



# **Glasurit Commercial Vehicles**

## **Paint Systems For CV Finishing**

**< Compact Version >**

**According to EU Decopaint Directive  
2004/42/IIIB**

**04/2025**



# TECHNICAL INFORMATION

## A 1 Product List

<b>Cleaning agents</b>		
541-68	Glasurit CV Wax and Silicone Remover	SV20-0368
360-68	Glasurit CV Metal Cleaner	SV22-0368
P-P-41	Glasurit Plastic Cleaner	
P-P-31	Glasurit Waterborne Cleaner, base-/topcoat	
P-P-26	Glasurit Waterborne multi cleaner	

<b>Body fillers</b>		
839-15	Glasurit CV Flexible Body Filler, grey beige	SP69-7015
839-5	Glasurit CV Universal Body Filler, white	SP69-0005
839-7451	Glasurit CV Body Filler extra slow, light grey	SP69-745Z
839-180	Glasurit HS Polyester Spray Filler	SP60-7018

<b>Undercoat materials</b>		
9-7	Glasurit CV Steel Primer, grey beige	AB09-7777
183-153	Glasurit Shop Primer, red brown,	AB83-8198
283-1870	Glasurit CV-Multi-Wash, beige	AB83-1870
284-13	Glasurit 2K CV Chassis Surfacer, beige grey	AB84-7135
284-55	Glasurit 2K CV UHS Primer Filler, white	AB84-0U48
284-45	Glasurit CV Filler, white	AC84-0045
284-58E	Eco Balance CV universal primer filler, white	AC84-058E
284-60	Glasurit CV universal primer filler, grey	AC84-0060
284-90	Glasurit CV Primer Filler white	AB84-0090
284-99	Glasurit CV Texture Filler, tintable	AC84-0502
284-10	Glasurit Transparent Sealer CV	AC84-0010
801-715	Glasurit CV-HS Primer Filler EP, grey	AC01-7815

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<b>68 Line PLUS</b>		
568-M 80	Basic Mixing Clear	AZ68-0080
568-M 90	High Build Mixing Clear	AZ68-0090
568-M 100	Efficient Airless Mixing Clear	AZ68-0100
568-M 135	Efficient Mixing Clear	AZ68-1350
568-M 200	Supreme Mixing Clear	AZ68-0200
568-M 124	Matting Mixing Clear	AZ68-0124
68- + 568-M 124 CV	Glasurit HS 2K CV Topcoat + CV Mixing Clear M124 Matt Mixing Clear	AD68-/AZ68-0124
68-RAL 9006	Glasurit HS 2K CV Topcoat, direct-gloss, metallic, white aluminum	AE68-9006
58-	Glasurit HS 2K CV Chassis Paint, satin gloss MB 7350 nova grey, MB 9124 chassis black, MAN 9011 black, 58-1250-M rally black (matt)	AD58-

<b>Daylight Colours</b>		
923-RAL 1026-T 923-RAL 2005-T 923-RAL 3024-T	Glasurit Daylight Fluorescent Paint, luminous yellow, orange, luminous red	AD23-1026 AD23-2005 AD23-3024

<b>Metallic / solid colour basecoats</b>		
90 CV PLUS	Glasurit Basecoat, Metallics / Solids mixed from mixing system	AH/AJ90-
93-E 3 CV PLUS	Glasurit Adjusting Base	AZ93-0602
90-M 4 CV PLUS	Glasurit Waterborne Mixing Base	AK50-0602
90-M+A	Glasurit mixing base concentrates for the mixing system	
90-VE	Glasurit Deionised Water	AZ90-0101

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<b>Clearcoat</b>		
924-50	Glasurit HS 2K CV clear coat extreme mat	AF23-0050
924-68	Glasurit HS 2K CV clear coat	AF24-0068
924-268	Glasurit CV performance clear coat	AF24-0268

<b>Stone chip and underbody protection</b>		
1109-1240/4	Glasurit Stone Chip and Underbody Protection, black	FT90-9400

<b>Hardeners for body fillers</b>		
G-H-115	Glasurit Hardener for Glasurit 839-180 Polyester Spray Filler	SB48-115A
G-H-110	Glasurit Body Filler Hardener	SB48-110A

<b>Hardeners for undercoats, epoxy primer fillers and etch primers</b>		
352-235	Glasurit Activator, slow	SC12-0235
965-715	Glasurit CV EP Hardener for CV EP Primer Filler 801-715	SC65-0715

<b>2K PU acrylic hardeners for undercoats and topcoats</b>		
922-16 PRO	Glasurit 2K CV Hardener, fast	SC22-0116
922-18 PRO	Glasurit 2K CV Hardener, normal	SC22-0118
922-180 PRO	Glasurit 2K CV Filler Hardener	SC22-0180
922-220 PRO	Glasurit 2K CV Undercoat Hardener	SC22-0220
922-55 PRO	Glasurit 2K CV Primer Filler Hardener UHS	SC22-0U03
922-136	Glasurit 2K CV Topcoat Hardener, fast	SC22-0136
922-138	Glasurit 2K CV Topcoat Hardener, normal	SC22-0138
922-139	Glasurit 2K CV Topcoat Hardener, slow	SC22-0139
922-815	Glasurit 2K CV Basic Topcoat Hardener for M80, standard	SC22-0815
922-825	Glasurit 2K CV Basic Topcoat Hardener for M80, slow	SC22-0825

<b>2K-Hardeners for daylight colours and protective clears</b>		
929-91	Glasurit 2K HS Topcoat Hardener, fast	SC29-0091
929-93	Glasurit 2K HS Topcoat Hardener, normal	SC29-0093
929-94	Glasurit 2K HS Topcoat Hardener, slow	SC29-0094

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<b>Additives</b>		
568-17	Glasurit CV Multi-Colour Additive	AZ68-0012
568-20	Glasurit HAFLEX (Plastic Adhesion Promoter)	AZ68-0020
568-46	Glasurit Steel Primer Paste	AZ68-0046
568-96	Glasurit Express Reducer	AZ68-0906
568-405	Glasurit CV Texture Additive	AZ68-0405
568-407	Glasurit CV Brush and Roll Additive	AZ68-0407
568-408	Glasurit CV Primer Tinting Paste	AZ68-0408
568-409	Glasurit CV Airless Additive	AZ68-0409
568-412	Glasurit CV Thix Additive	AZ68-0412
568-720	Glasurit CV protective additive EP normal	AZ68-0720
568-745	Glasurit CV protective additive EP slow	AZ68-0745
A-P-50	Glasurit Activation wipes	AZ76-050A
P-A-912	Glasurit Flex Additive	AZ22-091P

<b>Reducers and thinners</b>		
352-310	Glasurit Reducer, extra fast	SV41-1310
352-315	Glasurit Reducer, fast	SV41-1315
352-320	Glasurit Reducer, medium	SV41-1320
352-330	Glasurit Reducer, slow	SV41-0333
352-340	Glasurit Reducer, extra slow	SV41-0344
P-A-930	Glasurit Blending additive	SV99-093P

### Safety advice:

The products are suitable for professional use only.

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

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.

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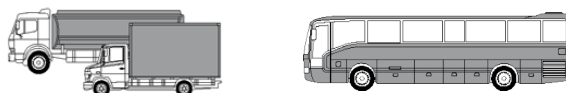
# 839-5

Glasurit CV universal body filler, white



A brand of BASF –  
We create chemistry

**Application:**



all applications

**Key Features:**

- fast drying
- suitable on all substrates
- good filling properties
- fast sandable

**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
●●	●●	○	●●		●			●	●	●	●	●	●	●

**Solid Content** ~ 96 %

**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 (b)(250)180:** The EU limit value for this product (product category: IIB.b) in ready to use form is max. 250 g/l. The VOC content of this product is 180 g/l.

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# 839-5

Glasurit CV universal body filler, white



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**Mixing Ratio** 100 : 2 - 3 % by weight



**Hardener** G-H-110

**Potlife at 20°C** 4 min



Drying	Overcoatable	Tack-free	Ready for masking	Ready to assemble	Sandable
	Min.	Max.			
<b>Object Temp. 20°C</b>					20-30 min

**Remark**

Can be sanded after 20 - 30 min.  
Not suitable for applications that require elasticity, e.g., welding seams.  
Do not use on acid-hardening products or substrates pre-treated with acid.

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.

**Safety advice:**

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

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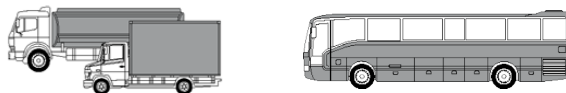


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# 839-15

CV Flexible Body Filler, grey beige

**Application:**



all applications

**Key Features:**

- fast sandable
- good filling properties
- high flexible alignment for welding seams

**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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**Solid Content** ~ 99 %



**Mixing Ratio** 100 : 2-3% by weight



**Hardener** G-H-110

**Potlife at 20°C** 4 min

**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 (b)(250)219:** The EU limit value for this product (product category: IIB.b) in ready to use form is max. 250 g/l. The VOC content of this product is 219 g/l.

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# 839-15

CV Flexible Body Filler, grey beige



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**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

Min.      Max.

**Object Temp. 20°C**

30 min

**Remark**

Can be sanded after 30 min.  
Highly flexible product, for example for weld seams on tankers.  
On zinc, before body-filling, see variant with EP 801-715 CV Primer Filler or variant with 284-13 CV primer filler.  
Do not use on wash primer or acid-pre-treated surfaces!

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.

**Safety advice:**

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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# 839-7451

Glasurit CV body filler extra slow, light grey



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- Application:** all applications
- Key Features:**
- to be used for large surfaces
  - high flexible alignment for welding seams
  - long potlife
  - suitable for high temperatures
- Remarks:** The substrate should be clean, free of dust, rust, oil and grease.

## Handling

### Substrates:

Very well suited:

- Steel
- Aluminium
- Wood



Well suited:

- GRP / SMC
- Glasurit CV Primer Filler / Filler
- Powder coatings
- Coil-coatings
- Plywood
- OEM-Paintwork
- Old paint work



Solid content RFU 98 %  
Potlife at 20°C: 35 - 40 min

## 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 (b)(250)180:** The EU limit value for this product (product category: IIB.b) in ready to use form is max. 250 g/l. The VOC content of this product is 180 g/l.



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# 839-7451

Glasurit CV body filler extra slow, light grey



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		100:3 % by weight	
	<b>Mixing Ratio</b>	100 % by weight	839-7451
	<b>Hardener</b>	3 % by weight	G-H-110

**Drying Remark**

**Sandable**  
20°C 3 - 4 h

**Remark**

Suitable for large surfaces. Sanding after 3-4h drying.  
On galvanized steel: before 839-7451 can be applied it is required to pre-prime the substrate with either Glasurit EP 801-715 (30 - 40 µm, 45 min 60°C) or CV Primer Filler 284-13 (20 - 25 µm, 20 min 60°C). Do not use on acid-hardening products or substrates pre-treated with acid.

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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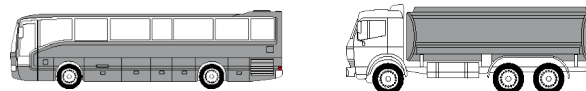


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# 839-180

Glasurit CV spray body filler, grey

**Application:**



all applications

**Key Features:**

- good filling properties
- fast drying
- fast sandable

**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	●●	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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**Spreading rate** 551 m<sup>2</sup>/l at 1 µm

**Solid Content** ~72 % (RFU~73%)

**Safety advice:**

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# 839-180


Glasurit CV spray body filler, grey



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	<b>Mixing Ratio</b>	100 : 5 % by volume + max. 2% by weight
	<b>Hardener</b>	G-H-115
	<b>Reducer</b>	352-310
	<b>Potlife at 20°C</b>	30 min

<b>Application:</b>		<b>Compliant - gravity feed cup</b>		<b>HVLV spray gun</b>		<b>Suction cup</b>		<b>Airless/ Airmix</b>		<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	<b>bar</b>	2.2-2.5		2.5						
<b>Nozzle size</b>		2.5-3		2.5-3						
<b>Number of coats</b>		3-8		3-8						
<b>Film thickness</b>	<b>µm</b>	>200 max. 1000								

	<b>Drying</b>	<b>Overcoatable</b>	<b>Tack-free</b>	<b>Ready for masking</b>	<b>Ready to assemble</b>	<b>Sandable</b>
		Min.	Max.			
	<b>Object Temp. 20°C</b>	3 h	4 h			3-4 h
	<b>Object Temp. 60°C</b>	30 min				30 min

**Remark** Do not overcoat etch wash primer or acid pre treated substrates with 839-180!  
Use only dry sanding for 839-180. Galvanized steel must be primed with 283-1870 and 284-13 (max. 30 - 40 µm). For temperature less than 15°C or to speed up the drying the amount of G-H-115 can be increased up to 7.5 vol.%.

**Safety advice:**

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Glasurit CV spray body filler, grey



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**2004/42/IIIB (b)(250)249:** The EU limit value for this product (product category: IIB.b) in ready to use form is max. 250 g/l. The VOC content of this product is 249 g/l.

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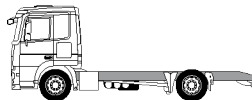


A brand of BASF –  
We create chemistry

# 1109-1240/4

Underbody protection, black

**Application:**



structure effect, underbody protection

**Key Features:**

- can be used on all Glasurit PU and EP CV primer fillers and fillers
- high flexible
- outstanding application characteristics

**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
								●●					●●	●●



**Spreading rate** 379 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 55 %

**Handling**



Protect from frost.

**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 (e)(840)32:** The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/l. The VOC content of this product is 32 g/l.






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A brand of BASF –  
We create chemistry

# 1109-1240/4

Underbody protection, black

Application:	 Compliant - gravity feed cup	 HVLP spray gun	 Suction cup	 Airless/ Airmix	 Pressure pot dbl.-pump
<b>Application pressure</b>	<b>bar</b>	2-2.5	2-2.5	2-4	2.5
<b>Nozzle pressure</b>	<b>bar</b>			120-180	2
<b>Nozzle size</b>		3-4	3-5	0.41-0.5	3-4
<b>Number of coats</b>		2-6	4-6	2-6	2-6
<b>Film thickness</b>	<b>µm</b>	500 - 1000			

 <b>Drying</b>	<b>Overcoatable</b>	<b>Tack-free</b>	<b>Ready for masking</b>	<b>Ready to assemble</b>	<b>Sandable</b>
<b>Object Temp. 20°C</b>	Min. Max.				
	6 h				

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.

**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 (e)(840)32:** The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/l. The VOC content of this product is 32 g/l.

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A brand of BASF –  
We create chemistry

# 183-153

CV Shop Primer, red-brown

**Application:**



construction machinery (steel), container

**Key Features:**

- fast to assemble
- fast drying
- weldable
- temporary corrosion protection

**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
●●	●●												●	●



**Spreading rate** 206 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 38 % (RFU~31%)

**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 (c III)(780)714:** The EU limit value for this product (product category: IIB.c III) in ready to use form is max. 780 g/l. The VOC content of this product is 714 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](http://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.

# 183-153

CV Shop Primer, red-brown



A brand of BASF –  
We create chemistry



**Mixing Ratio** 4 : 1 by volume



**Reducer** 352-310, -315



**Spray viscosity at 20°C** DIN 4: 22-25 s

Application:		Compliant - gravity feed cup	HVLV spray gun	Suction cup	Airless/ Airmix	Pressure pot dbl.-pump
<b>Application pressure</b>	bar	2.5	2	2.5		2.5
<b>Nozzle pressure</b>	bar					0.8-1.5
<b>Nozzle size</b>		1.6-1.8	1.7	1.7		1-1.1
<b>Number of coats</b>		2	2	2		1-2
<b>Flash off at 20°C</b>	min	10-15	10-15	10-15		10-15
<b>Film thickness</b>	µm	20-25				



Drying	Overcoatable	Tack-free	Ready for masking	Ready to assemble	Sandable
	Min. Max.				
<b>Object Temp. 20°C</b>	10 min 8 h				

**Remark**

The product is ready for application with a brush.  
 Shop Primer cannot be directly over coated with topcoat or polyester products.  
 All CV PUR Primer Filler / Filler can be used to overcoat.  
 Panels treated with 183-153 are very easy to weld.  
 The adhesion on hot dipped galvanized steel has to be checked before.

**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 (c III)(780)714:** The EU limit value for this product (product category: IIB.c III) in ready to use form is max. 780 g/l. The VOC content of this product is 714 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](http://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.  
 BASF Coatings GmbH - Automotive Refinish Coatings Solutions Europe - Glasuritstrasse 1 - 48165 Münster - Germany

# 183-153

CV Shop Primer, red-brown



A brand of BASF –  
We create chemistry

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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**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/II B (c III)(780)714:** The EU limit value for this product (product category: IIB.c III) in ready to use form is max. 780 g/l. The VOC content of this product is 714 g/l.

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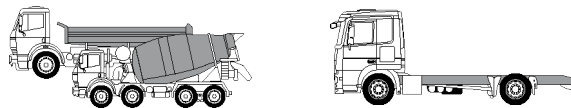
# 9-7

## CV steel primer, grey-beige



A brand of BASF –  
We create chemistry

**Application:**



construction machinery (steel), chassis painting (steel / aluminum), steel and galvanized steel spare parts

**Key Features:**

- tintable
- very good corrosion protection
- good coverage of shot blasted profile
- high efficiency
- outstanding application characteristics

**Remarks:**

Aluminum-Chassis have to be primed with a suitable primer.  
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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**Spreading rate** 440 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 72 % (RFU ~ 64%)

**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 (c I)(540)504:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 504 g/l.

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# 9-7

## CV steel primer, grey-beige



A brand of BASF –  
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**Mixing Ratio**

4 : 1 by volume



**Reducer**

568-96



**Spray viscosity at 20°C**

DIN 4: 18-20 s

Application:		Compliant - gravity feed cup	HVLV spray gun	Suction cup	Airless/ Airmix	Pressure pot dbl.-pump
<b>Application pressure</b>	<b>bar</b>	2.2-2.5	2	2.5	2	2.5
<b>Nozzle pressure</b>	<b>bar</b>				120-150	0.8-1.5
<b>Nozzle size</b>		1.6-1.8	1.7	1.7	0.28-0.33	1-1.1
<b>Voltage</b>	<b>kV</b>				50-80	
<b>Elect. Resistance</b>	<b>Ω</b>				1500-2000	
<b>Number of coats</b>		2	2	2	1-2	1.5-2
<b>Flash off at 20°C</b>	<b>min</b>	without	without	without	without	without
<b>Film thickness</b>	<b>µm</b>	50-60				



**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

	Min.	Max.				
<b>Object Temp. 20°C</b>	1 h	72 h	1 h	16 h	16 h	16 h
<b>Object Temp. 60°C</b>	30 min		30 min	30 min	30 min	45 min

**Remark**

For tinting see 9-7 Variant with 568-408. When repainting old paint work, depending on the condition of the substrate, apply 1 spray coat 20 - 30 µm.

**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 (c I)(540)504:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 504 g/l.

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# 9-7

CV steel primer, grey-beige



A brand of BASF –  
We create chemistry

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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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**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 (c I)(540)504:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 504 g/l.

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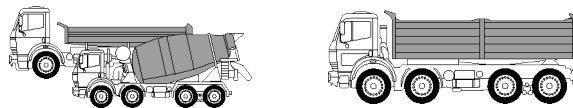


A brand of BASF –  
We create chemistry

# 568-46

## CV Steel Primer Paste, 2-layer system

### Application:



construction machinery (steel), chassis painting, chassis (color change), container, steel and galvanized steel spare parts

### Key Features:

- suitable for large areas / surfaces
- can be applied directly on steel or galvanized steel
- tintable
- good coverage of shot blasted profile
- brilliant top coat appearance
- improves the hiding power

### Remarks:

Aluminum-Chassis have to be primed with a suitable primer.  
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
●●	●●	●			●		●		●	●			●	●



**Spreading rate** 540 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 80 %

### 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 (c II)(540)530:** The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. The VOC content of this product is 530 g/l.

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# 568-46

CV Steel Primer Paste, 2-layer system



A brand of BASF –  
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	<b>Pre Mix</b>	568-46 with 68 Line PLUS mix 568-46 (70 parts) with 68 Line PLUS (30 Parts)
	<b>Mixing Ratio</b>	7 : 1 + 15 - 25% Vol. (if mixed with Efficient, High Build or Supreme) 3:1 Vol. with 922-815 or -825 (if mixed with Basic topcoat)
	<b>Hardener</b>	922-138, -136, -139
	<b>Reducer</b>	352-315, -320, -330
	<b>Spray viscosity at 20°C</b>	DIN 4: 25-35 s
	<b>Potlife at 20°C</b>	1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Nozzle pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.6-1.8	1.7-1.9	1.7-1.9	0.28-0.33	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	2	2	2	1-2	2
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min	10-15 min	10-15 min
<b>Film thickness</b>	60-70 µm				

**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 (c II)(540)530:** The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. The VOC content of this product is 530 g/l.

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# 568-46

CV Steel Primer Paste, 2-layer system



A brand of BASF –  
We create chemistry



**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

	Min.	Max.			
<b>Object Temp. 20°C</b>	60 min	72 h			16 h
<b>Object Temp. 60°C</b>	30 min				30 min

**Remark**

Shelf life of the mixed product (68 Line PLUS with 568-46) is only 2 weeks.  
Corrosion protection can only be achieved, if the required film thickness is applied (covering of sand blasting roughness, edges).  
568-46 must not be adjusted with 568-17 as it impacts technical performance.  
The adhesion on hot dipped galvanized steel has to be checked before.

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.

**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 (c II)(540)530:** The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. The VOC content of this product is 530 g/l.

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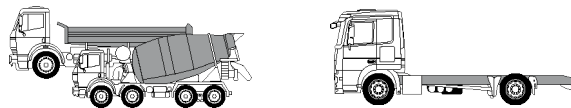
# 284-13

2K CV Chassis Filler, beige-grey



A brand of BASF –  
We create chemistry

**Application:**



chassis painting, container, construction machinery (steel), steel and galvanized steel spare parts

**Key Features:**

- suitable on all Glasurit CV primer
- suitable for large areas / surfaces
- very good corrosion protection
- good coverage of shot blasted profile
- brilliant top coat appearance
- outstanding application characteristics
- tintable

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
Aluminum-Chassis have to be primed with a suitable primer.

**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** 435 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 73 % (RFU~61%)

**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 (c I)(540)508:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 508 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](http://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.

# 284-13

2K CV Chassis Filler, beige-grey



A brand of BASF –  
We create chemistry



**Mixing Ratio** 4 : 1 : 1 by volume



**Hardener** 922-18 Pro, -16 Pro



**Reducer** 352-320, -330, -340



**Spray viscosity at 20°C** DIN 4: 25 s

**Potlife at 20°C** 2 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Nozzle pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.6-1.8	1.5-1.7	1.5-1.7	0.28-0.33	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				300-500 Ω	
<b>Number of coats</b>	2	2	2	1-2	2
<b>Flash off at 20°C</b>	without	without	without	without	without
<b>Film thickness</b>	60-70 µm				

**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 (c I)(540)508:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 508 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](http://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.

# 284-13

2K CV Chassis Filler, beige-grey



A brand of BASF –  
We create chemistry



Drying	Overcoatable		Tack-free	Ready for masking	Ready to assemble	Sandable
	Min.	Max.				
Object Temp. 20°C	60 min	72 h	2 h	16 h	16 h	16 h
Object Temp. 60°C	30 min		30 min	30 min	30 min	45 min

**Remark**

Can be tinted with up to 10% of 68 Line PLUS topcoat for the 2nd spray coat.  
 To plasticize the product, mix it 4 : 1 by volume with P-A-912 Flex Additive before adding hardener.  
 Can be overcoated with CV topcoats of 68 Line PLUS, 58, 55\*  
 For tinting see variant with CV Primer Tininting Paste 568-408.  
 Mixing ratio 5:1:1 by vol. = higher viscosity, e. g. for rough-blasted substrates.  
 On hot-dip galvanized steel, adhesion must be tested beforehand.  
 \* Has to be applied within 72h with 68 Line PLUS, within one working day with 55 line.  
 UP spray filler apply 1 full coat ~30-40 µm.

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.

**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 (c I)(540)508:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 508 g/l.

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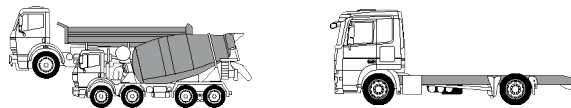
# 284-55

CV UHS Primer Filler PUR, white



A brand of BASF –  
We create chemistry

**Application:**



Vehicle manufacturing, chassis, transportation

**Key Features:**

- ultra High Solid 2K Primer Filler
- fast over coating
- white
- very good corrosion protection
- for usage on large or small areas
- over coating with topcoat 68 Line PLUS

**Remarks:**

Steel: shot blasting acc standard grade of cleanliness SA 2 ½. The substrate should be clean, free of dust, rust, mill scale, old paintwork, 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
----	-------	------------------	-----------------	---	-----------	--	--------------------	--	-----------	--	---------	--	----------------------	--	--------------------------------------	--	----------------	--	--------------	--	---------	--	------	--	---------------	--	----------------



**Spreading rate** 600 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 78 %

**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 (c II)(540)331:** The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. The VOC content of this product is 331 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](http://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.

# 284-55

CV UHS Primer Filler PUR, white



A brand of BASF –  
We create chemistry

## Handling



Minimum ambient temperature during application: +15°C, +3°C above dew-point temperature. Application with 2K mixing system recommended.



After adding hardener mix and stir intensely with an agitator.



**Mixing Ratio** 3 : 1 by volume



**Hardener** 922-55 PRO



**Spray viscosity at 20°C** DIN 4: 23-28 s

**Potlife at 20°C** 1 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar			3-4 bar	3-4 bar
<b>Material pressure</b>				150-200 bar	0.8-1.2 bar
<b>Nozzle size</b>	1.4-1.6			0.28	1.2-1.5
<b>Number of coats</b>	1.5-2			1.5-2	1.5-2
<b>Flash off at 20°C</b>	10-15 min			10-15 min	10-15 min
<b>Film thickness</b>	60-70 µm				

## Safety advice:

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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# 284-55

CV UHS Primer Filler PUR, white



A brand of BASF –  
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**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

	Min.	Max.
<b>Object Temp. 20°C</b>	1 h	72 h
<b>Object Temp. 60°C</b>	30 min	

60 min

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.

**Safety advice:**

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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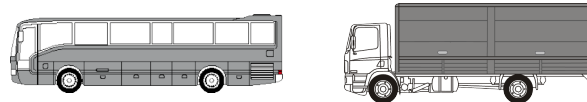
# 283-1870

CV-Multi-Wash 2 layer, beige



A brand of BASF –  
We create chemistry

**Application:**



busses, fire-fighting vehicle, boxes (aluminum), boxes, bulk loading vehicles (aluminum)

**Key Features:**

- good levelling and flow
- suitable for large surfaces
- quick drying
- excellent corrosion protection
- tintable with max. 3% 568-408
- 2-layer system with topcoat 68 Line PLUS

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
The pre-treated metallic surface must be coated on the same day to prevent renewed oxidation.

**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** 190 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 34 % (RFU~24%)

**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 (c III)(780)729:** The EU limit value for this product (product category: IIB.c III) in ready to use form is max. 780 g/l. The VOC content of this product is 729 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](http://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.

# 283-1870

CV-Multi-Wash 2 layer, beige



A brand of BASF –  
We create chemistry



**Mixing Ratio** 4:1:1 Vol.



**Hardener** 352-235, P-H-120



**Reducer** 352-320, -330



**Spray viscosity at 20°C** DIN 4: 22-24 s

**Potlife at 20°C** 8 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLV spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4-1.8	1.5	1.6	0.23	1-1.1
<b>Number of coats</b>	2-2.5	2-2.5	2-2.5	2-2.5	2-2.5
<b>Flash off at 20°C</b>	until mat	until mat	until mat	until mat	until mat
<b>Film thickness</b>	20-25*				



Drying	Overcoatable	Tack-free	Ready for masking	Ready to assemble	Sandable
	Min. Max.				
<b>Object Temp. 20°C</b>	30 min 8 h				
<b>Object Temp. 60°C</b>	10 min				

**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 (c III)(780)729:** The EU limit value for this product (product category: IIB.c III) in ready to use form is max. 780 g/l. The VOC content of this product is 729 g/l.

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# 283-1870

CV-Multi-Wash 2 layer, beige



A brand of BASF –  
We create chemistry

## Remark

Do not overcoat 283-1870 directly with polyester- or epoxy-products, 68 RAL 9006, basecoat line 90 CV PLUS or line 55.

\* 2 - 2.5 spray coats (20-25 µm) for 2-layer system with topcoat 68 Line PLUS.

Apply topcoat on 283-1870 within one working day (8 hours). P-H-120 only suitable for repair and small parts. Do not use on blasted substrates. On anodized alu and hot-dip galvanized steel, adhesion must be tested beforehand.

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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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## Safety advice:

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

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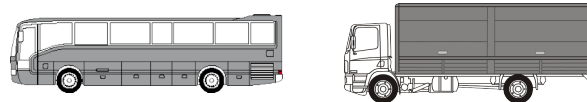
# 283-1870

283-1870 Variant 3 layer, beige



A brand of BASF –  
We create chemistry

**Application:**



busses, fire-fighting vehicle, boxes (aluminum), boxes, bulk loading vehicles (aluminum)

**Key Features:**

- good levelling and flow
- suitable for large surfaces
- quick drying
- excellent corrosion protection
- tintable with max. 3% 568-408
- 3-layer system i.e. with 284-45 or 284-90

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
The pre-treated metallic surface must be coated on the same day to prevent renewed oxidation.

**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
●●	●●	●●	●●	●	○				○	○			○	○



<b>Spreading rate</b>	196 m <sup>2</sup> /l at 1 µm
<b>Solid Content</b>	~34% (RFU~23%)

**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 (c III)(780)729:** The EU limit value for this product (product category: IIB.c III) in ready to use form is max. 780 g/l. The VOC content of this product is 729 g/l.

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# 283-1870

283-1870 Variant 3 layer, beige



A brand of BASF –  
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**Mixing Ratio** 2 : 1 + 10 - 20% by volume



**Hardener** 352-235, P-H-120



**Reducer** 352-320, -330



**Spray viscosity at 20°C** DIN 4: 22-26 s

**Potlife at 20°C** 8 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4-1.8	1.5	1.6	0.23	1-1.1
<b>Number of coats</b>	1.5-2*	1.5-2*	1.5-2*	1.5-2*	1.5-2*
<b>Flash off at 20°C</b>	until mat	until mat	until mat	until mat	until mat
<b>Film thickness</b>	15-20*				



<b>Drying</b>	<b>Overcoatable</b>	<b>Tack-free</b>	<b>Ready for masking</b>	<b>Ready to assemble</b>	<b>Sandable</b>
	Min. Max.				
<b>Object Temp. 20°C</b>	30 min 8 h				
<b>Object Temp. 60°C</b>	10 min				

**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 (c III)(780)729:** The EU limit value for this product (product category: IIB.c III) in ready to use form is max. 780 g/l. The VOC content of this product is 729 g/l.

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# 283-1870

283-1870 Variant 3 layer, beige



A brand of BASF –  
We create chemistry

## Remark

Do not overcoat 283-1870 directly with polyester- or epoxy-products, 68 RAL 9006, basecoat line 90 CV PLUS or line 55.

\* 1,5 - 2 coats (15-20µm) for 3-layer system with 284-45 or 284-90.

Apply filler on 283-1870 within one working day (8 hours).

P-H-120 only suitable for repair and small parts. Do not use on blasted substrates. On anodized alu and hot-dip galvanized steel, adhesion must be tested beforehand.

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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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## Safety advice:

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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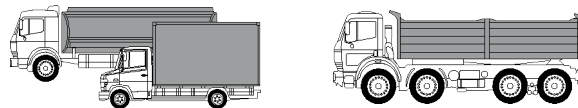
# 284-58E

Eco Balance CV universal primer filler, white



A brand of BASF –  
We create chemistry

**Application:**



boxes, construction vehicles, silo / tank truck, bus

**Key Features:**

- can be used on many substrates
- greyscale L07 (tintable with max. 10% 568-408)
- very good corrosion protection
- good appearance used wet on wet
- can be used for large areas

**Remarks:**

Suitable for commercial vehicle repair and aluminum add-on parts. Due to the large number of different aluminum alloys, the coating of large areas of vehicles (e. g. dropsides) or the close-to-production line coating of vehicles must be tested from a technological standpoint beforehand. The substrate should be clean, free of dust, rust, oils and grease. The pre-treated metallic surface must be coated on the same day to prevent renewed oxidation.

**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** 458 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 75% res. ~66% mixed (+/- 2%)

**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 (c I)(540)474:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 474 g/l.

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# 284-58E

Eco Balance CV universal primer filler, white



A brand of BASF –  
We create chemistry



**Mixing Ratio** 4 : 1 : 1 by volume wet on wet  
5 : 1 : 1 sanding



**Hardener** 922-220 PRO



**Reducer** 352-320E, -330, -315



**Spray viscosity at 20°C** DIN 4: 18-20 s

**Potlife at 20°C** 1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Nozzle pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4-1.6	1.7	1.7	0.28-0.33	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				1300-1600 Ω	
<b>Number of coats</b>	2	2	2	2	2
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min	10-15 min	10-15 min
<b>Film thickness</b>	50-70 µm				

**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 (c I)(540)474:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 474 g/l.

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# 284-58E

Eco Balance CV universal primer filler, white



A brand of BASF –  
We create chemistry



**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

	Min.	Max.				
<b>Object Temp. 20°C</b>	60 min	72 h	6 h	16 h	16 h	16 h
<b>Object Temp. 60°C</b>	30 min		30 min	30 min	30 min	45 min

**Remark**

On hot-dip galvanized steel, adhesion must be tested beforehand.

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.



**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 (c I)(540)474:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 474 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](http://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.

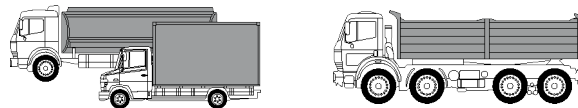
# 284-60

Glasurit CV universal primer filler, grey



A brand of BASF –  
We create chemistry

**Application:**



boxes, construction vehicles, silo / tank truck, bus

**Key Features:**

- can be used on many substrates
- greyshade L04 (tintable with max. 10% 568-408)
- very good corrosion protection
- good appearance used wet on wet
- can be used for large areas

**Remarks:**

Suitable for commercial vehicle repair and aluminum add-on parts. Due to the large number of different aluminum alloys, the coating of large areas of vehicles (e. g. dropsides) or the close-to-production line coating of vehicles must be tested from a technological standpoint beforehand. The substrate should be clean, free of dust, rust, oils and grease. The pre-treated metallic surface must be coated on the same day to prevent renewed oxidation.

**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** 444 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 74% res. ~65% mixed (+/- 2%)

**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 (c I)(540)488:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 488 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](http://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.

# 284-60

Glasurit CV universal primer filler, grey



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**Mixing Ratio** 4 : 1 : 1 by volume wet on wet  
5 : 1 : 1 by volume sanding



**Hardener** 922-220 PRO



**Reducer** 352-315, -320, -330



**Spray viscosity at 20°C** DIN 4: 18-20 s

**Potlife at 20°C** 1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Nozzle pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4-1.6	1.7	1.7	0.28-0.33	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				1300-1600 Ω	
<b>Number of coats</b>	2	2	2	2	2
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min	10-15 min	10-15 min
<b>Film thickness</b>	50-70 µm				

**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 (c I)(540)488:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 488 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](http://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.

# 284-60

Glasurit CV universal primer filler, grey



A brand of BASF –  
We create chemistry



**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

	Min.	Max.				
<b>Object Temp. 20°C</b>	60 min	72 h	6 h	16 h	16 h	16 h
<b>Object Temp. 60°C</b>	30 min		30 min	30 min	30 min	45 min

**Remark**

On hot-dip galvanized steel, adhesion must be tested beforehand.  
For tinting see CV Primer Tinting Paste 568-408.

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.

**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 (c I)(540)488:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 488 g/l.

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# 284-90

CV Primer Filler, PU



A brand of BASF –  
We create chemistry

**Application:**



busses, fire-fighting vehicle, boxes, bulk loading vehicles

**Key Features:**

- 284-90 white (greyscale 08)
- tintable
- can be used on many substrates
- very good appearance and flow
- very good corrosion protection
- all-purpose
- can be over coated with Glasurit topcoat 58, 68 Line PLUS, 55

**Remarks:**

Suitable for commercial vehicle repair and aluminum add-on parts. Due to the large number of different aluminum alloys, the coating of large areas of vehicles (e. g. dropsides) or the close-to-production line coating of vehicles must be tested from a technological standpoint beforehand. 283-6150 Wash Primer can be used in advance without separate testing. The substrate should be clean, free of dust, rust, oils and grease. The pre-treated metallic surface must be coated on the same day to prevent renewed oxidation.

Substrates	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
●● = Very well suited	●●	●●	●●	●	●			●●	●●	●●	●●	●●	●●	●●	●●
● = well suited															
○ = suited in some cases															

**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 (c I)(540)480:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 480 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](http://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.

# 284-90

CV Primer Filler, PU



A brand of BASF –  
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**Spreading rate** 528 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 80 % (RFU~70%)



**Mixing Ratio** 3:1 + 10 - 30% by volume



**Hardener** 922-180 Pro



**Reducer** 352-320, -330



**Spray viscosity at 20°C** DIN 4: 18-28 s

**Potlife at 20°C** 1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVL spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Nozzle pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4-1.6	1.7	1.7	0.28-0.33	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				1300-1600 Ω	
<b>Number of coats</b>	2	1.5-2	1.5-2	1.5-2	1.5-2
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min	10-15 min	10-15 min
<b>Film thickness</b>	50-70 µm				

**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 (c I)(540)480:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 480 g/l.

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# 284-90

CV Primer Filler, PU



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**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

	Min.	Max.				
<b>Object Temp. 20°C</b>	60 min	72 h	6 h	16 h	16 h	16 h
<b>Object Temp. 60°C</b>	30 min		30 min	30 min	30 min	45 min

**Remark**

2nd spray coat maximum 10% tintable with 68 Line PLUS.  
 For Flex additive see variant with P-A-912.  
 For tinting see variant with 568-408.  
 On hot-dip galvanized steel, adhesion must be tested beforehand.  
 Mixing ratio for smooth/flat surfaces (best flow) 3:1 + 30%, 2 spray coats, nozzle size 1.4 (RP).

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.

**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 (c I)(540)480:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 480 g/l.

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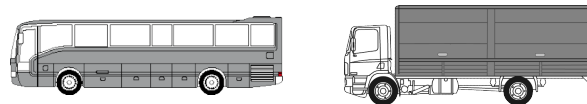
# 801-715

CV EP primer filler



A brand of BASF –  
We create chemistry

**Application:**



busses, fire-fighting vehicle, boxes, bulk loading vehicles, boxes (aluminum)

**Key Features:**

- suitable on many metal substrates
- very good levelling
- good filling properties
- multi-purpose
- outstanding corrosion protection
- grey (greyscale 04), tintable with 568-408
- overcoating with 68 Line PLUS, 58, 90 CV PLUS or 55 Line\*

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
\*For overcoating with 90 CV PLUS or 55 Line flash off of 1h at 20°C (not less) is mandatory.  
Because of the variety of metal alloys and manufacturing processes, it is recommended to carry out a preliminary adhesion test before application.

**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** 430 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 77 % (RFU~63%)

**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 (c I)(540)493:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 493 g/l.

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# 801-715

CV EP primer filler



A brand of BASF –  
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**Mixing Ratio** 4 : 1 : 1 by volume



**Hardener** 965-715



**Reducer** 568-745, -720



**Spray viscosity at 20°C** DIN 4: 19-22 s

**Potlife at 20°C** 8 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLV spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4-1.6	1.5	1.7	0.28-0.33	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				600-900 Ω	
<b>Number of coats</b>	2	2	2	1.5-2	1.5-2
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min	10-15 min	10-15 min
<b>Film thickness</b>	50-70 μm				

**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 (c I)(540)493:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 493 g/l.

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# 801-715

CV EP primer filler



A brand of BASF –  
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**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

	Min.	Max.				
<b>Object Temp. 20°C</b>	60 min	72 h	3 h	16 h	16 h	
<b>Object Temp. 60°C</b>	30 min		30 min	30 min	30 min	50-60 min

**Remark**

Minimum ambient temperature during application and drying: +15°C.  
 For overcoating 801-715 with 90 CV PLUS or Line 55 flash off at least 1 h at 20°C mandatory, maximum flash off time: within one working day (for over coating with 68 Line PLUS 72 h).  
 Do not adjust 801-715 with 352-reducers, only with 568-745 CV protective additive EP slow or 568-720 CV protective additive normal!  
 The first spray coat has to be a closed coat followed after flash off by a second full wet coat.  
 On blasted substrates take care of covering the surface roughness.  
 801-715 provides a good wet on wet finish, however, if sanding is required:  
 drying of 50 - 60 min at 60°C object temperature or 16 h at 20°C is necessary.  
 For tinting see variant with 568-408.  
 Before applying polyester products 801-715 has to be dried for at least 45 min 60°C (object temperature). Adhesion on hot dipped galvanized steel has to be checked before.

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.

**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 (c I)(540)493:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 493 g/l.

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# 284-10

Glasurit CV transparent sealer



A brand of BASF –  
We create chemistry

**Application:**



sign writing, cabs (color change), multi - color painting, powder coated profiles / boxes

**Key Features:**

- tintable
- brilliant top coat appearance
- fast drying

**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
●●	●●	●●	●●	●●	○	●●	●●	●●	●●	●●	○	●●	●●	●●



**Spreading rate** 406 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 66 % (RFU~53%)

**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 (c II)(540)502:** The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. The VOC content of this product is 502 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](http://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.

# 284-10

Glasurit CV transparent sealer



A brand of BASF –  
We create chemistry



**Mixing Ratio**                      **2:1+30 % by volume**



**Hardener**                              922-18 Pro, -16 Pro



**Reducer**                                352-310, -315, -320



**Spray viscosity at 20°C**      DIN 4:    17 s

**Potlife at 20°C**                      3 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLV spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar		
<b>Nozzle size</b>	1.4	1.5	1.7		
<b>Number of coats</b>	1	1	1		
<b>Film thickness</b>	20-25 µm				



<b>Drying</b>	<b>Overcoatable</b>	<b>Tack-free</b>	<b>Ready for masking</b>	<b>Ready to assemble</b>	<b>Sandable</b>
	Min.      Max.				
<b>Object Temp. 20°C</b>	15 min    2 h				

**Remark**                                      Transparent Sealer 284-10 can be tinted with (up to 10% of) 68 Line PLUS topcoat.

**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 (c II)(540)502:** The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. The VOC content of this product is 502 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](http://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.

# 284-10

Glasurit CV transparent sealer



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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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**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 (c II)(540)502:** The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. The VOC content of this product is 502 g/l.

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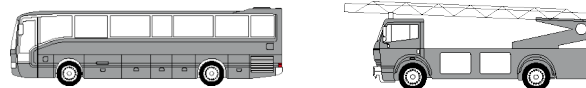
# 284-45

CV Filler, PUR



A brand of BASF –  
We create chemistry

**Application:**



busses, plastic painting, cabs (color change), boxes, daylight fluorescent paint

**Key Features:**

- suitable on all Glasurit CV primer and primer filler
- 284-45 white (greyscale 08)
- good adhesion to various plastics
- brilliant topcoat appearance
- good leveling
- filler for daylight fluorescent paint and for 2 step colors
- tintable
- overcoatable with Glasurit topcoat 58, 68 Line PLUS, 55

**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
●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●	●●



**Spreading rate** 494 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 78 % (RFU ~ 66%)

**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 (c I)(540)456:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 456 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](http://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.

# 284-45

CV Filler, PUR



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**Mixing Ratio** 2:1 + 10 - 30% by volume



**Hardener** 922-180 Pro



**Reducer** 352-320, -330, -340



**Spray viscosity at 20°C** DIN 4: 17-21 s

**Potlife at 20°C** 1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Nozzle pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4-1.6	1.5	1.7	0.28-0.33	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				600-800 Ω	
<b>Number of coats</b>	1.5	1.5	1.5	1.5	1.5
<b>Flash off at 20°C</b>	without	without	without	without	without
<b>Film thickness</b>	50-70 µm				

**Safety advice:**

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

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# 284-45

CV Filler, PUR



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**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

	Min.	Max.				
<b>Object Temp. 20°C</b>	60 min	72 h	2 h	16 h	16 h	16 h
<b>Object Temp. 60°C</b>	30 min		30 min	30 min	30 min	45 min

**Remark**

Can be tinted by adding up to 10% of 68 Line PLUS topcoat.  
 To plasticize the product, see variant with P-A-912 Flex Additive.  
 For tinting see variant with 568-408.  
 For sanding (2:1 + 10%) the filmthickness should be 80 µm (50 – 60 µm after sanding) and the drying time has to be 45 min 60°C or 16 h 20 °C. Sandthroughs have to covered by using a suitable primer.  
 For using 284-45 as plastic adhesion promoter see variant.  
 See high build variant for higher film thickness.

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.

**Safety advice:**

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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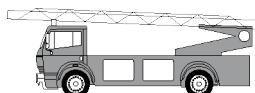
# 284-99

CV Texture Filler, ACR, transparent



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**Application:**



firefighting truck, trams

**Key Features:**

- suitable on all Glasurit CV primer filler (PUR & EP)
- overcoatable with Topcoat 68 Line PLUS
- from fine to coarse textured effect application
- good sagging resistance
- quick drying properties
- to be tinted with 10% topcoat 68 Line PLUS (except Basic topcoat)
- semi glossy

**Remarks:**

284-99 to be used as textured effect given filler (i. e. on EP 801- or PUR 284-), afterwards over coating with topcoat 68 Line PLUS in requested color, for perfect color appearance it is necessary to tint 284-99 with 10% topcoat 68 Line PLUS (except Basic topcoat), same color as requested on top of 284-99.

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

- Viscosity: high-viscous

**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 (c I)(540)346:** The EU limit value for this product (product category: IIB.c I) in ready to use form is max. 540 g/l. The VOC content of this product is 346 g/l.

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# 284-99

CV Texture Filler, ACR, transparent



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<b>Spreading rate</b>	615 m <sup>2</sup> /l at 1 µm
<b>Solid Content</b>	~ 73 % (RFU~75%)



<b>Mixing Ratio</b>	8 : 1 by volume
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<b>Hardener</b>	922-139, -138
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<b>Reducer</b>	352-91 CV
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<b>Potlife at 20°C</b>	1 h
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**Application:** **Compliant - gravity feed cup** **HVLP spray gun** **Suction cup** **Airless/ Airmix** **Pressure pot dbl.-pump**

<b>Application pressure</b>	0.5-1.5 bar
<b>Material pressure</b>	1-1.5 bar
<b>Nozzle size</b>	1.2-1.7
<b>Number of coats</b>	1-2
<b>Flash off at 20°C</b>	10-15 min
<b>Film thickness</b>	depends on textured effect

**Safety advice:**

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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# 284-99

CV Texture Filler, ACR, transparent



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**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

	Min.	Max.		
<b>Object Temp. 20°C</b>	60 min	72 h		24-36 h
<b>Object Temp. 60°C</b>	30 min			60-90 min

The textured effect can be influenced by distance to substrate, spray equipment, nozzle size, atomization and or material pressure. 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 1,4), afterwards use 284-99 (8:1 by volume) as textured filler.

**Remark**

**Pressure Pot:**

- Atomization pressure: 0,5 - 1,5 bar
- Paint pressure: 1 - 1,5 bar
- Nozzle size: 1,7 - 2,5
- Spray coats: 1 - 2
- Flash off: 10 - 15 Min.

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.

**Safety advice:**

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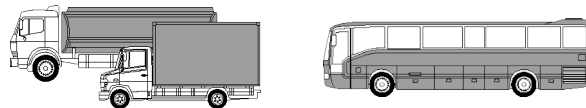


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# 568-M 135

68 Line PLUS Efficient Topcoat

**Application:**



**Key Features:**

- very good appearance, flow and finish
- suitable for large and small areas
- very good UV and chemical resistance
- quick and easy application with 1,5 spray coats
- very good surface hardness
- good opacity

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
The complete color range for CV application is covered.

**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** 511 m<sup>2</sup>/l at 1 µm

**Solid Content** (rfu) ~ 58- 66 %

**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/IIB (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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# 568-M 135

68 Line PLUS Efficient Topcoat



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**Mixing Ratio** 4 : 1 : 1 by volume



**Hardener** 922-138, -139, -136



**Reducer** 352-315, -320, -330



**Spray viscosity at 20°C** DIN 4: 20-23 s

**Potlife at 20°C** 1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLV spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	1.8-2.2 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-180 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.3-1.4	1.5	1.7	0.23-0.28	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	1.5	1.5	1.5	1.5	1.5
<b>Flash off at 20°C</b>	without	without	without	without	without
<b>Film thickness</b>	40-60 µm				

**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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# 568-M 135

68 Line PLUS Efficient Topcoat



**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

**Remark**

Application: Pre-spray 1 thin grip coat with the finishing coat following immediately.  
 Airless or Airmix: Use mixing clear 568-M 100 instead of 568-M 135.  
 Best appearance in combination with hardener 922-139 slow Premium  
 Potlife: ~1h with 922-136 / ~ 1,5h 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.  
 Use Scotch Pad and pre-spray adhesion promoter 284-10 if painted surface was force dried at 60°C or dried at 20°C for 16h.

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.

**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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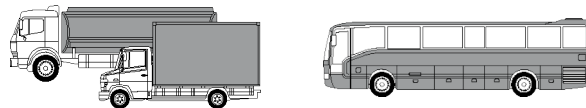


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# 568-M 100

68 Line PLUS - CV Efficient Topcoat

**Application:**



all applications

**Key Features:**

- airless / airmix application
- 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<sup>2</sup>/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.

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# 568-M 100

68 Line PLUS - CV Efficient Topcoat



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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**

<b>Application pressure</b>	2 bar
<b>Material pressure</b>	120-180 bar
<b>Nozzle size</b>	0.23-0.28
<b>Voltage</b>	50-80 kV
<b>Elect. Resistance</b>	700-1500 Ω
<b>Number of coats</b>	1.5
<b>Film thickness</b>	40-60 μm

**Safety advice:**

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

The e products are suitable for professional use only.

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# 568-M 100

68 Line PLUS - CV Efficient Topcoat



**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

**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 284-10 prior to multi-colour finishing if painted surface was baked or flashed off for 16 h.

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.

**Safety advice:**

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

The e products are suitable for professional use only.

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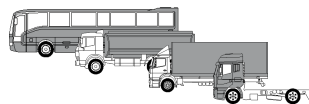


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We create chemistry

# 568-M 200

68 Line PLUS Supreme Topcoat

**Application:**



**Key Features:**

- excellent appearance, flow and finish
- high UV and chemical resistance
- designed for small and large areas
- very good surface hardness
- very good opacity
- suitable for all application methods
- 50°C drying, reduction of energy

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
The complete color range for CV application is covered.

**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** 523 m<sup>2</sup>/l at 1 µm

**Solid Content** (rfu) ~ 59 - 65%

**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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# 568-M 200

68 Line PLUS Supreme Topcoat



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We create chemistry

## Handling



Best appearance in combination with hardener 922-139 slow Premium.  
 Potlife: ~1h with 922-136 / ~ 1,5h with 922-138 and ~ 2h with 922-139.  
 Drying: 30 min. at 50°C with 922-138, 45 - 60 min. at 50°C with 922-139.  
 Recoatable with itself without intermediate sanding for up to 16 hours after application.  
 Use Scotch Pad and pre-spray adhesion promoter 284-10 if painted surface was force dried at 50°C or dried at 20°C for 16h.



**Mixing Ratio** 4 : 1 : 1 by volume



**Hardener** 922-138, -139, -136



**Reducer** 352-315, -320, -330



**Spray viscosity at 20°C** DIN 4: 20-23 s

**Potlife at 20°C** 1.5 h

## Safety advice:

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

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# 568-M 200

68 Line PLUS Supreme Topcoat

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLV spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	1.8-2.2 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-180 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.3-1.4	1.5	1.7	0.23-0.28	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	2	2	2	2	2
<b>Flash off at 20°C</b>	~ 10 min flash off between coats	~ 10 min flash off between coats	~ 10 min flash off between coats	~ 10 min flash off between coats	~ 10 min flash off between coats
<b>Film thickness</b>	50-60 µm				



**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

**Remark**

**Drying Object temp. 50°C**

- Overcoatable 30 min
- Tack-free 30 min
- Ready for masking 30 min
- Ready to assemble 30 min
- Sandable 30 min

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.

**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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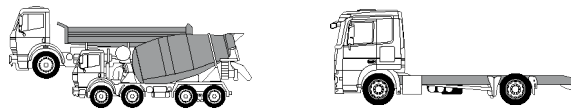


A brand of BASF –  
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# 568-M 90

68 Line PLUS High Build Topcoat

**Application:**



**Key Features:**

- good appearance
- suitable for large and small areas
- robust application e. g. for chassis
- outstanding edge covering (e.g. for rivets, screws, welding seams)
- very good surface hardness
- good UV and chemical resistance
- high opacity
- suitable for all application methods

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
The complete color range for CV application is covered.

**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** 516 m<sup>2</sup>/l at 1 µm

**Solid Content** (rfu) ~ 58 - 66%

**Safety advice:**

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

The e products are suitable for professional use only.

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# 568-M 90

68 Line PLUS High Build Topcoat



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**Mixing Ratio** 4 : 1 : 1 by volume



**Hardener** 922-138, -139, -136



**Reducer** 352-315, -320, -330



**Spray viscosity at 20°C** DIN 4: 23-25 s

**Potlife at 20°C** 1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLV spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	1.8-2.2 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-180 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.6-1.8	1.7	1.7	0.23-0.28	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	2	2	2	2	2
<b>Flash off at 20°C</b>	~ 10 min flash off between coats	~ 10 min flash off between coats	~ 10 min flash off between coats	~ 10 min flash off between coats	~ 10 min flash off between coats
<b>Film thickness</b>	50-80 µm				

**Safety advice:**

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

The e products are suitable for professional use only.

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# 568-M 90

68 Line PLUS High Build Topcoat



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**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

**Remark**

Potlife: ~1h with 922-136 / ~1,5h 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.

Use Scotch Pad and pre-spray adhesion promoter 284-10 if painted surface was force dried at 60°C or dried at 20°C for 16h.

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.

**Safety advice:**

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

The e products are suitable for professional use only.

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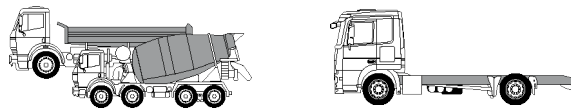


A brand of BASF –  
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# 568-M 80

68 Line PLUS Basic Topcoat

**Application:**



**Key Features:**

- good appearance, flow and finish
- suitable for large and small areas
- good UV and chemical resistance
- easy application
- very good surface hardness
- good opacity
- suitable for all application methods

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
The complete color range for CV application is covered.  
Mixing Clear 568-M 80 needs to be stirred well before mixing with tinting bases.

**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
								●●					○	○



<b>Spreading rate</b>	525 m <sup>2</sup> /l at 1 µm
<b>Solid Content</b>	(rfu) ~ 59- 65%

**Safety advice:**

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

The e products are suitable for professional use only.

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# 568-M 80

68 Line PLUS Basic Topcoat



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**Mixing Ratio** 2 : 1 by volume



**Hardener** 922-815, -825



**Spray viscosity at 20°C** DIN 4: 20-23 s

**Potlife at 20°C** 1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVL spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	1.8-2.2 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-180 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.3-1.4	1.5	1.7	0.23-0.28	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	2	2	2	2	2
<b>Flash off at 20°C</b>	~ 10 min flash off between coats	~ 10 min flash off between coats	~ 10 min flash off between coats	~ 10 min flash off between coats	~ 10 min flash off between coats
<b>Film thickness</b>	50-60 µm				



<b>Drying</b>	<b>Overcoatable</b>		<b>Tack-free</b>	<b>Ready for masking</b>	<b>Ready to assemble</b>	<b>Sandable</b>
	Min.	Max.				
<b>Object Temp. 20°C</b>		16 h	2.5 h	16 h	12 h	16 h
<b>Object Temp. 60°C</b>	30 min		30 min	30 min	30 min	30 min

**Safety advice:**

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

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# 568-M 80

68 Line PLUS Basic Topcoat



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## Remark

Potlife: ~1,5h with 922-815 and ~ 2h with 922-825.

Drying: 30 min. at 60°C with 922-815, 45 - 60 min. at 60°C with 922-825.

Recoatable with itself without intermediate sanding for up to 16 hours after application.

Use Scotch Pad and pre-spray adhesion promoter 284-10 if painted surface was force dried at 60°C or dried at 20°C for 16h.

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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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## Safety advice:

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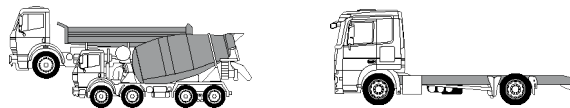


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# 568-M 124

68 Line Plus matt

**Application:**



all applications where a reduced gloss is required, construction machinery (steel), chassis painting, chassis (color change)

**Key Features:**

- suitable on all Glasurit CV primer filler and filler
- suitable for large areas / surfaces
- good leveling
- excellent UV resistance
- excellent surface hardness
- good hiding power
- different gloss level can be mixed via Color Online/Profit Manager

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
The complete color range for CV-application is covered.

**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
								●●					○	○



<b>Spreading rate</b>	536 m <sup>2</sup> /l at 1 µm
<b>Solid Content</b>	~ 67 %

**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 (e)(840)830:** The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/l. The VOC content of this product is 830 g/l.

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# 568-M 124

68 Line Plus matt



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	<b>Pre Mix</b>	Mix 68 Line PLUS 5:1 Vol with 568-M 124 CV Matt Mixing Clear = Gloss ~60-70 units at 20° For lower gloss level please refer to Glasurit Color Online.
	<b>Mixing Ratio</b>	5:1:1 Vol. (if mixed with Efficient, High Build or Supreme) 3:1 Vol. with 922-815 or -825 (if mixed with Basic topcoat)
	<b>Hardener</b>	922-139, -138, -136
	<b>Reducer</b>	352-320, -315, -330
	<b>Spray viscosity at 20°C</b>	DIN 4: 18-22 s
	<b>Potlife at 20°C</b>	1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-180 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4	1.5	1.7	0.23-0.28	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	2	2	2	2	2
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min	10-15 min	10-15 min
<b>Film thickness</b>	40-60 µm				

**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 (e)(840)830:** The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/l. The VOC content of this product is 830 g/l.

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# 568-M 124

68 Line Plus matt



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**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

**Remark**

Potlife: ~1h with 922-136 / ~ 1,5h 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.

568-M 124 must be stirred in with a pneumatic stirrer or alternatively a shaker.

Attention: The various topcoat hardener influences the gloss level; above mentioned gloss values refer to drying M124 with 922-139.

Adjust with hardener and reducer 5:1:1 Vol. with mixing stick.

After the first coat a flash off of 10 - 15 min is required, after the second coat flash off until matt.

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.

**Safety advice:**

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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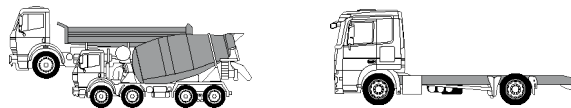


A brand of BASF –  
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# 58 Line 2K HS CV

2K HS CV chassis topcoat, satin gloss

**Application:**



all applications where a reduced gloss is required, chassis (color change), chassis painting, container

**Key Features:**

- suitable on all Glasurit CV primer filler and filler
- good leveling
- high efficiency
- good hiding power
- excellent surface hardness
- excellent UV resistance
- Colors MB 7350 nova gray, MB 9124 chassis black, MAN 9011 black, 58-1250 M rally black (matt)

**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
								●●					○	○



**Spreading rate** 536 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 67 %

**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.

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A brand of BASF –  
We create chemistry

# 58 Line 2K HS CV

2K HS CV chassis topcoat, satin gloss

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

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-180 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4	1.5	1.7	0.23-0.28	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	1.5	1.5	1.5	1.5	1.5
<b>Flash off at 20°C</b>	without	without	without	without	without
<b>Film thickness</b>	40-60 µm				

**Safety advice:**

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

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**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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A brand of BASF –  
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# 58 Line 2K HS CV

2K HS CV chassis topcoat, satin gloss



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

**Remark**

Gloss level is depending on the specific color master.  
Recoatable with itself without intermediate sanding for up to 16 hours after application.  
Due to the reduced gloss level not suitable for blend in processes.

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.

**Safety advice:**

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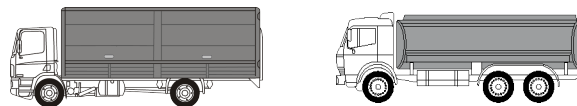


A brand of BASF –  
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# 68-RAL 9006

HS 2K CV Topcoat, silver direct gloss, RAL 9006

**Application:**



all applications, dumptruck (aluminum), boxes, bulk loading vehicles

**Key Features:**

- suitable on all Glasurit CV primer filler and filler
- suitable for large areas / surfaces
- good leveling
- excellent UV resistance
- excellent surface hardness

**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
								●●					○	○



<b>Spreading rate</b>	536 m <sup>2</sup> /l at 1 µm
<b>Solid Content</b>	~ 62 %

**Safety advice:**

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

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A brand of BASF –  
We create chemistry

# 68-RAL 9006

HS 2K CV Topcoat, silver direct gloss, RAL 9006

	<b>Mixing Ratio</b>	4 : 1 : 1 by volume
	<b>Hardener</b>	922-136, -138, -139
	<b>Reducer</b>	352-310, -320
	<b>Spray viscosity at 20°C</b>	DIN 4: 28-32 s
	<b>Potlife at 20°C</b>	1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-180 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4	1.5	1.7	0.23-0.28	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	1.5	1.5	1.5	1.5	1.5
<b>Flash off at 20°C</b>	without	without	without	without	without
<b>Film thickness</b>	40-60 µm				

**Safety advice:**

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

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A brand of BASF –  
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# 68-RAL 9006

HS 2K CV Topcoat, silver direct gloss, RAL 9006



## 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

## Remark

Application: Pre-spray 1 thin grip coat with the finishing coat following immediately. Alternatively, apply several thin spray coats.  
Recoatable with itself without intermediate sanding for up to 16 hours after application.  
After baking + 16 hours of air drying and prior to multi-colour finishing, the use of the adhesion promoter 284-10 is mandatory.

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.

## Safety advice:

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

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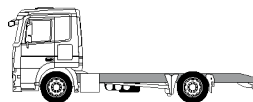


A brand of BASF –  
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# 568-46

568-46 Variant one layer system

**Application:**



chassis painting, chassis (color change), container

**Key Features:**

- tintable
- suitable for large areas / surfaces
- good leveling
- can be applied directly on steel or galvanized steel
- high efficiency
- good corrosion protection

**Remarks:**

Aluminum-Chassis have to be primed with a suitable primer.  
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 (c II)(540)530:** The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. The VOC content of this product is 530 g/l.

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A brand of BASF –  
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# 568-46

568-46 Variant one layer system



**Pre Mix**

568-46 with 68 Line PLUS  
mix 568-46 (50 parts) with 68 Line PLUS (50 parts)



**Mixing Ratio**

7 : 1 + 10 - 15% Vol. (if mixed with Efficient, High Build or Supreme)  
3:1 Vol. with 922-815 or -825 (if mixed with Basic topcoat)



**Hardener**

922-138, -136, -139



**Reducer**

352-315, -320, -330



**Spray viscosity at 20°C**

DIN 4: 30-40 s

**Potlife at 20°C**

1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.6-1.8	1.7-1.9	1.7-1.9	0.28-0.33	1-1.3
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	2	2	2	1-2	2
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min	10-15 min	10-15 min
<b>Film thickness</b>	70-100 µm				

**Safety advice:**

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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# 568-46

568-46 Variant one layer system



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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

16 h

16 h

**Object Temp. 60°C**

30 min

30 min

30 min

30 min

30 min

**Remark**

Shelf life of the mixed product (68 Line PLUS with 568-46) is only 2 weeks.  
The DTM version is not suitable for areas that are directly exposed to sunlight.  
Corrosion protection can only be achieved, if the required film thickness is applied (covering of sand blasting roughness, edges).  
568-46 must not be adjusted with 568-17 as it impacts technical performance. Mixing of 568-46 can change the color.  
The adhesion on hot dipped galvanized steel has to be checked before.

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.

**Safety advice:**

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

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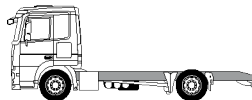


A brand of BASF –  
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# 568-46

568-46 Variant direct to Aluminium topcoat - glossy

**Application:**



chassis parts, spare and hang-on parts

**Key Features:**

- glossy version – mix 20 parts 568-46 / 80 parts topcoat 68 Line PLUS
- gloss level ~ 65 (white) –80 (red) units at 20°
- can be applied directly on alu, stainless steel
- good leveling & high efficiency
- provides good durability

**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
		●	●				●		●				●	●

**Handling**



**Spreading rate (rfu)**  
~ 517 - 536 m<sup>2</sup> / l / 1µm  
**Solid content (rfu)**  
~ 62 - 70 %

**Safety advice:**

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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# 568-46

568-46 Variant direct to Aluminium topcoat - glossy



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	<b>Pre Mix</b>	568-46 with 68 Line PLUS 20 parts 568-46 (vol) / 80 parts topcoat 68 Line PLUS (vol)
	<b>Mixing Ratio</b>	4:1 + 10% by volume
	<b>Hardener</b>	922-220 PRO
	<b>Reducer</b>	352-315, -320, -330
	<b>Spray viscosity at 20°C</b>	DIN 4: 23-28 s
	<b>Potlife at 20°C</b>	1.5 h

Application:	 <b>Compliant - gravity feed cup</b>	 <b>HVLP spray gun</b>	 <b>Suction cup</b>	 <b>Airless/ Airmix</b>	 <b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4-1.6	1.7-1.9	1.7-1.9	0.28-0.33	1-1.3
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	2	2	2	1.5-2	2
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min	10-15 min	10-15 min
<b>Film thickness</b>	50-70 µm				

**Safety advice:**

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

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# 568-46

568-46 Variant direct to Aluminium topcoat - glossy



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**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

Min.      Max.

**Object Temp. 20°C**

16 h

3-4 h

24 h

24 h

24 h

**Object Temp. 60°C**

45 min

45 min

45 min

45 min

45 min

**Remark**

The shelf life of the mixed product (topcoat Line 68 PLUS and 568-46) is only 2 weeks.  
The DTM version is not suitable for areas that are directly exposed to sunlight.  
The corrosion protection can only be achieved, if the required film thickness is applied.  
568-46 must not be adjusted with 568-17 as it impacts technical performance.  
Mixing of 568-46 can change the color.  
For airless / airmix application use recommended mixing clears.

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.

**Safety advice:**

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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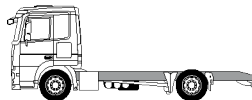


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# 568-46

568-46 Variant direct to Aluminium topcoat - semi-glossy

## Application:



chassis parts, spare and hang-on parts

## Key Features:

- semi-glossy version – mix 50 parts 568-46 / 50 parts topcoat 68 Line PLUS
- gloss level ~ 40 (white) – 75 (red) units at 20°
- can be applied directly on alu, stainless steel, steel
- good leveling & high efficiency
- provides good durability

## 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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## Handling



**Spreading rate (rfu)**  
≈ 539 - 550 m<sup>2</sup> / l / 1µm  
**Solid content (rfu)**  
≈ 68 - 72 %

## 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.

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# 568-46

568-46 Variant direct to Aluminium topcoat - semi-glossy



A brand of BASF –  
We create chemistry

	<b>Pre Mix</b>	568-46 with 68 Line PLUS 50 parts 568-46 (vol) / 50 parts topcoat 68 Line PLUS (vol)
	<b>Mixing Ratio</b>	4:1 + 10% by volume
	<b>Hardener</b>	922-220 PRO
	<b>Reducer</b>	352-315, -320, -330
	<b>Spray viscosity at 20°C</b>	DIN 4: 25-35 s
	<b>Potlife at 20°C</b>	1.5 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4-1.6	1.7-1.9	1.7-1.9	0.28-0.33	1-1.3
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				700-1500 Ω	
<b>Number of coats</b>	1.5-2	1.5-2	1.5-2	1-2	1.5-2
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min	10-15 min	10-15 min
<b>Film thickness</b>	60-70 µm				

**Safety advice:**

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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# 568-46

568-46 Variant direct to Aluminium topcoat - semi-glossy



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**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

Min.      Max.

**Object Temp. 20°C**

16 h

3-4 h

24 h

24 h

24 h

**Object Temp. 60°C**

45 min

45 min

45 min

45 min

45 min

**Remark**

The shelf life of the mixed product (topcoat 68 Line PLUS and 568-46) is only 2 weeks.  
The DTM version is not suitable for areas that are directly exposed to sunlight.  
The corrosion protection can only be achieved, if the required film thickness is applied (covering of sand blasting roughness, edges).  
568-46 must not be adjusted with 568-17 as it impacts technical performance.  
Mixing of 568-46 can change the color.  
For airless / airmix application use recommended mixing clears.

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.

**Safety advice:**

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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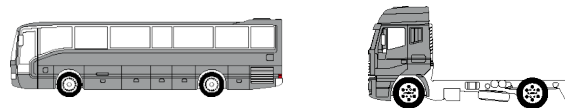


A brand of BASF –  
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# 90 CV PLUS

Basecoat metallics/solids

**Application:**



busses, cabs (color change), boxes, bulk loading vehicles, busses (repair)

**Key Features:**

- good leveling
- suitable for large areas / surfaces
- excellent UV resistance
- good hiding power
- outstanding application characteristics

**Remarks:**

The complete color range for CV-application is covered.  
The substrate should be clean, free of dust, rust, oil and grease.  
Use P-P-31 to clean substrates after sanding.  
Mixing Base 90-M 4 CV PLUS + 90-M Tinting Base + Adjusting Base 93- E 3 CV PLUS = 90 CV PLUS

**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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<b>Spreading rate</b>	130 m <sup>2</sup> /l at 1 µm
<b>Solid Content</b>	~ 15 %

**Safety advice:**

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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A brand of BASF –  
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# 90 CV PLUS

Basecoat metallics/solids



**Mixing Ratio**

2 : 1 by volume



**Reducer**

93-E 3 CV PLUS



**Spray viscosity at 20°C**

DIN 4: 20-30 s

**Potlife at 20°C**

8 h

**Application:**

**Compliant - gravity feed cup**
**HVL spray gun**
**Suction cup**
**Airless/ Airmix**
**Pressure pot dbl.-pump**

<b>Application pressure</b>	2 bar	2.5 bar
<b>Nozzle pressure</b>		0.8-1.5 bar
<b>Nozzle size</b>	1.5	1-1.1
<b>Number of coats</b>	2 + ½	2 + ½
<b>Flash off at 20°C</b>	until mat	until mat
<b>Film thickness</b>	10-15 µm	



**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

	Min.	Max.
<b>Object Temp. 20°C</b>	30 min	8 h
<b>Object Temp. 60°C</b>	15 min	

**Safety advice:**

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

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# 90 CV PLUS

Basecoat metallics/solids



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## Remark

Prespray one light spray coat, leave to flash off until mat. Then finish with one wet coat, leave to flash off until mat.

Apply ½ spray coat (minimum distance to the panel: 50 cm) to match the effect.

If required to reduce the viscosity afterwards use Glasurit 93-E 3 CV PLUS.

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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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## Safety advice:

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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# 55-

## Basecoat metallics / solids, 55 Line variant for CV



A brand of BASF –  
We create chemistry

**Application:** sign writing, busses, cabs (refurbishing), cabs (color change), boxes, busses (repair)

**Key Features:**

- suitable for large areas / surfaces
- good leveling
- excellent UV resistance
- good hiding power
- fast drying

**Remarks:** The complete color range for CV application is covered.  
The substrate should be clean, free of dust, rust, oil and grease.  
For large areas and higher temperatures the use of reducer 352-330 slow or 352-340 extra slow is recommended for better overspray absorption.

### Handling



**Substrates**

Glasurit CV - Primer Filler / Filler  
Spreading rate 115 m<sup>2</sup>/l at 1 μm  
Solid Content ~ 25 %



**Pressure pot dbl.-pump**

Application pressure 1.8 - 2.5 bar  
Nozzle size 0.8 - 1.1  
Number of coats 2 + ½  
Flash off at 20°C until mat

2:1 by volume



**Reducer**

352-315, -320



**Spray viscosity at 20°C**

DIN 4: 18-22 s

**Safety advice:**

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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# 55-

Basecoat metallics / solids, 55 Line variant for CV

Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Application pressure	2-2.5 bar	2 bar
Nozzle size	1.4	1.5
Number of spray coats	2 + ½	
Flash off at 20°C	until mat	
Film thickness	10-15 µm	



Drying at 20°C

**Overcoatable**

min. 10 min

max. 8 h

**Tack-free**

10 min

**Ready for masking**

30 min

**Remark**

Prespray one light spray coat, leave to flash off until mat. Then finish with one wet coat, leave to flash off until mat. Apply ½ spray coat (minimum distance to the panel: 50 cm) to match the effect. To achieve best technical performance of the paint system it is recommended to add 2% hardener 922-138 (or -136) to 55 line basecoat.

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.

**Safety advice:**

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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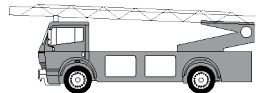


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# 923-Daylight fluorescent

Glasurit Daylight fluorescent paint

**Application:**



fire-fighting vehicle

**Key Features:**

- suitable for large areas / surfaces
- brilliant top coat appearance
- good leveling
- colors RAL 1026-T, RAL 2005-T, RAL 3024-T

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease.  
Daylight fluorescent paints are special fluorescent paints for fire brigades (cf. DIN 14502, Part 3), police and municipal vehicles, etc..  
In this case, a special authorization is needed according to para. 1 of s. 49a of the German Road Traffic Act.

**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** 430 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 62 %

**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 (e)(840)839:** The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/l. The VOC content of this product is 839 g/l.

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# 923-Daylight fluorescent

Glasurit Daylight fluorescent paint



**Mixing Ratio** 4:1+10 % by volume



**Hardener** 929-93, -91, -94



**Reducer** 352-315, -320, -330



**Spray viscosity at 20°C** DIN 4: 30 s

**Potlife at 20°C** 4 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLV spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar		
<b>Nozzle size</b>	1.3-1.6	1.3-1.5	1.7		
<b>Number of coats</b>	4-5	4-5	4-5		
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min		
<b>Film thickness</b>	100 µm				



**Drying** **Overcoatable** **Tack-free** **Ready for masking** **Ready to assemble** **Sandable**

	Min.	Max.
<b>Object Temp. 20°C</b>	10 h	72 h
<b>Object Temp. 60°C</b>	60 min	

**Safety advice:**

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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# 923-Daylight fluorescent

Glasurit Daylight fluorescent paint



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## Remark

May only be used on homogeneous white undercoat, i. e. 284-45. After oven drying and before application of 924-268 object has to cool down to ambient room temperature.

Apply Glasurit 924-268 Protective Clear over the Daylight Fluorescent Paint to slow down the bleach out/ dull process of the Daylight Fluorescent Paint. Because of the chemical composition of these specific pigments, the degradation through direct sunlight is accelerated massively.

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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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## Safety advice:

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BASF Coatings GmbH - Automotive Refinish Coatings Solutions Europe - Glasuritstrasse 1 - 48165 Münster - Germany

03/2025

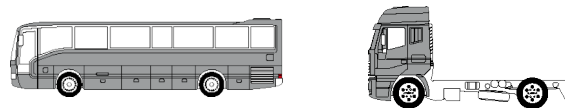
# 924-50

Glasurit CV clear coat extreme mat



A brand of BASF –  
We create chemistry

**Application:**



busses, sign writing, metallic coating (line 90), boxes, bulks

**Key Features:**

- good leveling
- nice and even mat appearance
- high flexibility
- gloss level ~ 10 units at 60° / ~ 30 units at 85°
- for mat finish with topcoat 68 Line PLUS , line 90 or 55

**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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<b>Spreading rate</b>	276 m <sup>2</sup> /l at 1 µm
<b>Solid Content</b>	~ 33 %

**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 (e)(840)651:** The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/l. The VOC content of this product is 651 g/l.

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# 924-50

Glasurit CV clear coat extreme mat



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**Mixing Ratio** 5 : 1 : 1 by volume



**Hardener** 922-138, -139



**Reducer** 352-315, -320, -330



**Spray viscosity at 20°C** DIN 4: 18-20 s

**Potlife at 20°C** 2 h

**Application:** **Compliant - gravity feed cup** **HVLV spray gun** **Suction cup** **Airless/ Airmix** **Pressure pot dbl.-pump**

<b>Application pressure</b>	2.2-2.5 bar	2 bar
<b>Nozzle size</b>	1.2-1.4	1.5
<b>Number of coats</b>	2	2
<b>Flash off at 20°C</b>	mat	mat
<b>Film thickness</b>	40-50 µm	



**Drying** **Overcoatable** **Tack-free** **Ready for masking** **Ready to assemble** **Sandable**

	Min.	Max.
<b>Object Temp. 20°C</b>	8 h	
<b>Object Temp. 60°C</b>	30 min	

**Safety advice:**

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

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# 924-50

Glasurit CV clear coat extreme mat



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We create chemistry

**Remark**

Pre-spray 1 light coat, flash off until mat and then apply the second coat wet for flow and levelling. Gloss level will be influenced by many parameters, such as film thickness, drying condition, color, humidity and ambient temperature, flash off between coats and before oven drying, etc.

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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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**Safety advice:**

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

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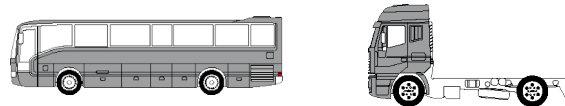
# 924-68

HS 2K CV clear coat



A brand of BASF –  
We create chemistry

**Application:**



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

**Key Features:**

- suitable for large areas / surfaces
- good leveling
- excellent UV resistance
- outstanding application characteristics
- excellent gloss level

**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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<b>Spreading rate</b>	505 m <sup>2</sup> /l at 1 µm
<b>Solid Content</b>	~ 61 % (RFU~56%)

**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.

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# 924-68

HS 2K CV clear coat



A brand of BASF –  
We create chemistry



**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

**Potlife at 20°C** 2 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLV spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar		2.5 bar
<b>Material pressure</b>					0.8-1.5 bar
<b>Nozzle size</b>	1.3-1.4	1.5	1.7		1-1.1
<b>Voltage</b>					50-80 kV
<b>Number of coats</b>	1.5	1.5	1.5		1.5
<b>Flash off at 20°C</b>	without	without	without		without
<b>Film thickness</b>	40-60 µm				

**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.

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# 924-68

HS 2K CV clear coat



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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 (drying at room temperature).

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.

**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.

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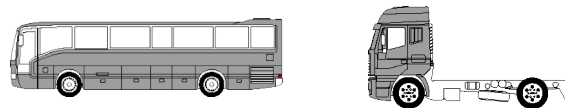
# 924-268

Glasurit CV Performance clear coat



A brand of BASF –  
We create chemistry

**Application:**



busses, sign writing, boxes, bus repair

**Key Features:**

- suitable for large areas / surfaces
- superior finish
- very smooth levelling features
- good anti-graffiti properties
- excellent UV resistance
- perfectly suitable as protective clearcoat for daylight colors
- outstanding application characteristics
- very high gloss level

**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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**Spreading rate** 496 m<sup>2</sup>/l at 1 µm

**Solid Content** ~ 61 % (RFU~56%)

**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.

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# 924-268

Glasurit CV Performance clear coat



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	<b>Mixing Ratio</b>	3 : 1 : 1 by volume
	<b>Hardener</b>	922-138, -139, -136
	<b>Reducer</b>	352-320, -330, -340
	<b>Spray viscosity at 20°C</b>	DIN 4: 18-20 s
	<b>Potlife at 20°C</b>	2 h

Application:	<b>Compliant - gravity feed cup</b>	<b>HVLP spray gun</b>	<b>Suction cup</b>	<b>Airless/ Airmix</b>	<b>Pressure pot dbl.-pump</b>
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar		2.5 bar
<b>Material pressure</b>					0.8-1.5 bar
<b>Nozzle size</b>	1.3-1.4	1.5	1.7		1-1.1
<b>Voltage</b>					50-80 kV
<b>Elect. Resistance</b>					600-1,500 Ω
<b>Number of coats</b>	1.5	1.5	1.5		1.5
<b>Flash off at 20°C</b>	without	without	without		without
<b>Film thickness</b>	40-60 µm				

**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.

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# 924-268

Glasurit CV Performance clear coat



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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.  
As clear coat on Glasurit Daylight Colors: 2 full spray coats (with 10 min flash off between coats).  
Recoatable with itself for up to 16 hours after application (drying at room temperature).

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.

**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.

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# 568-17

CV multi color and drying additive

**Application:**



cabs (refurbishing), boxes, busses (repair), sign writing  
this product is used in:

- 284-13
- 284-45
- 924-68
- 68 Line PLUS (except Basic topcoat)

**Key Features:**

- good leveling
- fast to assemble
- quick-drying for multicolor painting with 68 Line PLUS (except Basic topcoat)

**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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**Drying**

**Remark**

Use adhesion promoter 284-10 after 8 h at 20°C or oven drying.  
The maximum amount of 568-17 should only be 50% of the used reducer (premix of 568-17 and 352-... 1:1).

**Safety advice:**

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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# 568-17

CV multi color and drying additive



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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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**Safety advice:**

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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# 568-20

HAFLEX Additive (Adhesion promotor plastic)

**Application:**



plastic painting

**Key Features:**

- adhesion promotor for PP- / PE-blends
- high efficiency
- use for example in 284-45

**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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**Solid Content** 7 %



**Drying**

**Remark**

Best adhesion on PP- & PE-blends is achieved if 568-20 is used directly on the substrate with one spray coat (not VOC-compliant), follow a flash off time of 10 - 15min between 568-20 and application of filler 284-45.

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 individually.

**Safety advice:**

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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# 568-20

HAFLEX Additive (Adhesion promotor plastic)



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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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#### **Safety advice:**

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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# 568-96

Express Reducer for 9-7

**Application:**

This product is used in 9-7.

**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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**Solid Content** 10 %



**Drying**

**Overcoatable**

**Tack-free**

**Ready for masking**

**Ready to assemble**

**Sandable**

Min. Max.

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.

**Safety advice:**

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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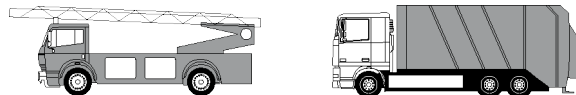


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# 568-405

CV Texture Additive

**Application:**



All applications, structure effect  
This product is used in 68 Line PLUS.

**Key Features:**

- suitable for large areas / surfaces
- different structure effects can be achieved

**Remarks:**

The substrate should be clean, free of dust, rust, oil and grease. Mixing ratio for 68 Line PLUS and 568-405: max. 1 : 1.

**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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**Solid Content** 41 %



**Drying**

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.

**Safety advice:**

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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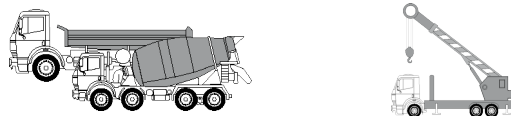


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We create chemistry

# 568-407

## CV Brush- and Roll Additive

### Application:



all applications  
this product is used in 68 Line PLUS (except Basic)

### Key Features:

- allows application of the top coat with brush or roller
- suitable on all Glasurit CV primer filler and filler
- good leveling

### 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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**Solid Content** 5 %

### Handling



2 - 3 applications with brush or roll. Intermediate drying 3 h 20°C.



**Drying**

### Safety advice:

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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# 568-407

CV Brush- and Roll Additive



A brand of BASF –  
We create chemistry

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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## Safety advice:

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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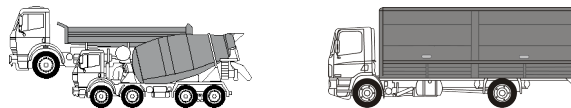


A brand of BASF –  
We create chemistry

# 568-408

CV Primer Tinting Paste, black

**Application:**



All applications  
This product is used in:  
9-7, 284-13, 284-1870, 284-90, 284-45, 284-58E, 284-60, 801-715.

**Key Features:**

- brilliant top coat appearance
- colour strength
- can be used in all PUR and EP primer and filler

**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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**Solid Content** 56 %



**Drying**

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.

**Safety advice:**

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

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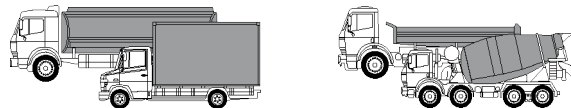
# 568-409

Airless Additive



A brand of BASF –  
We create chemistry

**Application:**



all applications  
this product is used in 924-68, 924-268

**Key Features:**

- prevents foam formation during the airless application of Glasurit CV clear coats
- 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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**Solid Content** 13 %



**Drying**

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.

**Safety advice:**

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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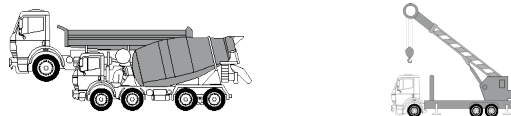
# 568-412

CV Thix Additive



A brand of BASF –  
We create chemistry

**Application:**



this product is used in 68 Line PLUS (except Basic topcoat)

**Key Features:**

- improves sagging resistance of 68 Line PLUS (except Basic topcoat) on objects with difficult geometry
- better edge covering on sharp edges / screws / rivets etc..
- exchange 568-412 one to one with reducer 352-
- good levelling and topcoat finish

**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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**Solid Content** 14 %



**Drying**

**Remark**

68 Line PLUS with 568-412 is due to its slow evaporation rate suitable for large areas and vehicles, at higher temperature 922-139 is recommend. For colors with less performance regarding edge covering apply one thin but covered spray coat, follow flash off time and a second spray coat. Follow recommended grey shade for colors to be applied.

**Safety advice:**

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# 568-412

CV Thix Additive



A brand of BASF –  
We create chemistry

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# TECHNICAL INFORMATION

## Overview of Glasurit CV Painting Processes

### Which painting processes are suitable for which vehicle with 68 Line topcoat

CV 1	Aluminium vehicles 2-layer with 68 Line
CV 1.1	Aluminium vehicles 3-layer wet-on-wet
CV 1.2	Busses, firefighting trucks 3-layer sanded
CV 2	Aluminium vehicles 2-layer
CV 2.1	Busses, firefighting trucks
CV 2.2	Commercial vehicles 2-layer system with 68 Line
CV 3	Chassis painting
CV 3.1	2K-Chassis painting: DTM or 2-layer
CV 3.2	Chassis and Transport
CV 4	Chassis and Transport
CV 5	Cab color change
CV 6	Chassis color change
CV 7	Powder-coated profiles
CV 8	Multi-color painting
CV 9	Daylight Colors
CV 10	Spray body filler
CV 11	Textured Paint (firefighting trucks)

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# TECHNICAL INFORMATION

## Overview of Glasurit CV Painting Processes

### Which painting processes are suitable for which vehicle with basecoats of 90 Line and 100 Line

CV 12	Commercial vehicles 2-layer system with 90CV PLUS
CV 13	Commercial vehicles 3-layer system with 90CV PLUS
CV 14	Commercial vehicles 2-layer system with 90CV PLUS
CV 15	Commercial vehicles 3-layer system with 90CV PLUS
CV 16	Commercial vehicles Low VOC painting process WB basecoat Glasurit 100 Line on 284-60
CV 17	Commercial vehicles Low VOC painting process WB basecoat Glasurit 100 Line on 801-715 and 284-45
CV 18	Commercial vehicles Low VOC painting process WB basecoat Glasurit 100 Line on 801-715
CV 19	Commercial vehicles Low VOC painting process WB basecoat Glasurit 100 Line on 283-1870 and 284-90

### CV Race 1 – 4 painting processes

CV Race 1	Repair
CV Race 2	Repair
CV Race 3	Repair
CV Race 4	Repair

#### Safety advice:

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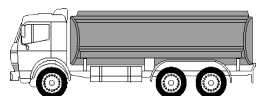
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# TECHNICAL INFORMATION

## CV 1 Aluminium vehicles 2-layer with 68 Line PLUS



**Application:** Painting of aluminium vehicles.

**Substrates:** Aluminium, steel or galvanised steel.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning							
<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	 100:3	 P80/P150				
<b>Primer filler</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235	Glasurit CV reducer medium 352-320	 4:1:1	 Gravity feed spray gun*	 2-2½ 20-25 µm	 at least 30 min 20°C max. 8 h 20°C	
<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	 4:1:1	 Gravity feed spray gun*	 1½ 40-60 µm	 30 min 60°C	or  overnight air drying (16 h 20°C)

\*See product data sheet for other equipment.

\*\*Please refer to product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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.

### Safety advice:

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# TECHNICAL INFORMATION

## CV 1.1 Aluminium vehicles 3-layer wet-on-wet



**Application:** Painting of aluminium vehicles.

**Substrates:** Aluminium, steel, galvanised steel, stainless (inox) steel.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning						
<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150			
<b>Primer</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235	Glasurit CV reducer medium 352-320	2:1 + 10-20%	Gravity feed spray gun*	1½-2 15-20 µm	at least 30 min 20°C
<b>Primer filler</b>	Glasurit CV Primer Filler, PU 284-90	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer medium 352-320	3:1 + 30%	Gravity feed spray gun*	2 50-70 µm	at least 1 h 20°C
<b>(alternatively: wet-on-wet process with 284-45)</b>							
<b>Filler</b>	Glasurit CV Filler, PUR 284-45	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer slow 352-330	2:1 + 10-30%	Gravity feed spray gun*	1½ 50-70 µm	1 h 20°C
<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	1½ 40-60 µm	30 min 60°C

\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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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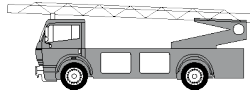
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# TECHNICAL INFORMATION

## CV 1.2 Busses, firefighting trucks 3-layer sanded



**Application:** Painting of high-performance vehicles like busses or firefighting trucks.

**Substrates:** Steel, galvanised steel, stainless (inox) steel, aluminium.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning							
<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150				
<b>Primer</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235	Glasurit CV reducer medium 352-320	2:1 + 10-20%	Gravity feed spray gun*	1½-2 15-20 µm	at least 30 min 20°C max. 8 h 20°C	
<b>Filler</b>	Glasurit CV Filler, PUR 284-45	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer slow 352-330	2:1 + 10%	Gravity feed spray gun*	2 70-90 µm	45 min 60°C object temperature	P400
<b>Note:</b> Seal sand-throughs with 1 coat of 283-1870.								
<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	1½ 40-60 µm	30 min 60°C	or  overnight air drying (16 h 20°C)

\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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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# TECHNICAL INFORMATION

## CV 2 Aluminium vehicles 2-layer



**Application:** Painting of Aluminium vehicles.

**Substrates:** Steel, galvanised steel, stainless (inox) steel, aluminium.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning						
<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	 100:3	 P80/P150			
<b>Primer filler</b>	Glasurit CV-EP primer filler 801-715	Glasurit CV EP hardener 965-715	Glasurit CV protective additive EP, slow 568-745	 4:1:1	 Gravity feed spray gun*	 2 50-70 µm	 1 h 20°C
<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	 4:1:1	 Gravity feed spray gun*	 1½- 40-60 µm	 30 min 60°C
							or Overnight air drying (16 h 20°C)

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

\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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.

### Safety advice:

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

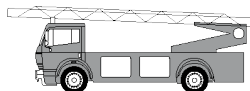
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# TECHNICAL INFORMATION

## CV 2.1 Busses, firefighting trucks



**Application:** Painting of high-performance vehicles like busses or firefighting trucks.

**Substrates:** Steel, galvanised steel, stainless (inox) steel, aluminium.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning								
<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150					
<b>Primer filler</b>	Glasurit CV-EP primer filler 801-715	Glasurit CV EP hardener 965-715	Glasurit CV protective additive EP, slow 568-745	4:1:1	Gravity feed spray gun*	2 50-70 µm	1 h 20°C		
<b>Filler</b>	Glasurit CV Filler, PUR 284-45	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer slow 352-330	2:1 + 10-30%	Gravity feed spray gun*	2 50-70 µm	1 h 20°C wet-on-wet	or  45 min 60°C object temperature for sanding	P400
<b>Note:</b>	Seal sand-throughs with 1 coat of 801-715								
<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	1½- 40-60 µm	30 min 60°C	or  Overnight air drying (16 h 20°C)	

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

\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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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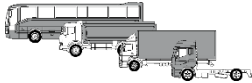
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# TECHNICAL INFORMATION

## CV 2.2 Commercial vehicles 2-layer system with 68 Line PLUS



**Application:** Painting of aluminium vehicles.

**Substrates:** Steel, galvanised steel, stainless (inox) steel, aluminium.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning
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<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	 100:3	 P80/P150
	Glasurit CV universal primer filler, grey 284-60	Glasurit CV undercoat hardener plus 922-220 PRO	Glasurit CV reducer 352-320, -330	 4:1:1  Gravity feed spray gun*  2 50-60 µm  1 h 20°C

Alternative: 284-58E Glasurit Eco Balance CV universal primer filler, white

or

<b>Primer filler sanding</b>	Glasurit CV universal primer filler, grey 284-60	Glasurit CV undercoat hardener plus 922-220 PRO	Glasurit CV reducer 352-320, -330	 5:1:1  Gravity feed spray gun*  2 60-70 µm  45 min 60°C	or	 overnight 20°C  P400
	Glasurit CV universal primer filler, grey 284-60	Glasurit CV undercoat hardener plus 922-220 PRO	Glasurit CV reducer 352-320, -330	 4:1:1  Gravity feed spray gun*  1½- 40-60 µm  30 min 60°C	or	 overnight air drying (16 h 20°C)

Alternative: 284-58E Glasurit Eco Balance CV universal primer filler, white

<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	 4:1:1  Gravity feed spray gun*  1½- 40-60 µm  30 min 60°C	or	 overnight air drying (16 h 20°C)
	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	 4:1:1  Gravity feed spray gun*  1½- 40-60 µm  30 min 60°C	or	 overnight air drying (16 h 20°C)

\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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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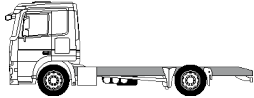
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# TECHNICAL INFORMATION

## CV 3 Chassis painting



**Application:** Chassis painting.

**Substrates:** Steel, aluminium.

<b>Pre-treatment</b>	Abrasive blast-cleaning							
<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150				
<b>Pre-prime aluminium chassis</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235	Glasurit CV reducer medium 352-320	2:1 + 10-20%	Gravity feed spray gun*	1½ 12-15 µm	20-30 min 20°C max. 8 h 20°C	
<b>Primer filler</b>	Glasurit 2K CV Chassis Filler, beige-grey 284-13	Glasurit 2K CV Filler hardener normal 922-18 Pro	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	2 60-70 µm	at least 60 min 20°C	or  30 min 60°C
<b>Alternative:</b>								
<b>Primer filler</b>	Glasurit CV Primer Filler, PU 284-90	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer medium 352-320	3:1 + 20%	Gravity feed spray gun*	2 50-70 µm	min 60 min 20°C	or  30 min 60°C
<b>Alternative:</b>								
<b>Primer filler</b>	Glasurit CV steel primer, grey-beige 9-7	Glasurit Express Reducer for 9-7 568-96	4:1	Gravity feed spray gun*	2 50-60 µm	at least 60 min 20°C	or  30 min 60°C	
<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	1½ 40-60 µm	30 min 60°C	or  overnight air drying (16 h 20°C)

\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

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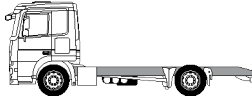
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# TECHNICAL INFORMATION

## CV 3.1 2K-Chassis painting: DTM or 2-layer



**Application:** Chassis painting.

**Substrates:** Steel, galvanised steel – 1- or 2-layer.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning
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<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150

### 1-layer-system:

<b>DTM Topcoat Step 1</b>	Glasurit CV Steel Primer Paste 568-46	Glasurit 68 Line	1:1					
<b>DTM Topcoat Step 2</b>	Glasurit Mixture Step 1	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	7:1 + 10-15%	Gravity feed spray gun*	2 wet-on-wet 70-100 µm	30 min 60°C object temp.	or  overnight air drying

### 2-layer-system:

<b>Chassisfiller Step 1</b>	Glasurit CV Steel Primer Paste 568-46	Glasurit 68 Line	7:3					
<b>Chassisfiller Step 2</b>	Glasurit Mixture Step 1	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	7:1 + 15-25%	Gravity feed spray gun*	2 wet-on-wet 60-70 µm	60 min 20°C	or  30 min 60°C object temp.
<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	1½ 40-60 µm	30 min 60°C	or  overnight air drying (16 h 20°C)

<b>Remark</b>	To cover the roughness of the sand blasted areas the above-mentioned film thickness has to be achieved.
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\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**Please note:** For automotive refinishing, 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.

#### Safety advice:

The products are suitable for professional use only.

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# TECHNICAL INFORMATION

## CV 3.2 Chassis and Transport



**Application:** Chassis painting.

**Substrates:** Steel (blasted), aluminium, galvanised steel parts.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning
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<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150
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<b>UHS Primer filler</b>	Glasurit CV UHS Primer Filler PUR, white 284-55	Glasurit CV UHS hardener 922-55 PRO	3:1	Airmix*	1½-2 60-70 µm	60 min 20°C	or	30 min 60°C
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<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	1½ 40-60 µm	30 min 60°C	or	overnight air drying (16 h 20°C)
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\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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.

### Safety advice:

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

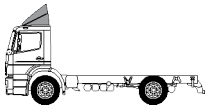
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# TECHNICAL INFORMATION

## CV 4 Chassis and Transport



**Application:** Application of plastic parts of commercial vehicles.

**Substrates:** Various plastic types.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning
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**Plastics: \*\*** ABS, ASA, PC, PC-PBT, PC/ABS, GRP, SMC, DCPD, PVC, PUR, PMMA, PPE-PA

<b>Filler</b>	Glasurit CV Filler, PUR 284-45	Glasurit Body filler hardener 922-180 Pro	Glasurit CV reducer 352-320, -330	2:1 + 10-30%	Gravity feed spray gun*	1½-2 40-60 µm	60 min 20°C	or	30 min 60°C
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**Plastics: \*\*** PP-blends, PE-blends, TPO-blends \*\*\*

<b>Filler</b>	Glasurit CV Filler, PUR 284-45	Glasurit Body filler hardener 922-180 Pro	Glasurit HAFLEX Additive (Adhesion promotor plastic) 568-20	2:1 + 30%	Gravity feed spray gun*	1½-2 40-50 µm	60 min 20°C	or	30 min 60°C
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<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer 352-320, -330	4:1:1	Gravity feed spray gun*	1½ 40-60 µm	overnight air drying (16 h 20°C)	or	30 min 60°C
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\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

<b>Remark</b>	<p>** Due to different raw material suppliers, the quality of the different plastics can differ from time to time. Therefore, the adhesion should be checked before painting.</p> <p>*** Adhesion on PP or PE blends cannot be guaranteed. Certain pre-treatments such as flaming, plasma or corona will help to improve adhesion. Application of one spray coat pure 568-20 (not VOC compliant) as adhesion promoter onto the substrate (before 284-45) could also help to improve adhesion characteristics.</p>
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**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.

**Safety advice:**

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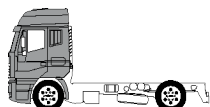
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# TECHNICAL INFORMATION

## CV 5 Cab color change



**Application:** Cab color change.

**Substrates:** Old paintwork.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning
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<b>Adhesion promoter</b>	Glasurit CV transparent sealer 284-10	Glasurit 2K CV Filler hardener normal 922-18 Pro	Glasurit CV reducer medium 352-320	2:1 + 30%	Gravity feed spray gun*	1 app. 20-25 µm	at least 15 min 20°C max. 2 h
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Alternative to 284-10: 284-45 (see product data sheet)

<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	1½ 40-60 µm	30 min 60°C object temperature	or  overnight air drying (16 h 20°C)
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\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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.

### Safety advice:

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

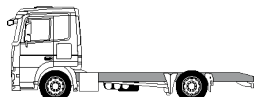
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# TECHNICAL INFORMATION

## CV 6 Chassis color change



**Application:** Chassis color change.

**Substrates:** Old paintwork, factory finish.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning						
<b>Note</b>	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.						
<b>Adhesion promoter (not on bare metal)</b>	Glasurit CV transparent sealer 284-10	Glasurit 2K CV Filler hardener normal 922-18 Pro	Glasurit CV reducer medium 352-320	2:1 + 30%	Gravity feed spray gun*	1 app. 20-25 µm	at least 15 min 20°C max. 2 h
	or						
<b>Adhesion promoter</b>	Solvent-sensitive factory finish	Glasurit CV steel primer, grey-beige 9-7	Glasurit Express Reducer for 9-7 568-96	4:1	Gravity feed spray gun*	1 20-30 µm	at least 60 min 20°C
	or						
<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	1½ 40-60 µm	30 min 60°C object temperature
	or						
							overnight air drying (16 h 20°C)

\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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.

### Safety advice:

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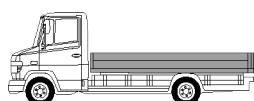
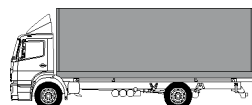
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# TECHNICAL INFORMATION

## CV 7 Powder-coated profiles



**Application:** All kind of precoated profiles and boxes.

**Substrates:** Powder coated substrates.

<b>Pre-treatment</b>	Cleaning – Sanding – Cleaning
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<b>Filler</b>	Glasurit CV Filler, PUR 284-45	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer medium 352-320	2:1 + 30%	Gravity feed spray gun*	1 app. 30 µm	min 30 min 20°C or max. 72 h
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Alternative product to 284-45: 284-10 CV transparent sealer (see product data sheet)

<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	1½ 40-60 µm	30 min 60°C	or  overnight air drying (16 h 20°C)
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\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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.

### Safety advice:

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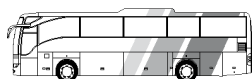
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# TECHNICAL INFORMATION

## CV 8 Multi-color painting



**Application:** Sign writing, multi-color painting with 68 Line and 568-17 CV multi color and drying additive.

**Substrates:** CV primer filler / filler and old paintwork.

<b>Substrates</b>	<b>With adhesion promoter:</b> Sanded, well-cured old paintwork
	<b>Without adhesion promoter:</b> 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 P400 and cleaned with 541-68!

<b>Adhesion promoter</b>	Glasurit CV transparent sealer 284-10	Glasurit CV hardener fast 922-16 Pro	Glasurit CV reducer extra fast 352-310	2:1 + 30%	Gravity feed spray gun*	1 app. 20-25 µm	at least 15 min 20°C max. 2 h

<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line***	Glasurit CV topcoat hardener 922-138, -136	Glasurit CV multi color and drying additive 568-17	4:1:1	Gravity feed spray gun*	1½-2 40-60 µm	Tape resistant after 2 h 20°C Potlife max. 30 min

\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

\*\*\*After 16 h air drying use adhesion promoter 284-10 CV transparent sealer!

**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.

### Safety advice:

The products are suitable for professional use only.

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

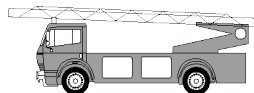
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# TECHNICAL INFORMATION

## CV 9 Daylight Colors



**Application:** Glasurit Fluorescent Paint.

**Substrates:** All CV primer filler / filler, old paint work coated with 284-45 or 284-90.

<b>Pre-treatment</b>	Cleaning - Sanding - Cleaning								
<b>Primer</b>	See painting process for the vehicle to be finished.								
<b>Filler</b>	Glasurit CV Filler, PUR 284-45	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer slow 352-330	 2:1 + 10-30%	 Gravity feed spray gun*	 1½ 50-70 µm	 1 h 20°C	or	 30 min 60°C object temperature
	<b>Alternative to 284-45:</b>								
<b>Filler</b>	Glasurit CV Primer Filler, PU 284-90	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer medium 352-320	 3:1 + 30%	 Gravity feed spray gun*	 2 50-70 µm	 1 h 20°C	or	 30 min 60°C
	<b>Daylight Colors</b> RAL 1026/00T RAL 2005/00T RAL 3024/00T	Glasurit Clear 923-	Glasurit HS - normal hardener 929-93	Glasurit CV reducer medium 352-320	 4:1 + 10%	 Gravity feed spray gun*	 4-5 min 100 µm	 drying overnight 20°C	or
<b>Clearcoat / Protective Clear ***</b>		Glasurit CV Performance clear coat 924-268	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer 352-320, -330	 3:1:1	 Gravity feed spray gun*	 2 50-70 µm	 45 min 60°C	or

\*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 924-268 as protective coat / clear coat.

**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.

### Safety advice:

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

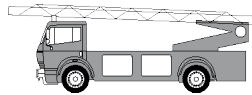
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# TECHNICAL INFORMATION

## CV 10 Spray body filler



**Application:** Painting process for extensive body filling.

**Substrates:** Steel, galvanised steel, stainless (inox) steel, aluminium, powder-, coil-coated surfaces, plywood, GRP, SMC old paintwork.

<b>Pre-treatment</b>	Cleaning - Sanding - Cleaning
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<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150
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### 1.1 Aluminium, stainless steel (inox), galvanised steel:

<b>Primer</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235	Glasurit CV reducer medium 352-320	2:1 + 10-20%	Gravity feed spray gun*	1½ 12-15 µm	min 20-30 min 20°C max. 8 h 20°C
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### 1.2 Steel

<b>Primer filler</b>	Glasurit 2K CV Chassis Filler, beige-grey 284-13	Glasurit 2K CV Filler hardener normal 922-18 Pro	Glasurit CV reducer medium 352-320	4:1:1	Gravity feed spray gun*	1 full coat app. 30-40 µm	30 min 60°C
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**2** Application of 839-180 on primed substrates as mentioned in 1.1 and 1.2 (not directly on 283-1870) or directly on the following substrates: aluminium, powdercoating, coil coating, plywood, GRP, SMC, old paintwork

<b>CV Spray body filler</b>	Glasurit CV spray body filler, grey 839-180	Glasurit Spray body filler hardener G-H-115	Glasurit CV reducer extra fast 352-310	100:5 additional 352-50 if required, max. 2% by weight	Gravity feed spray gun*	3-8 200-1000 µm	3-4 h 20°C	or  30 min 60°C
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\*See product data sheet for other equipment.

<b>3</b>	<b>Further process steps:</b> Use the undercoat materials and topcoats as described in the painting process of the corresponding vehicle
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**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.

#### Safety advice:

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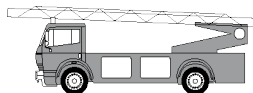
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# TECHNICAL INFORMATION

## CV 11 Textured Paint (firefighting trucks)



**Application:** Painting of high-performance vehicles like firefighting trucks with textured paint.

**Substrates:** PU-primer filler or PU-filler.

<b>Pre-treatment</b>	Cleaning - Sanding - Cleaning							
<b>Primer</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235	Glasurit CV reducer medium 352-320	 2:1 + 10-20%	 Gravity feed spray gun*	 2 12-15 µm	 min 20-30 min 20°C max. 8 h 20°C	
<b>Primer filler</b>	Glasurit CV Primer Filler, PU 284-90	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer medium 352-320	 3:1 + 30%	 Gravity feed spray gun*	 2 50-70 µm	 1 h 20°C	or 30 min 60°C
<b>Textured Filler</b> Pre-mix 284-99 with topcoat 68 Line before adding hardener (90:10), same color	Glasurit CV Texture Filler, ACR, transparent 284-99	Glasurit CV topcoat hardener normal 922-138	 8:1	 Pressure pot* nozzle size 1,6-2,5 material pressure app. 1,0-1,5 bar atomisation pressure app. 0,5-1,5 bar	 1-2	 60 min 20°C or 30 min 60°C		
<b>Topcoat 68 Line PLUS Efficient**</b>	Glasurit 68 Line	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer medium 352-320	 4:1: 0,5-1	 Gravity feed spray gun*	 1½ 40-60 µm	 30 min 60°C object temperature	or overnight air drying (16 h 20°C)

\*See product data sheet for other equipment.

\*\*Please refer to the product data sheets of 68 Line PLUS Supreme, High Build or Basic for mixing ratios, drying parameters etc.

**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.

### Safety advice:

The products are suitable for professional use only.

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

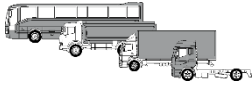
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# TECHNICAL INFORMATION

## CV 12 Commercial vehicles 2-layer system with 90CV PLUS



**Application:** Painting of aluminium vehicles.

**Substrates:** Steel, galvanised steel, stainless (inox) steel, aluminium.

<b>Pre-treatment</b>	Cleaning - Sanding - Cleaning
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<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	 100:3	 P80/P150
	Glasurit CV universal primer filler, grey 284-60	Glasurit CV undercoat hardener plus 922-220 Pro	Glasurit CV reducer 352-320, -330	 4:1:1  Gravity feed spray gun*  2 50-60 µm  1 h 20°C

Alternative: 284-58E

Or

<b>Primer filler sanding</b>	Glasurit CV universal primer filler, grey 284-60	Glasurit CV undercoat hardener plus 922-220 Pro	Glasurit CV reducer 352-320, -330	 5:1:1  Gravity feed spray gun*  2 60-70 µm  45 min 60°C	or	 overnight 20°C	 P400
	Glasurit Basecoat metallics/solids 90-M 4 CV PLUS	Glasurit Adjusting Base 93-E 3 CV PLUS		 2:1 stir immediately  HVLP* 1.5  2 1/2 10-15 µm  Flash off until mat after each spray coat			

Alternative: 284-58E

<b>Basecoat 90CV PLUS (90-M 4 CV PLUS)</b>	Glasurit Basecoat metallics/solids 90-M 4 CV PLUS	Glasurit Adjusting Base 93-E 3 CV PLUS	 2:1 stir immediately  HVLP* 1.5	 2 1/2 10-15 µm  1: one thin coherent coat, not hiding 2: second coat wet, hiding 3: 1/2 coat to match the effect	 Flash off until mat after each spray coat
	Glasurit CV Performance clear coat 924-268	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer slow 352-330	 3:1:1  Gravity feed spray gun*  1 1/2-2 50-60 µm  30 min 60°C	or

**Important** The basecoat must always be applied from the bottom to the top in horizontal stripes of approx. 1 metre width. To match the effect, distance of at least 50 cm.

<b>Clear coat</b>	Glasurit CV Performance clear coat 924-268	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer slow 352-330	 3:1:1  Gravity feed spray gun*  1 1/2-2 50-60 µm  30 min 60°C	or	 16 h 20°C
	Glasurit CV universal primer filler, grey 284-60	Glasurit CV undercoat hardener plus 922-220 Pro	Glasurit CV reducer 352-320, -330	 5:1:1  Gravity feed spray gun*  2 60-70 µm  45 min 60°C		

Alternative: 924-68

\*See product data sheet for other equipment.

**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.

### Safety advice:

The products are suitable for professional use only.

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

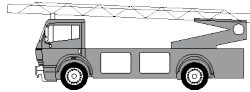
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# TECHNICAL INFORMATION

## CV 13 Commercial vehicles 3-layer system with 90CV PLUS



**Application:** Coaches, firefighting vehicles.

**Substrates:** Steel, galvanised steel, stainless (inox) steel, aluminium.

<b>Pre-treatment</b>	Cleaning - Sanding - Cleaning						
<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150			
<b>Primer filler</b>	Glasurit CV EP primer filler 801-715	Glasurit CV EP hardener 965-715	Glasurit CV protective additive EP, slow 568-745	4:1:1	Gravity feed spray gun*	2 50-70 µm	1 h 20°C
<b>Filler</b>	Glasurit CV Filler, PUR 284-45	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer slow 352-330	2:1 + 10-30%	Gravity feed spray gun*	2 50-70 µm	1 h 20°C wet on wet
						or	45 min 60°C object temperature for sanding
							P400
<b>Note:</b>	Seal sand-throughs with 1 coat of 801-715.						
<b>Basecoat 90CV PLUS (90-M 4 CV PLUS)</b>	Glasurit Basecoat metallics/solids 90-M 4 CV PLUS	Glasurit Adjusting Base 93-E 3 CV PLUS	2:1 stir immediately	HVLP* 1,5	2½ 10-15 µm	1: one thin coherent coat, not hiding 2: second coat wet, hiding 3: ½ coat to match the effect	Flash off until mat after each spray coat
<b>Important:</b>	The basecoat must always be applied from the bottom to the top in horizontal stripes of approx. 1 metre width. To match the effect, distance of at least 50 cm.						
<b>Clear coat</b>	Glasurit CV Performance clear coat 924-268	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer slow 352-330	3:1:1	Gravity feed spray gun*	1½-2 50-60 µm	30 min 60°C
						or	16 h 20°C

**Alternative:** 924-68

\*See product data sheet for other equipment.

**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.

**Safety advice:**

The products are suitable for professional use only.

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

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.

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# TECHNICAL INFORMATION

## CV 14 Commercial vehicles 2-layer system with 90CV PLUS



**Application:** Commercial vehicles.

**Substrates:** Steel, galvanised steel, stainless steel, aluminium.

**Pre-treatment** Cleaning - Sanding - Cleaning

<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150
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<b>Primer filler</b>	Glasurit CV EP primer filler 801-715	Glasurit CV EP hardener 965-715	Glasurit CV protective additive EP, slow 568-745	4:1:1	Gravity feed spray gun*	2 50-70 µm	1 h 20°C for wet-on- wet	or	overnight 20°C for sanding	P400	or	50-60 min 60°C object temp. for sanding	P400
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**Note:** Seal sand-throughs with 1 coat of 801-715.

<b>Basecoat 90CV PLUS (90-M 4 CV PLUS)</b>	Glasurit Basecoat metallics/solids 90-M 4 CV PLUS	Glasurit Adjusting Base 93-E 3 CV PLUS	2:1 stir immediately	HVLP* 1,5	2½ 10-15 µm	Flash off until mat after each spray coat
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1: one thin coherent coat, not hiding  
2: second coat wet, hiding  
3: ½ coat to match the effect

**Important:** The basecoat must always be applied from the bottom to the top in horizontal stripes of approx. 1 metre width. To match the effect, distance of at least 50 cm.

<b>Clear coat</b>	Glasurit CV Performance clear coat 924-268	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer slow 352-330	3:1:1	Gravity feed spray gun*	1½-2 50-60 µm	30 min 60°C	or	16 h 20°C
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**Alternative:** 924-68

\*See product data sheet for other equipment.

**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.

### Safety advice:

The products are suitable for professional use only.

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

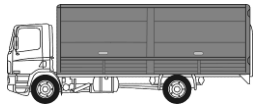
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# TECHNICAL INFORMATION

## CV 15 Commercial vehicles 3-layer system with 90CV PLUS



**Application:** Commercial vehicles.

**Substrates:** Steel, galvanised steel, stainless steel, aluminium.

<b>Pre-treatment</b>	Cleaning - Sanding - Cleaning						
<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150			
<b>Primer</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235	Glasurit CV reducer medium 352-320	2:1 + 10-20%	Gravity feed spray gun*	1½ – 2 15-20 µm	30 min 20°C
<b>Primer filler</b>	Glasurit CV Primer Filler, PU 284-90	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer medium 352-320	3:1 + 30%	Gravity feed spray gun*	2 50-70 µm	at least 60 min 20°C
<b>Alternative:</b>	284-45						
<b>Basecoat 90CV PLUS (90-M 4 CV PLUS)</b>	Glasurit Basecoat metallics/solids 90-M 4 CV PLUS	Glasurit Adjusting Base 93-E 3 CV PLUS	2:1 stir immediately	HVLP* 1,5	2½ 10-15 µm	1: one thin coherent coat, not hiding 2: second coat wet, hiding 3: ½ coat to match the effect	Flash off until mat after each spray coat
<b>Important:</b>	The basecoat must always be applied from the bottom to the top in horizontal stripes of approx. 1 metre width. To match the effect, distance of at least 50 cm.						
<b>Clear coat</b>	Glasurit CV Performance clear coat 924-268	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer slow 352-330	3:1:1	Gravity feed spray gun*	1½-2 50-60 µm	30 min 60°C
<b>Alternative:</b>	924-68						

\*See product data sheet for other equipment.

**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.

**Safety advice:**

The products are suitable for professional use only.

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

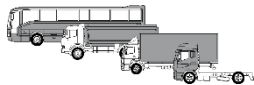
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# TECHNICAL INFORMATION

## CV 16 Commercial vehicles Low VOC painting process WB basecoat Glasurit 100 Line on 284-60



**Application:** Painting of commercial vehicles.  
**Substrates:** Steel, galvanised steel, stainless (inox) steel, aluminium.

**Pre-treatment** Cleaning - Sanding - Cleaning

<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	 100:3	 P80/P150			
	<b>Primer filler wet-on-wet</b>	Glasurit CV universal primer filler, grey 284-60	Glasurit CV undercoat hardener plus 922-220 PRO	Glasurit CV reducer 352-320, -330	 4:1:1	 Gravity feed spray gun	 2 50-60 µm

Alternative: 284-58E  
or

<b>Primer filler sanding</b>	Glasurit CV universal primer filler, grey 284-60	Glasurit CV undercoat hardener plus 922-220 PRO	Glasurit CV reducer 352-320, -330	 5:1:1	 Gravity feed spray gun	 2 60-70 µm	 45 min 60°C	or	 overnight 20°C	 P40
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Alternative: 284-58E

<b>Basecoat 100 Line</b>	Glasurit Basecoat 100 Line 100-M 10 (metallics) or 100-M 20 (solids)*	Glasurit Reducer 100-E 5	 2:1	 Compliant** 1,3-1,4	 1 full coat + 1 finish coat wet-on-wet	 Flash off until mat before clear coat application
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\*When using 100-M 10X (metallics), -M 20X (solids) in the mixing formula, 100-E 5X must be used, too.

\*When using 100-M 40 in the mixing formula, 100-E 40 must be used, too.

\*\*See Glasurit knowhow 100 Line for further info regarding equipment, mixing clear / reducer, cleaning, sanding, etc.

<b>Clear coat</b>	Glasurit CV Performance clear coat 924-268	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer slow 352-330	 3:1:1	 Gravity feed spray gun	 1 1/2 50-60 µm	 30 min 60°C	or	 16 h 20°C
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Alternative: 924-68

**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.

### Safety advice:

The products are suitable for professional use only.

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

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.

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# TECHNICAL INFORMATION

## CV 17 Commercial vehicles Low VOC painting process WB basecoat Glasurit 100 Line on 801-715 and 284-45



**Application:** Coaches or firefighting vehicles.

**Substrates:** Steel, galvanised steel, stainless (inox) steel, aluminium.

<b>Pre-treatment</b>	Cleaning - Sanding - Cleaning						
<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150			
<b>Primer filler</b>	Glasurit CV EP primer filler 801-715	Glasurit CV EP hardener 965-715	Glasurit CV protective additive EP, slow 568-745	4:1:1	Gravity feed spray gun	2 50-70 µm	1 h 20°C
<b>Filler</b>	Glasurit CV Filler, PUR 284-45	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer 352-330	2:1 + 10-30%	Gravity feed spray gun	2 50-70 µm	1 h 20°C wet-on-wet
						45 min 60°C object temperature for sanding	P400

**Note:** Seal sand-throughs with 1 coat of 801-715.

<b>Basecoat 100 Line</b>	Glasurit Basecoat 100 Line 100-M 10 (metallics) or 100-M 20 (solids)*	Glasurit Reducer 100-E 5	2:1	Compliant** 1,3-1,4	1 full coat + 1 finish coat wet-on-wet	Flash off until mat before application of clear coat
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\*When using 100-M 10X (metallics), -M 20X (solids) in the mixing formula, 100-E 5X must be used, too.

\*When using 100-M 40 in the mixing formula, 100-E 40 must be used, too.

\*\*See Glasurit knowhow 100 Line for further info regarding equipment, mixing clear / reducer, cleaning, sanding, etc.

<b>Clear coat</b>	Glasurit CV Performance clear coat 924-268	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer slow 352-330	3:1:1	Gravity feed spray gun	1 1/2-2 50-60 µm	30 min 60°C	or	16 h 20°C
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**Alternative:** 924-68

**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.

### Safety advice:

The products are suitable for professional use only.

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

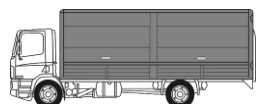
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# TECHNICAL INFORMATION

## CV 18 Commercial vehicles Low VOC painting process WB basecoat Glasurit 100 Line on 801-715



**Application:** Coaches or firefighting vehicles.

**Substrates:** Steel, galvanised steel, stainless (inox) steel, aluminium.

**Pre-treatment** Cleaning - Sanding - Cleaning

<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150
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<b>Primer filler</b>	Glasurit CV EP primer filler 801-715	Glasurit CV EP hardener 965-715	Glasurit CV protective additive EP, slow 568-745	4:1:1	Gravity feed spray gun	2 50-70 µm	1 h 20°C wet on wet	or	overnight 20°C for sanding	or	50-60 min 60°C object temperature for sanding	P400
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**Note:** Seal sand-throughs with 1 coat of 801-715.

<b>Basecoat 100 Line</b>	Glasurit Basecoat 100 Line 100-M 10 (metallics) or 100-M 20 (solids)*	Glasurit Reducer 100-E 5	2:1	Compliant** 1,3-1,4	1 full coat + 1 finish coat wet-on-wet	Flash off until mat before application of clear coat
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\*When using 100-M 10X (metallics), -M 20X (solids) in the mixing formula, 100-E 5X must be used, too.

\*\*When using 100-M 40 in the mixing formula, 100-E 40 must be used, too.

\*\*See Glasurit knowhow 100 Line for further info regarding equipment, mixing clear / reducer, cleaning, sanding, etc.

<b>Clear coat</b>	Glasurit CV Performance clear coat 924-268	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer slow 352-330	3:1:1	Gravity feed spray gun	1½-2 50-60 µm	30 min 60°C	or	16 h 20°C
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**Alternative:** 924-68

**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.

### Safety advice:

The products are suitable for professional use only.

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

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.

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# TECHNICAL INFORMATION

## CV 19 Commercial vehicles Low VOC painting process WB basecoat Glasurit 100 Line on 283-1870 and 284-90



**Application:** Commercial vehicles.  
**Substrates:** Steel, galvanised steel, stainless steel, aluminium.

**Pre-treatment** Cleaning - Sanding - Cleaning

<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	100:3	P80/P150					
<b>Primer</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235	Glasurit CV reducer medium 352-320	2 : 1 + 10-20%	Gravity feed spray gun	1½-2 15-20 µm	30 min 20°C		
<b>Primer filler</b>	Glasurit CV Primer Filler, PU 284-90	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer medium 352-320	3:1 + 30%	Gravity feed spray gun	2 50-70 µm	at least 60 min 20°C	or	30 min 60°C

Alternative: 284-45

<b>Basecoat 100 Line</b>	Glasurit Basecoat 100 Line 100-M 10 (metallics) or 100-M 20 (solids)*	Glasurit Reducer 100-E 5	2:1	Compliant** 1,3-1.4	1 full coat 15-20 µm 1 finish coat 25-30 µm wet-on-wet	Flash off until mat before application of clear coat			
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\*When using 100-M 10X (metallics), -M 20X (solids) in the mixing formula, 100-E 5X must be used, too.

\*\*When using 100-M 40 in the mixing formula, 100-E 40 must be used, too.

\*\*See Glasurit knowhow 100 Line for further info regarding equipment, mixing clear / reducer, cleaning, sanding, etc.

<b>Clear coat</b>	Glasurit CV Performance clear coat 924-268	Glasurit CV topcoat hardener normal 922-138	Glasurit CV reducer slow 352-330	3:1:1	Gravity feed spray gun	1½-2 50-60 µm	30 min 60°C	or	16 h 20°C
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Alternative: 924-68

**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.

### Safety advice:

The products are suitable for professional use only.

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

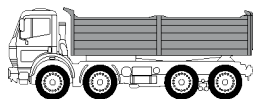
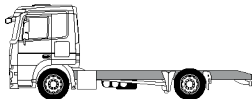
For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.

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# TECHNICAL INFORMATION

## CV Race 1 Repair



**Application:** Chassis painting with 2K Chassissurfacer.

**Substrates:** Steel, aluminium.

<b>Pre-treatment</b>	Cleaning - Sanding - Cleaning
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<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	 100:3	 P80/P150
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<b>Primer only for aluminium</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235**	Glasurit CV reducer extra fast 352-310	 2:1 + 10-20%	 Gravity feed spray gun*	 1 1/2-2 12-15 µm	 min. 20-30 min 20° max. 8 h 20°C
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\*\*Depending on size, object, and ambient temperature, 352-235 can be replaced by P-H-120 if needed.

<b>Chassis- surfacer</b>	Glasurit CV Chassis Filler, beige-grey 284-13	Glasurit 2K CV Filler hardener normal 922-18 Pro	Glasurit CV multi color and drying additive 568-17	Glasurit CV reducer extra fast 352-310	 4:1:0.5:0.5	 Gravity feed spray gun*	 2 60-70 µm	 at least 30 min 20°C
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<b>Topcoat 68 Line PLUS - Efficient - Supreme - High Build</b>	Glasurit 68 Line	Glasurit CV topcoat hardener fast 922-136	Glasurit CV multi color and drying additive 568-17	 4:1:1 Potlife max. 30 min	 Gravity feed spray gun*	 1 1/2-2 40-60 µm	 2-3 h 20°C
--	---------------------	--	--	-------------------------------------	--------------------------------	-------------------------	-------------------

\*See product data sheet for other equipment.

**Remark:** The area to be painted should not exceed 3 m<sup>2</sup>.

**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.

### Safety advice:

The products are suitable for professional use only.

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

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.

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# TECHNICAL INFORMATION

## CV Race 2 Repair



**Application:** Repainting of boxes and busses.

**Substrates:** Steel, galvanised steel, stainless (inox) steel, powder- and coil-coated surfaces, plywood, GRP, SMC.

**Pre-treatment** Cleaning - Sanding - Cleaning

<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	 100:3	 P80/P150			
	<b>Primer filler</b>	Glasurit CV Primer Filler, PU 284-90	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer fast 352-315	 3:1 + 30%	 Gravity feed spray gun*	 1½-2 50-60 µm
<b>Topcoat 68 Line PLUS - Efficient - Supreme - High Build</b>	Glasurit 68 Line	Glasurit CV topcoat hardener fast 922-136	Glasurit CV multi color and drying additive 568-17	 4:1:1 Potlife max. 30 min	 Gravity feed spray gun*	 1½-2 40-60 µm	 2-3 h 20°C

\*See product data sheet for other equipment.

**Remark:** The area to be painted should not exceed 3 m².

**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.

### Safety advice:

The products are suitable for professional use only.

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

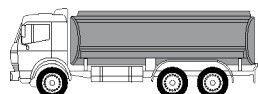
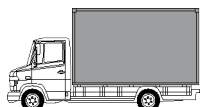
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# TECHNICAL INFORMATION

## CV Race 3 Repair



**Application:** Repainting of boxes and busses.

**Substrates:** Aluminium vehicles, hang-on parts made of steel or galvanised steel.

**Pre-treatment** Cleaning - Sanding - Cleaning

<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	 100:3	 P80/P150			
	<b>Primer filler</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235**	Glasurit CV reducer extra fast 352-310	 2:1 + 10-20%	 Gravity feed spray gun*	 2-2½ 20-25 µm
<b>Topcoat 68 Line PLUS - Efficient - Supreme - High Build</b>	Glasurit 68 Line	Glasurit CV topcoat hardener fast 922-136	Glasurit CV multi color and drying additive 568-17	 4:1:1 Potlife max. 30 min	 Gravity feed spray gun*	 1½-2 40-60 µm	 2-3 h 20°C

\*\*Depending on size, object, and ambient temperature, 352-235 can be replaced by P-H-120 if needed.

\*See product data sheet for other equipment.

**Remark:** The area to be painted should not exceed 3 m².

**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.

### Safety advice:

The products are suitable for professional use only.

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

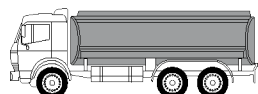
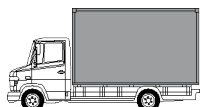
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# TECHNICAL INFORMATION

## CV Race 4 Repair



**Application:** Repainting of boxes and busses.

**Substrates:** Aluminium vehicles, hang-on parts made of steel or galvanised steel.

**Pre-treatment** Cleaning - Sanding - Cleaning

<b>Body filler (if required)</b>	Glasurit CV universal body filler, white 839-5	Glasurit Body filler hardener G-H-110	 100:3	 P80/P150				
					 2:1 + 10-20%	 Gravity feed spray gun*	 1½ 12-15 µm	 min 20 min 20° max. 8 h 20°C
<b>Primer filler</b>	Glasurit CV-Multi-Wash, beige 283-1870	Glasurit Activator long 352-235**	Glasurit CV reducer extra fast 352-310	 2:1 + 10-20%	 Gravity feed spray gun*	 1½ 12-15 µm	 min 20 min 20° max. 8 h 20°C	
					 2:1+ 20% +10%	 Gravity feed spray gun*	 2 50-70 µm	 30 min 20°C
<b>Surfacer</b>	Glasurit CV Filler, PUR 284-45	Glasurit CV filler hardener 922-180 Pro	Glasurit CV reducer slow 352-330	Glasurit CV multi color and drying additive 568-17	 2:1+ 20% +10%	 Gravity feed spray gun*	 2 50-70 µm	 30 min 20°C
					 4:1:1 Potlife max. 30 min	 Gravity feed spray gun*	 1½-2 40-60 µm	 2-3 h 20°C
<b>Topcoat 68 Line PLUS - Efficient - Supreme - High Build</b>	Glasurit 68 Line	Glasurit CV topcoat hardener fast 922-136	Glasurit CV multi color and drying additive 568-17	 4:1:1 Potlife max. 30 min	 Gravity feed spray gun*	 1½-2 40-60 µm	 2-3 h 20°C	
					 4:1:1 Potlife max. 30 min	 Gravity feed spray gun*	 1½-2 40-60 µm	 2-3 h 20°C

\*\*Depending on size, object, and ambient temperature, 352-235 replaced by P-H-120 if needed.

\*See product data sheet for other equipment.

**Remark:** The area to be painted should not exceed 3 m<sup>2</sup>.

**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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# TECHNICAL INFORMATION

## D 1 Which products for which substrates?

		Rawmaterial base	Steel	Galvanised steel*	Stainless steel	Aluminium	Anodised alum.	GRP/SMC	PP-EPDM	Glasurit CV-Primer	Glasurit CV-Primer-Filler / Filler	Powder	Coil-Coating	Plywood	Wood	Factory finish	Old paintwork
<b>Polyester-Body fillers</b>																	
CV Universal Body Filler	839-5	PE	●●	●●	○	●●		●			●	●	●	●	●●	●	●
CV Flexible Body Filler	839-15	PE	●●			●●		●			●	●	●	●	●●	●	●
CV Body Filler extra slow	839-7451	PE	●●			●●		●			●	●	●	●	●●	●	●
CV Spray Body Filler	839-180	PE	●			○		●●			●	●	●	●	●●	●●	●●
<b>Stone chip and underbody protection</b>																	
Underbody protection	1109-1240/4									●	●●					●●	●●
<b>Primer</b>																	
CV Shop Primer	183-153	PVB	●●	●●												●	●
<b>Primer Filler</b>																	
CV Steel Primer	9-7	EP-E	●●										○		○	●●	●●
CV Multi Wash	283-1870	PVB	●●	●●	●●	●●	●					○	○			○	○
CV 2K UHS Primerfiller	284-55	PUR	●●	●		●											
CV 2K Chassis Surfacers	284-13	PUR	●●	●				●●		●●		●	●	●●	●●	●	●●
Eco Balance CV universal primer filler	284-58E	PUR	●	●	●	●●	●	●●				●	●	●	●	●●	●●
CV universal primer filler	284-60	PUR	●	●	●	●●	●	●●				●	●	●	●	●●	●●
CV 2K PUR Primerfiller	284-90	PUR	●●	●●	●●	●	●	●●				●●	●●	●●	●●	●	●
CV HS EP Primerfiller, grey	801-715	EP	●●	●●	●●	●●	●	●●				●●	●●	●●	●●	●	●
Steel Primer Paste	568-46 / 70:30	PUR	●●	●●	●			●		●		●	●			●	●
<b>Surfacer</b>																	
CV Filler white	284-45	PUR						●●		●●	●●	●●	●●	●●	●●	●●	●●
CV Textured Filler	284-99	PUR						●●		●●	●●	●●	●●	●●	●●	●●	●●
<b>Adhesion promoter</b>																	
Transparent Sealer CV	284-10 CV	PUR						○		●●	●●	●●	●●	○	●●	●●	●●
284-45 with 568-20	568-20	PUR						●●	●●		●●	●●	●●	●●	●●	●●	●●
<b>DTM Topcoat</b>																	
Steel Primer Paste (DTM)	568-46 / 1:1	PUR	●●	●●	●			●			●	●	●			●	●

●● = very well suited      ● = well suited      ○ = suited in some cases (testing recommended)

\* = The adhesion on hot dipped galvanised steel has to be checked in advance.

For detailed information please see the Technical Information Sheet of the respective product.

### Key to abbreviations:

EP	=	epoxy / polyamine	PE	=	polyester
EP E	=	epoxy ester	PU	=	polyurethane / isocyanate
CP	=	copolymer	PU-AC	=	Polyurethan-Acrylat / Isocyanat
			PVB	=	polyvinyl butyral / phosphoric acid

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# TECHNICAL INFORMATION

## D 2 Tinting guide for 68 Line solid colors

Tinting direction	Color group									
	white	grey	yellow	beige	orange	red	bordeaux	brown	green	blue
lighter	T 002	T 002	T 002	T 002	T 002	T 002	T 002	T 002	T 002	T 002
dirtier	T 900	T 900	T 900	T 900	T 900	T 900	T 900	T 900	T 900	T 900
darker	T 900	T 900	T 900	T 900	T 200	T 330*	T 310	T 900	T 600	T 500 T 523
bluer	T 500 T 523	T 500 T 523	-	-	-	-	-	-	T 600	T 600
greener	T 600	T 600	T 600	T 600	-	-	-	-	T 600	T 600
yellower	T 100	T 100	T 141*	T 100	T 141*	T 141*	T 100	T 100	T 141*	-
more orange	T 120	T 120	T 230	T 230	T 230	T 230	T 230	T 230	-	-
redder	T 311	T 311	T 230	T 311	T 330*	T 330*	T 330*	T 311	-	T 340
more violet	T 340	T 340	-	T 340	-	T 340	T 310	T 340	-	T 420

Use only the mixing bases contained in the relevant mixing formula.

\* Do not use in low concentration!

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# TECHNICAL INFORMATION

## D 3 68 Line Tinting Bases

Tinting Base	Name	
	German	English
T 002	weiß	white
T 100	oxidgeb	oxide yellow
T 120	signalgeb	signal yellow
T 141	zitrusgeb	lemon yellow
T 144	sonnengeb	sun yellow
T 150	geb	yellow
T 200	hellorange	light orange
T 230	reinorange	pure orange
T 310	bordeaux	bordeaux
T 311	oxidrot	oxide red
T 320	dunkelrot	dark red
T 330	rot	red
T 340	weinrot	wine red
T 350	neonpink	neon pink
T 420	lila	lilac
T 500	dunkelblau	dark blue
T 523	mittelblau	medium blue
T 531	blau	blue
T 600	flaschengrün	bottle green
T 900	blauschwarz	bluish black
T 920	gelbschwarz	yellowish black
T 940	schwarz	black

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# TECHNICAL INFORMATION

## D 4 Main products and resin bases

Product	Resin base	Abbreviation
839-15	unsaturated polyester	UPE
839-5	unsaturated polyester	UPE
839-7451	unsaturated polyester	UPE
839-180	unsaturated polyester	UPE
9-7	epoxy ester	EP E
183-153	polyvinylbutyral	PVB
283-6150	polyvinylbutyral	PVB
283-1870	polyvinylbutyral	PVB
284-13	polyurethane	PU
284-90	polyurethane	PU
284-45	polyurethane	PU
284-55	polyurethane	PU
284-99	polyurethane	PU
284-10 CV	polyurethane	PU
801-715	epoxy	EP
568-46	polyurethane	PU
68-	polyurethane acrylate	PU AC
58-	polyurethane acrylate (gloss-reduced)	PU AC
90 CV PLUS	polyurethane, water-thinnable	PU, W
924-68	modified polyacrylate	PAC
924-168	modified polyacrylate	PAC

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# TECHNICAL INFORMATION

## D 5 Temperature table for Glasurit products

This table shows reference material combinations based on market experience. However, customer-specific parameters (e.g. spraybooth, objects to be painted or atomizing technique) may require different hardener / reducer combinations.

		Up to 15°C	from 15°C	from 20°C	from 25°C	from 30°C
9-7	Hardener					
	Reducer	568-96	568-96	568-96	568-96	568-96
283-1870	Hardener	352-235	352-235	352-235	352-235	352-235
	Reducer	352-315	352-320	352-320	352-330	352-330
801-715	Hardener	not	965-715	965-715	965-715	965-715
	Reducer	suitable	568-720	568-745	568-745	568-745
284-13	Hardener	922-16 PRO	922-18 PRO	922-18 PRO	922-18 PRO	922-18 PRO
	Reducer	352-315	352-320	352-330	352-330	352-340
284-90	Hardener	922-180 PRO	922-180 PRO	922-180 PRO	922-180 PRO	922-180 PRO
	Reducer	352-320	352-320	352-320	352-330	352-340
284-58E	Hardener	922-220 PRO	922-220 PRO	922-220 PRO	922-220 PRO	922-220 PRO
	Reducer	352-315	352-320E	352-320E	352-330	352-330
284-60	Hardener	922-220 PRO	922-220 PRO	922-220 PRO	922-220 PRO	922-220 PRO
	Reducer	352-315	352-320	352-320	352-330	352-330
284-45	Hardener	922-180 PRO	922-180 PRO	922-180 PRO	922-180 PRO	922-180 PRO
	Reducer	352-315	352-320	352-330	352-330	352-340
568-46	Hardener	922-136	922-138	922-138	922-138	922-138
	Reducer	352-315	352-320	352-320	352-330	352-340
568-46 (DTM)	Hardener	922-136	922-138	922-138	922-138	922-138
	Reducer	352-315	352-320	352-320	352-330	352-340
68 PLUS	Hardener	922-136	922-138	922-138	922-138	922-139
	Reducer	352-310	352-315	352-320	352-330	352-340
68-9006	Hardener	922-136	922-136	922-136	922-136	922-138
	Reducer	352-310	352-310	352-310	352-320	352-320
924-68	Hardener	922-136	922-138	922-138	922-138	922-138
	Reducer	352-315	352-320	352-330	352-330	352-340
924-268	Hardener	922-136	922-138	922-138	922-138	922-138
	Reducer	352-320	352-330	352-330	352-330	352-340

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# TECHNICAL INFORMATION

## D 6 Gloss levels with 68 Line PLUS

Product	Mixing ratio	Gloss unit [GU] at 20° angle
68 Line PLUS - CV Efficient Topcoat 568-M 135	According to TDS	~ 85 - 87
68 Line PLUS - CV Supreme Topcoat 568-M 200		~ 88 - 90
68 Line PLUS - CV High Build Topcoat 568-M 90		~ 81 - 83
68 Line PLUS - CV Basic Topcoat 568-M 80		~ 78 - 80
68 Line PLUS - CV Efficient Topcoat 568-M 135	68 Line PLUS topcoat Supreme, Efficient and High Build additionally mixed 5:1 with 568-M 124  → 5:1:1 with hardener and thinner	~ 63 - 68
68 Line PLUS - CV Supreme Topcoat 568-M 200		~ 69 - 73
68 Line PLUS - CV High Build Topcoat 568-M 90		~ 60 - 63
68 Line PLUS - CV Basic Topcoat 568-M 80	68 Line PLUS Basic topcoat additionally mixed 5:1 with 568-M 124 → 2:1 with premix hardener	~ 63 - 67
68 Line PLUS - CV Topcoat 568-M 124 matt	Use of mixing clear 568-M 124 only → 5:1:1 with hardener and thinner	~ 65 - 80 (at 60°)

### Used settings and process

Hardener: Based on hardener 922-138 and reducer 352-320 for Efficient, Supreme and High Build;  
for Basic Topcoat 568-M 80 Premix-hardener 922-815.

Application: Acc. to TDS, 10 min flash off before oven drying.

Drying: 30 min at 60°C

A lower gloss level as indicated in the matrix above cannot be achieved with the following mixing clears:

- 68 Line PLUS Supreme (568-M 200)
- 68 Line PLUS High Build (568-M 90)
- 68 Line PLUS Basic (568-M 80)

Lower gloss levels can only be obtained by using 68 Line PLUS Efficient based on mixing clear 568-M 124.

For further information on different gloss levels refer to Refinity, ICCM or Glasurit Color Online which contain semi-glossy, semi-matt and matt mixing formulas.

### Gloss measuring:

According to ISO 2813 the gloss is measured at 60° angle as first step. If the value exceeds 70 gloss units [GU], the measuring angle is reduced to 20°. Is it below 10 GU, the angle is increased to 85°.

Between 10 and 70 GU the measured value of 60° is used.

Many factors can influence the achieved gloss level: Film thickness, color, hardener, thinner, application process, flash off times, drying.

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# TECHNICAL INFORMATION

## D 7 Painting of Plastics

### D 7.1 Painting of Plastics with 284-45

Plastic type	Recommended pretreatment	284-45 2:1+10-30% 922-180 PRO 352-330	284-45 2:1+30% 922-180 PRO 568-20	*1x 568-20 + 284-45 2:1+10-30% 922-180 PRO 352-330
ABS	P-P-41; Pad grey or P600; P-P-41	●●	●	●
ABS/PC	P-P-41; Pad grey or P600; P-P-41	●●	●●	●●
ASA	P-P-26; Pad grey or P600; P-P-31; alternative P-P-41	●●	●●	●●
PC	P-P-41; Pad grey or P600; P-P-41	●●	●●	●●
PC/PBT	P-P-41; Pad grey or P600; P-P-41	●●	●●	●●
GRP	P-P-41; Pad grey or P600; P-P-41 ***	●●	●●	●●
SMC	P-P-41; P400; P-P-41	●●		
DCPD	P-P-41; P400; P-P-41	●●		
PU-RIM	P-P-41; Pad grey or P600; P-P-41	●●	○	○
PUR soft**	P-P-41; Pad grey or P600; P-P-41 ***	●	●	-
PVC	P-P-41; Pad grey or P600; P-P-41	●●	●●	●●
PMMA	P-P-26; Pad grey or P600; P-P-31	●●	●●	●●
PPE-PA	P-P-41; Pad grey or P600; P-P-41	●●	●●	●●
TPO-blends ***	P-P-41; Pad grey or P600; P-P-41	-	○	●●
PP-blends ***	P-P-41; Pad grey or P600; P-P-41	-	●	●●
PE-blends ***	P-P-41; Pad grey or P600; P-P-41	-	○	●
PA	P-P-41; Pad grey or P600; P-P-41 ***	○	-	-
POM	-	-	-	-
PS	-	-	-	-

\* not VOC-compliant

\*\* Softface-Additive used in filler and topcoat

\*\*\* solventborne cleaning required (e.g. 360-68 or P-P-41)

- = very well suited
- = well suited
- = suited in some cases
- = not suitable
- empty = not tested

**In detail:** see painting process "Painting of Plastics."

**In general:** Due to different raw material suppliers, the quality of the plastics can vary from time to time. Therefore, the adhesion should be checked before painting.

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# TECHNICAL INFORMATION

## D 7 Painting of Plastics

### D 7.2 Painting of Plastics with 284-90

Plastic type	Recommended pretreatment	284-90 3:1+30% 922-180 PRO 352-330	284-90 3:1+30% 922-180 PRO 568-20	*1x 568-20 + 284-90 3:1+30% 922-180 PRO 352-330
ABS	P-P-41; Pad grey or P600; P-P-41	○	○	○
ABS/PC	P-P-41; Pad grey or P600; P-P-41	●●	●●	●●
ASA	P-P-26; Pad grey or P600; P-P-31; alternative P-P-41	●●	●●	●●
PC	P-P-41; Pad grey or P600; P-P-41	●●	●	●●
PC/PBT	P-P-41; Pad grey or P600; P-P-41	●	●	●
GRP	P-P-41; Pad grey or P600; P-P-41 ***	●●	●●	●●
SMC	P-P-41; P400; P-P-41			
DCPD	P-P-41; P400; P-P-41			
PU-RIM	P-P-41; Pad grey or P600; P-P-41	●●	○	○
PUR soft**	P-P-41; Pad grey or P600; P-P-41 ***	●	●	-
PVC	P-P-41; Pad grey or P600; P-P-41	●●	●●	●●
PMMA	P-P-26; Pad grey or P600; P-P-31	-	-	-
PPE-PA	P-P-41; Pad grey or P600; P-P-41	●●	●●	●●
TPO-blends ***	P-P-41; Pad grey or P600; P-P-41	-	○	○
PP-blends ***	P-P-41; Pad grey or P600; P-P-41	-	-	●
PE-blends ***	P-P-41; Pad grey or P600; P-P-41	-	-	○
PA	-	-	-	-
POM	-	-	-	-
PS	-	-	-	-

\* not VOC-compliant

\*\* Softface-Additive used in filler and topcoat

\*\*\* solventborne cleaning required (e.g. 360-68 or P-P-41)

- = very well suited
- = well suited
- = suited in some cases
- = not suitable
- empty = not tested

**In detail:** see painting process "Painting of Plastics."

**In general:** Due to different raw material suppliers, the quality of the plastics can vary from time to time. Therefore, the adhesion should be checked before painting.

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# TECHNICAL INFORMATION

## D 7 Painting of Plastics

### D 7.3 Painting of Plastics with 284-60

Plastic type	Recommended pretreatment	284-60 4:1:1 922-220 PRO 352-330	284-60 4:1:1 922-220 PRO 568-20	*1x 568-20 + 284-60 4:1:1 922-220 PRO 352-330
ABS	P-P-41; Pad grey or P600; P-P-41	●	○	○
ABS/PC	P-P-41; Pad grey or P600; P-P-41	●●	●●	●
ASA	P-P-26; Pad grey or P600; P-P-31; alternative P-P-41	●	○	○
PC	P-P-41; Pad grey or P600; P-P-41	●●	●	●
PC/PBT	P-P-41; Pad grey or P600; P-P-41	●	●	●
GRP	P-P-41; Pad grey or P600; P-P-41 ***	●●	●●	●●
SMC	P-P-41; P400; P-P-41	●		
DCPD	P-P-41; P400; P-P-41	●		
PU-RIM	P-P-41; Pad grey or P600; P-P-41	●●	○	○
PUR soft**	-	-	-	-
PVC	P-P-41; Pad grey or P600; P-P-41	●●	●●	●●
PMMA	-	-	-	-
PPE-PA	P-P-41; Pad grey or P600; P-P-41	●●	●●	●●
TPO-blends ***	P-P-41; Pad grey or P600; P-P-41	-	○	○
PP-blends ***	P-P-41; Pad grey or P600; P-P-41	-	-	●
PE-blends ***	P-P-41; Pad grey or P600; P-P-41	-	-	○
PA	-	-	-	-
POM	-	-	-	-
PS	-	-	-	-

\* not VOC-compliant

\*\* Softface-Additive used in filler and topcoat

\*\*\* solventborne cleaning required (e.g. 360-68 or P-P-41)

- = very well suited
- = well suited
- = suited in some cases
- = not suitable
- empty = not tested

**In detail:** see painting process "Painting of Plastics."

**In general:** Due to different raw material suppliers, the quality of the plastics can vary from time to time. Therefore, the adhesion should be checked before painting.

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# TECHNICAL INFORMATION

## D 8 Grey shades of different products with 568-408

	284-45	284-90	284-58E	284-13	284-60	801-715	9-7
<b>L8 (RAL 9010)</b>							
MR: 568-408 by weight MR: 568-408 by volume	1000 : 0	1000 : 0					
<b>L7</b>							
MR: 568-408 by weight MR: 568-408 by volume	1000g : 0,8g 1000ml : 1,1ml	1000g : 0,7g 1000ml : 1,1ml	1000 : 0				
<b>L6</b>							
MR: 568-408 by weight MR: 568-408 by volume	1000g : 1g 1000ml : 2ml	1000g : 1g 1000ml : 2ml	1000g : 0,5g 1000ml : 0,7ml				
<b>L5</b>							
MR: 568-408 by weight MR: 568-408 by volume	1000g : 3g 1000ml : 4ml	1000g : 3g 1000ml : 4ml	1000g : 1,5g 1000ml : 2,2ml	1000 : 0			
<b>L4</b>							
MR: 568-408 by weight MR: 568-408 by volume	1000g : 7g 1000ml : 10ml	1000g : 7g 1000ml : 11ml	1000g : 4g 1000ml : 5,8ml	1000g : 4g 1000ml : 5ml	1000 : 0	1000 : 0	
<b>L3</b>							
MR: 568-408 by weight MR: 568-408 by volume	1000g : 14g 1000ml : 21ml	1000g : 13g 1000ml : 20ml	1000g : 7g 1000ml : 10ml	1000g : 11g 1000ml : 15ml	1000g : 3,5g 1000ml : 5,2ml	1000g : 4g 1000ml : 5,8ml	1000 : 0
<b>L2</b>							
MR: 568-408 by weight MR: 568-408 by volume	1000g : 32g 1000ml : 48ml	1000g : 32g 1000ml : 51ml	1000g : 16g 1000ml : 23,5ml	1000g : 36g 1000ml : 50ml	1000g : 12,7g 1000ml : 18,8ml	1000g : 16g 1000ml : 23,1ml	1000g : 36g 1000ml : 50ml
<b>~ L1</b>							
MR: 568-408 by weight MR: 568-408 by volume	1000g : 67g 1000ml : 100ml	1000g : 66g 1000ml : 100ml	1000g : 69g 1000ml : 100ml	1000g : 72g 1000ml : 100ml	1000g : 68g 1000ml : 100ml	1000g : 69g 1000ml : 100ml	1000g : 72g 1000ml : 100ml

The indicated colors are just reference points and are affected by the printer/screen setting. For colors with a mandatory gray shade as STEP #1, only the mixtures marked may be used.

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# TECHNICAL INFORMATION

## D 9 Optimised drying processes

		20°C *	50°C *	60°C *	Surface size	Potlife
<b>Primerfiller 284-90 wet-on-wet</b>						
3:1+30%	922-180 PRO / 352-320	60 min		30 min	~ 60-100 m <sup>2</sup>	1,5 h
3:1+[25% +5%] *1	922-180 PRO / [352-320 / 568-17]**	30 min		10 min	~ 60-100 m <sup>2</sup>	50-60 min

<b>Filler 284-45 wet-on-wet</b>						
2:1+30%	922-180 PRO / 352-330	60 min		30 min	~ 60-100 m <sup>2</sup>	2 h
2:1+[20%+10%] *2	922-180 PRO / [352-330 / 568-17]	30 min		10 min	~ 60-100 m <sup>2</sup>	1-1.5 h

<b>Filler 284-45 sanding</b>						
2:1+10%	922-180 PRO / 352-320	> 12 h		45 min	~ 60-100 m <sup>2</sup>	1 h
2:1+5-10%	922-180 PRO / 568-17	2,5 h		20 min	~ 60-100 m <sup>2</sup>	40-45 min

<b>Topcoat 68 Line PLUS Efficient and Supreme</b>						
4:1:1	922-138 / 352-320	> 12 h		30 min	~ 60-100 m <sup>2</sup>	1,5 h
4:1:1	922-138 / 568-17	2 h	15 min		~ 2 m <sup>2</sup>	15 min
4:1:[0,5:0,5] *3	922-138 / [352-320 / 568-17]	3 h	20 min		~ 10-12 m <sup>2</sup>	20-30 min
4:1:[0,8:0,2] *4	922-138 / [352-320 / 568-17]	4 h	25 min		~ 60-100 m <sup>2</sup>	30-40 min

<b>Clearcoat 924-68, -268</b>						
3:1:1	922-138 / 352-320	> 12 h		30 min	~ 60-100 m <sup>2</sup>	1,5 h
3:1:[0,8:0,2] *4	922-138 / 568-17	3-4 h	25 min	20 min	~ 10-12 m <sup>2</sup>	30 min

\* Time and temperature refer to the object temperature.

\*\* Do not use on aluminium in combination with base-, clearcoat.



Adding 568-17 has a huge impact on potlife and drying properties. When creating a pre-mix of **352-3xx** with **568-17**, use the Glasurit mixing sticks to improve the accuracy.

Mixing stick  
 \*1 5 : 1  
 \*2 2 : 1  
 \*3 1 : 1  
 \*4 4 : 1  
 352-3xx : 568-17

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# TECHNICAL INFORMATION

## D 10 Overcoatability of primer fillers after outdoor storage

### Test method:

Panels painted with primer filler (without topcoat) had been stored outside for three months at the premises of BASF Coatings GmbH. After the storage the panels had been sanded with Scotch pad and cleaned with 541-68 or high-pressure washer.

	68 Line applied <b>directly</b> on stored primer filler	1 spray coat of the same <b>primer filler</b> as adhesion promoter + 68 Line	1 spray coat <b>284-10</b> as adhesion promoter + 68 Line
<b>183-153</b>	-	-	-
<b>284-13</b>	○	●●	●●
<b>284-55</b>	○	●●	●●
<b>284-60</b>	●	●●	●●
<b>284-58E</b>	●	●●	●●
<b>284-90</b>	●	●●	●●
<b>568-46 (70:30)</b>	●	●●	●●
<b>801-715</b>	-	-	-
<b>9-7</b>	-	-	-

- Not overcoatable
- Limited overcoatability
- Overcoatable
- Very good overcoatability

### Test results:

183-153, 801-715 and 9-7 can be stored outside for 3 months and protect the substrate from corrosion, but it is not possible to overcoat them afterwards with 68 Line with or without an adhesion promoter (lack of adhesion). For further use, these primer fillers have to be removed and applied again.

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# TECHNICAL INFORMATION

## D 11 Corrosion protection classes of Glasurit CV Primers (acc. to DIN EN ISO 12944)

### Test method:

Internal product testing with Glasurit primers and 68 Line topcoat on blasted steel.  
 Regarding the test durations, the tests conformed to DIN EN ISO 12944-6 (2023).  
 However, the film thicknesses complied with the Glasurit Technical Information Sheets of each product.

CH = constant humidity test (DIN EN ISO 6270-2)  
 SS = salt spraytest (DIN EN ISO 9227)  
 CA = cyclic aging test (DIN EN ISO 12944-9)

The corrosion protection classes C4 very high and C5 high have been tested with a cyclic aging test which conforms to the DIN EN ISO 12944-6 (2023).  
 The durability range is not a guaranteed time.  
 The results do not provide a guarantee for corrosion resistance and adhesion of the paint systems.

The green fields of the table indicate that the tests had a positive result in terms of corrosion protection according to the norm DIN EN ISO 12944-6 (2023).

Corrosion protection classes	C3		C4				C5			
	Very high	Low	Medium	High	Very high	Low	Medium	High	Very high	
Durability range	> 25 years	up to 7 years	7 - 15 years	15 -25 years	> 25 years	up to 7 years	7 - 15 years	15 -25 years	> 25 years	
Tests	480 h CH 720 h SS	120 h CH 480 h SS	240 h CH 480 h SS	480 h CH 720 h SS	1680 h CA	240 h CH 480 h SS	480 h CH 720 h SS	1680 h CA	2688 h CA	
284-13 + 68 Line										
284-55 + 68 Line										
284-58E + 68 Line										
284-60 + 68 Line										
284-90 + 68 Line										
568-46 DTM [50:50] + 68 Line										
568-46 [70:30] + 68 Line										
801-715 + 68 Line										

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# TECHNICAL INFORMATION

## D 12 Gloss levels with 924-68 HS 2K CV clear coat and 924-50 CV clear coat extreme mat

Gloss	Gloss level [60°]	Gloss level [20°]	Mixing ratio clearcoats [weight]		Mixing ratio with hardener and thinner
			924-68 *	924-50	
<i>Color: black</i>					
High gloss	90 - 95	85 - 90	100	0	3:1:1
High gloss	85 - 90	60 - 65	60	40	4:1:1
Gloss	75 - 80	40 - 45	50	50	4:1:1
Gloss	70 - 75	30 - 35	40	60	4:1:1
Gloss	65 - 70	20 - 25	30	70	4:1:1
Satin gloss	40	-	20	80	4:1:1
Matt	10	-	0	100	5:1:1

Gloss	Gloss level [60°]	Gloss level [20°]	Mixing ratio clearcoats [weight]		Mixing ratio with hardener and thinner
			924-68 *	924-50	
<i>Color: silver</i>					
High gloss	100	90	100	0	3:1:1
High gloss	90 - 95	65 - 70	60	40	4:1:1
Gloss	80 - 85	45 - 50	50	50	4:1:1
Gloss	75 - 80	30 - 35	40	60	4:1:1
Gloss	70 - 75	25 - 30	30	70	4:1:1
Satin gloss	50	-	20	80	4:1:1
Matt	15	-	0	100	5:1:1

\*Clearcoat alternative: 924-268

### Used settings and process:

Hardener: 922-138

Thinner: 352-320

Application: 2 spray coats with 10 min flash off between the coats, plus 30 min flash off before oven drying

Drying: 30 min at 60°C

Many factors can influence the achieved gloss level: Film thickness, color, hardener, thinner, application process, flash off times and drying.

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# TECHNICAL INFORMATION

## D 13 Additives for undercoats and topcoats

Overview of which 568- additives can or cannot be used in undercoats and topcoats		568-17	568-20	568-46	568-96	568-405	568-407	568-408	568-409	568-412	568-720 / -745
CV Steel Primer	9-7	○	x	x	●	x	●	●	x	x	x
CV Shop Primer	183-153	x	x	x	x	x	x	●	x	x	x
CV Multi Wash	283-1870	x	x	x	x	x	x	●	x	x	x
CV Chassis Surfacer	284-13	●	○	x	x	x	●	●	●	●	x
CV UHS Primerfiller	284-55	x	x	x	x	x	●	●	x	x	x
CV Universal Primer Filler	284-58E	○	●	x	x	x	●	●	○	●	x
CV Universal Primer Filler	284-60	○	●	x	x	x	●	●	○	●	x
CV 2K PUR Primer Filler	284-90	●	●	x	x	x	●	●	○	●	x
CV Texture Filler	284-99	x	x	x	x	x	●	x	x	x	x
CV Transparent Sealer	284-10	●	●	x	x	x	●	●	x	○	x
CV Filler	284-45	●	●	x	x	x	●	●	○	●	x
CV EP Primer Filler	801-715	x	x	x	x	x	x	x	x	x	●
68 Line PLUS Efficient	568-M 135	●	○	●	x	●	●	x	●	●	x
68 Line PLUS Efficient	568-M 100	●	○	●	x	●	●	x	○	●	x
68 Line PLUS matt	568-M 124	●	○	●	x	●	●	x	○	●	x
68 Line PLUS Supreme	568-M 200	●	○	●	x	●	●	x	○	●	x
68 Line PLUS High Build	568-M 90	●	○	●	x	●	●	x	○	●	x
68 Line PLUS Basic	568-M 80	x	x	●	x	●	x	x	x	x	x
68 RAL 9006		●	○	x	x	●	●	x	○	●	x
58- Line		●	○	●	x	●	●	x	○	●	x
SB Basecoat	55 Line	x	x	x	x	x	x	x	x	x	x
WB Basecoat	90CV PLUS	x	x	x	x	x	x	x	x	x	x
CV Clear Coat matt	924-50	●	x	x	x	x	x	x	●	x	x
CV Clear Coat	924-68	●	x	x	x	x	x	x	●	x	x
CV Performance Clear Coat	924-268	●	x	x	x	x	x	x	●	x	x

● = compatible

○ = compatible / but no impact

x = not compatible

For further information see the Technical Information Sheet of the corresponding product.

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