



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	} 2 : 1 + 10%	Equipment : gravity-feed spraygun*
	Activator : 352-228 Reducer : 352-50**		Spray coats : 1½ Film thickness: 12 - 15 µm Flash-off : at least 20 min. at 20°C max 8 h at 20°C

Sanding filler	284-30	} 4 : 1 : 0.5:0.5	Equipment : gravity-feed spraygun*
	Hardener: 922-18 PRO Additive : 568-17 Reducer : 352-50**		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	} 2:1+5%+5%	Equipment : gravity-feed spraygun*
	hardener : 922-180 PRO Additive : 568-17 Reducer : 352-50**		Spray coats : 2 Film thickness: 50 - 70 µm Drying : 30 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.

**= Depending on size, object and ambient temperature

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

<u>Safety instructions</u>	<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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