

# 285-15

Black DTM Primer filler - Rapid Process, National Rule - Flexible



A brand of BASF –  
We create chemistry

- Application:** Flexed primer surfacer, rapid process.
- Key Features:** 285-15 is an acrylic two-component surfacer which may be flexed for application on bumpers and other flexible plastic.
- Remarks:**
- 285-15 may be mixed with 285-25 (White) to achieve differing L shades.
  - 10% 522-111 must be added prior to hardener and reducer.
  - 934-30 Adhesion Promoter must be applied to bare flexible plastic before applying primer.
  - Surface cleaning and preparation are critical to the success of the 285-15. All grease, rust and dirt must be properly removed.

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**VOC ready for use**                      365 g/l                      3.1 lb/gal

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**Mixing Ratio Pre-Mix**

100 parts by volume 285-15  
10 parts by volume 522-111

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**Mixing Ratio**

77.6 g                      Pre-Mix



**Hardener**

12.4 g                      929-385



**Reducer**

6.3 g                      352-91

**Additive**

3.7 g                      522-20



**Spray viscosity at 68°F / 20°C**

DIN 4:                      15-17 s

**Potlife at 68°F / 20°C**

2 h

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**Safety advice:**



Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Safety Data Sheet (SDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.

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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Nozzle pressure		10 psi
Nozzle size		1.5-1.7 mm
Number of spraycoats	2-3	
Flash-off at 68°F / 20°C	5 min between coats	
Film thickness	3-5 mil before sanding	



**Drying at 68°F / 20°C** 30-50 min  
Do not bake.



**Sanding manual, wet** P320 - P500



**Sanding manual, dry** P320 - P500



**Orbital sanding, dry** P400 - P500

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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