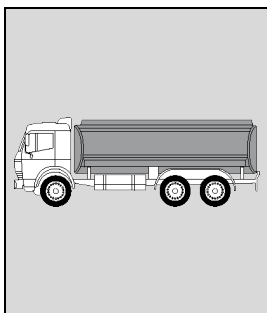
1. Which painting process for which vehicle?

CV 1	Aluminium vehicles, 2-layer wash
CV 1.1	Aluminium vehicles, 3-layer wet/ 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 4	Plastics painting
CV 5	Cab colour change (R68/ R90CV)
CV 6	Chassis colour change
CV 7	Powder-coated profiles
CV 8	Multi-colour painting (R68/ R90CV)
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

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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 : 352-216

} **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 : 352-216

} **4 : 1 : 1**

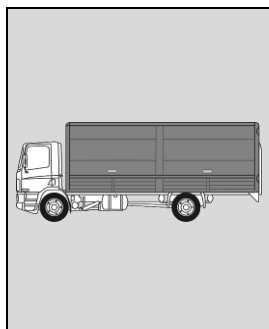
Equipment : Gravity-feed spraygun*
Spray coats : 1½
Film thickness: **40 - 60 µm**
Drying : overnight air drying
(16h at 20°C) or
30 min. at 60°C

* = See product data sheet for other equipment.

Safety instructions

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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** Equipment : Gravity-feed spraygun*
 Spray coats : 1½ – 2
 Film thickness: 15 - 20 µm
 Flash-off : at least 30 min. at 20°C
 Activator : 352-235 } **2 : 1 + 10-20%**
 Reducer : 352-216

Primer filler **284-90** 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
 Hardener: 922-180 PRO } **3 : 1 + 30%**
 Reducer : 352-216

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

Surfacer **284-45** 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
 Hardener: 922-180 PRO } **2:1+10-30%**
 Reducer : 352-345

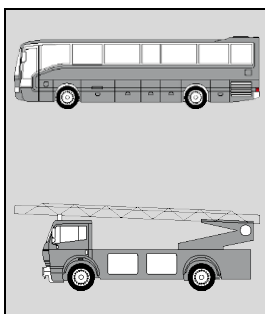
Topcoat **68-** Equipment : Gravity-feed spraygun*
 Spray coats : 1½
 Film thickness: 40 - 60 µm
 Drying : overnight air drying
 (16 h at 20°C) or
 30 min. at 60°C
 Hardener: 922-138 } **4 : 1 : 1**
 Reducer : 352-216

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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

Pre-treatment

Body filling

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

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

Primer

283-1870 } **2 : 1 + 10-20%**
Activator : 352-235
Reducer : 352-216
Equipment : Gravity-feed spraygun*
Spray coats : 1½ - 2
Film thickness: **15 - 20 µm**
Flash-off : at least 30 min. at 20°C
max. 8 h at 20°C

Sanding filler

284-30 } **4 : 1 : 1**
Hardener: 922-18 PRO
Reducer : 352-216
Equipment : Gravity-feed spraygun*
Spray coats : **2**
Film thickness: **70 - 90 µm**
Drying : 45 min. 60°C panel temp.
Sanding : dry with P400

(alternatively: sanding process with 284-45)

Surfacer

284-45 } **2:1+10-30%**
Hardener: 922-180 PRO
Reducer : 352-345
Equipment : Gravity-feed spraygun*
Spray coats : **1 ½ -2**
Film thickness: **min. 80 µm**
Drying : 45 min. 60°C panel temp.
Sanding : dry with P400

Note

Seal sand-throughs with 1 coat of 283-1870

Topcoat

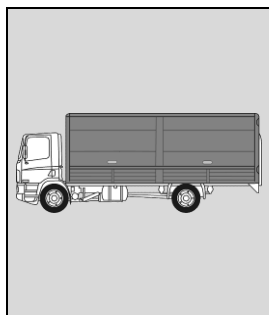
68- } **4 : 1 : 1**
Hardener: 922-138
Reducer : 352-216
Equipment : Gravity-feed spraygun*
Spray coats : **1½**
Film thickness: **40 - 60 µm**
Drying : overnight air drying
(16 h at 20°C) or
30 min. at 60°C

* = See product data sheet for other equipment.

Safety instructions

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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 : 352-216

} **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 : 352-216

} **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.

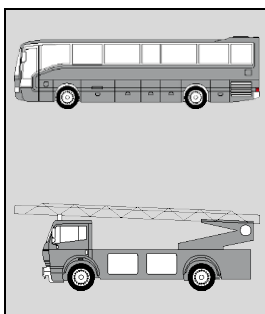
Note

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

Safety instructions

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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

Pre-treatment

Body filling

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

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

Primer filler

801-705

Hardener: 965-55
Reducer : 352-216

} **4 : 1 : 1**
} Mixing stick

Equipment : Gravity-feed spraygun*
Spray coats : **2**
Film thickness: **50 - 70 µm**
Drying : 30 min. at 60°C

Sanding filler

284-30

Hardener: 922-18 PRO
Reducer : 352-216

} **4 : 1 : 1**

Equipment : Gravity-feed spraygun*
Spray coats : **2**
Film thickness: **70 - 90 µm**
Drying : 45 min. 60°C panel temp.
Sanding : dry with P400

(alternatively: wet-on-wet process with 284-45 or 284-90)

Surfacer

284-45

Hardener:
922-180 PRO
Reducer : 352-345

} **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

Note

Seal sand-throughs with 1 coat of 801-705

Topcoat

68-

Hardener: 922-138
Reducer : 352-216

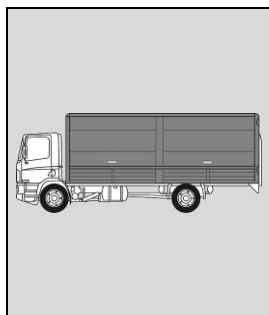
} **4 : 1 : 1**

Equipment : Gravity-feed spraygun*
Spray coats : **1 ½**
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

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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

Reducer : 568-720

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 : 352-216

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.

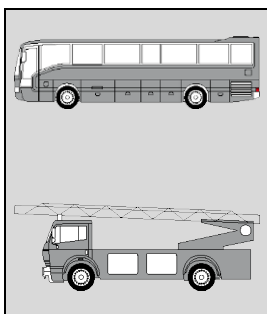
Note

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

Safety instructions

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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

Body filling

Cleaning - Sanding - Cleaning

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

Primer filler

801-715
 Hardener: 965-715 } **4 : 1 : 1**
 Reducer : 568-720 } Mixing stick

Equipment : Gravity-feed spraygun*
 Spray coats : **2**
 Film thickness: **50 - 70 µm**
 Drying : 30 min. at 60°C

Sanding filler

284-30
 Hardener: 922-18 PRO } **4 : 1 : 1**
 Reducer : 352-216 }

Equipment : Gravity-feed spraygun*
 Spray coats : **2**
 Film thickness: **70 - 90 µm**
 Drying : 45 min. 60°C panel temp.
 Sanding : dry with P400

(alternatively: wet-on-wet process with 284-45 or 284-90)

Surfacer

284-45
 Hardener: 922-180 PRO } **2:1+10-30%**
 Reducer : 352-345 }

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

Note

Seal sand-throughs with 1 coat of 801-715

Topcoat

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

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

* = See product data sheet for other equipment.

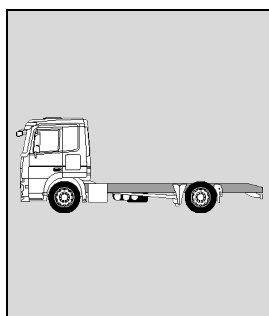
Note

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

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Chassis painting

CV 3

Application: Chassis painting
Substrates: Steel, aluminium

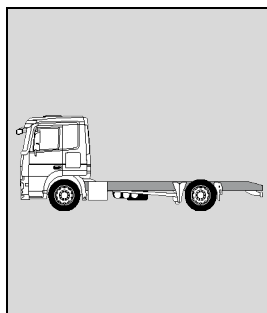
Pre-treatment	Abrasive blast-cleaning (See Technical Information Sheet A 4)		
Body filling	839-20 + 948-36;	100 : 3	Sanding with P80 / P150
Pre-prime aluminium chassis with	283-6150 Activator : 352-235 Reducer : 352-216	2 : 1 + 10%	Equipment : gravity-feed spraygun* Spray coats : 1½ Film thickness: 12 - 15 µm Flash-off : 20 -30 min. 20°C max 8 h at 20°C
Chassisurfacer	284-13 Hardener: 922-18 PRO Reducer : 352-216	4 : 1 : 1	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
Alternative:			
Primer Filler	284-90 Hardener: 922-180 PRO Reducer. : 352-216	3 : 1 + 30%	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
Alternative:			
Primer filler	9-7 Additive : 568-96	4 : 1	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
Topcoat	68- Hardener: 922-138 Reducer : 352-216	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

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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

Hardener: 922-138

Reducer: 352-216

7 : 1 +
10-15%

Equipment : gravity-feed spraygun*

Spray coats : **2 wet-on-wet**

Film thickness: **70 - 100 µm**

Flash-off : overnight air drying or
30 min. at 60°C
panel temp.

2-layer-system

Chassisfiller

568-46

Top coat: 68-

70:30

Hardener: 922-138

Reducer: 352-216

7 : 1 +
15-25%

Equipment : gravity-feed spraygun*

Spray coats : **2 wet-on-wet**

Film thickness: **60 - 70 µm**

Flash-off : 60 min. at 20°C or
30 min. at 60°C
panel temp.

Topcoat

68-

Hardener: 922-138

Reducer : 352-216

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

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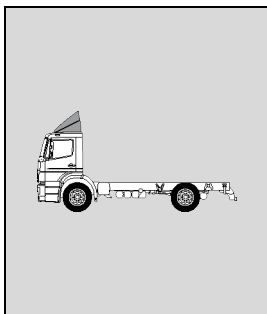
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Plastics painting **

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 : 352-216

} **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 : 352-216

} **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.

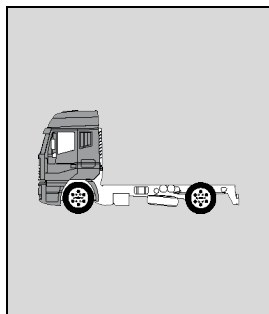
Remark

**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

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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 : 352-216

} **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 : 352-216

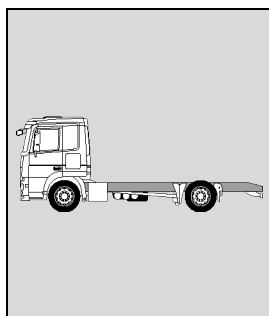
} **4 : 1 : 1**

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.
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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** Equipment : gravity-feed spraygun*
 Hardener: 922-18 PRO Spray coats : 1
 Reducer : 352-216 } **2 : 1 + 30%** 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 Equipment : gravity-feed spraygun*
 Reducer : 568-96 } **4 : 1** Spray coats : 1
 Film thickness: **20 - 30 µm**
 Flash-off : at least 60 min. at 20°C or
 30 min. at 60°C

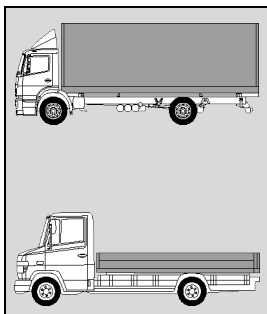
Topcoat **68-** Equipment : gravity-feed spraygun*
 Hardener: 922-138 } **4 : 1 : 1** Spray coats : 1½
 Reducer : 352-216 Film thickness: **40 - 60 µm**
 Drying : overnight air drying
 (16 h at 20°C) or
 30 min. at 60°C

* = See product data sheet for other equipment.

Safety instructions

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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 : 352-216

} **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 : 352-216

} **4 : 1 : 1**

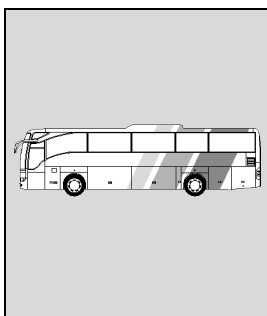
Equipment : gravity-feed spraygun *
Spray coats : 1½
Film thickness: **40 - 60 µm**
Drying : overnight air drying (16h at 20°C) or 30 min. at 60°C

* = See product data sheet for other equipment.

Safety instructions

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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 : 352-50

} **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**

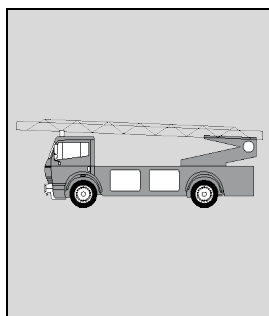
Equipment : gravity-feed spraygun *
Spray coats : **1½ - 2**
Film thickness: **40 - 60 µm**
Tape resistant: after 2 h at 20°C
Potlife max. 30 min.

****after 16h air drying use adhesion promoter 285-0 CV!**

* = See product data sheet for other equipment.

Safety instructions

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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	} 2 : 1 +10-30%	Equipment : gravity-feed spray gun *
Hardener: 922-180PRO		Spray coats : 1 ½
Reducer : 352-345		Film thickness: 50 - 70 µm
		Drying : 30 min. 60°C panel temp. or 1 h 20°C

Alternative to 284-45:

Primer Filler

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

Daylight Colours

923-	} 4 : 1 + 10%	Equipment : gravity-feed spray gun*
Hardener: 929-93		Spraycoats : 4 – 5
Reducer. : 352-216		Film thickness: min. 100 µm
		Flash off** : min. 60 Min. 60°C or drying over night at 20°C

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

Protective Clear ***

923-49	} 2 : 1 + 10%	Equipment : gravity-feed spraygun*
Hardener: 929-93		Spraycoats : 2
Reducer. : 352-216		Film thickness: 50 - 70 µm
		Drying : 60 min. at 60°C or 10 h at 20°C

* = See product data sheet for other equipment.

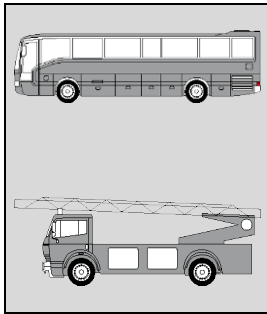
** = If masking is not required, fluorescent paint may be sprayed without prior sanding after 1 hour already. For dry sanding with an Orbital sander use sanding paper P400.
 → Sand-throughs must be blended in by means of **284-90 or 284-45**.

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

Safety instructions

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Glasurit[®], 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 : 352-216

} **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 : 352-216

} **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 : 352-50

} **100 : 5**
additional 352-50
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

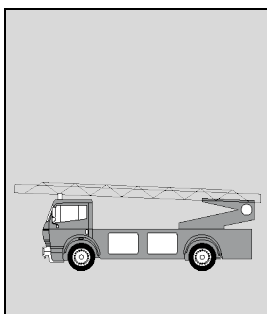
Safety instructions

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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 : 352-216 } **2 : 1 + 10%**

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

Primer filler

284-90

Hardener: 922-180 PRO
Reducer : 352-216 } **3 : 1 +30%**

Equipment : Gravity-feed spraygun*
Spray coats : **2**
Film thickness: **50 - 70µm**
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 : 352-216 } **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

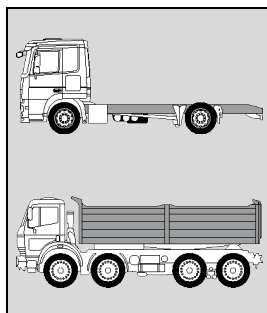
Remarks:

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

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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 : 352-50**

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 : 352-50**

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.

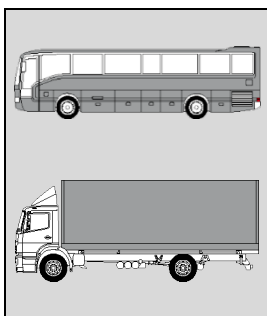
**= Depending on size, object and ambient temperature

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.
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- 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	} 3 : 1 + 30%	Equipment : gravity-feed spraygun*
	hardener: 922-180PRO Reducer : 352-91 CV		Spray coats : 1½ Film thickness: 50 - 60 µm Flash-off : at least 60 min. at 20°C

Topcoat	68-	} 4 : 1 : 1	Equipment : gravity-feed spraygun*
	hardener : 922-136 reducer : 568-17 Potlife max 30 min.		Spray coats : 1½ Film thickness: 40 - 60 µm Drying : air drying

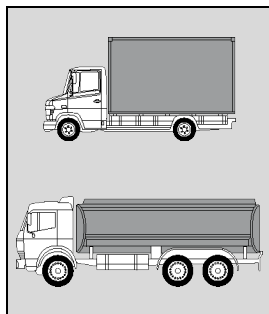
* = See product data sheet for other equipment

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

Safety instructions

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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	} 2 : 1 + 10-20%	Equipment : gravity feed spraygun*
	Activator: 352-228**		Spray coats : 2 – 2½
	Reducer: 352-216		Film thickness: 20 - 25 µm
			Flash-off : at least 15 min. at 20°C max. 8 h at 20°C

Topcoat	68-	} 4 : 1 : 1	Equipment : gravity feed spraygun*
	hardener : 922-136		Spray coats : 1½
	reducer : 568-17		Film thickness: 40 - 60 µm
	Potlife max 30 min.		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	<ul style="list-style-type: none"> • It cannot be ruled out that this product contains particles < 0.1 µm. • The products are suitable for professional use only. • For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.
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