



Busses, fire fighting trucks CV 3

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

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

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

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| Primer | 283-1870 Activator : 352-235 Reducer : 352-216 | $2 : 1 + 10-20\%$ | Equipment : Gravity-feed spraygun* Spray coats : 1½ – 2 Film thickness: 15 - 20 µm Flash-off : at least 30 min. at 20°C max. 8 h at 20°C |
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| 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 |
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(alternatively: wet-on-wet process with 284-45 or 284-90)

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| 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 |
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| Note | Seal sand-throughs with 1 coat of 283-1870 |
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| 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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* = See product data sheet for other equipment.

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| 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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