

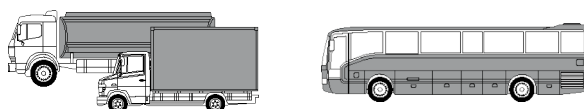


A brand of BASF –
We create chemistry

68-Line (568-M 135)

68- HS 2K CV Topcoat, glossy

Application:



all applications

Key Features:

- 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 m²/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.

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

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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	HVLP spray gun	Suction cup	Airless/ Airmix	Pressure pot dbl.-pump
Application pressure	2.2-2.5 bar	2 bar	2.5 bar		2.5 bar
Material pressure					0.8-1.5 bar
Nozzle size	1.4	1.5	1.7		1-1.1
Number of coats	1.5	1.5	1.5		1.5
Flash off at 20°C	without	without	without		without
Film thickness	40-60 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

Object Temp. 60°C

30 min

30 min

30 min

30 min

30 min

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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. Airless or Airmix - Use 568-M 100 instead of 568-M 135.

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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