

285-20

Low VOC DTM Primer - Rapid Process - White - Flexible







A brand of BASF –
We create chemistry

- Application:** A white primer surfacer for easy sanding, elastified for use on flexible parts, and with rapid cure additive.
- Key Features:** Excellent sag resistance and leveling. Very good adhesion. The use of a Glasurit Plastic Adhesion Promoter is needed prior to application over raw plastic parts.
- Remarks:**
- May be sanded in as little as 15 minutes air dry.
 - Surface cleaning and preparation are critical to the success of the 285-20 Rapid Process. All grease, rust and dirt must be properly removed.
 - Up to 30% of 285-10 may be added to the 285-20 to create a grey color prior to adding the hardener and 522-48. Adding more than the 30% will create a pot life too short to be useable.
 - When IR curing, primer must be flashed for a minimum of 3-4 minutes before being subjected to IR to prevent solvent popping. At this point the primer must be cured at a panel temp of approximately 160°F for 5-6 minutes.
 - **This must be weighed by scale.**

VOC ready for use 250 g/l 2.1 lb/gal

200 gram sample weight:

Mix thoroughly after each step!

	Mixing Ratio	100 gram	285-20
	Hardener	32 gram	929-105, -115, -120
	Reducer	35 gram	522-48
	Additive	33 g	522-333
	Spray viscosity at 68°F / 20°C	DIN 4:	16-18 s
	Potlife at 68°F / 20°C	15 min	

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		1.7-1.9 mm
Number of spraycoats	2	
Flash-off at 68°F / 20°C	No flash off required between coats.	
Film thickness	2-2.5 mil	



Drying at 68°F / 20°C 20 min

Drying at 140°F / 60°C 10 min



Infrared (short wave) 3-4 min flash, then approximately 5-6 min at 160°F / 71°C



Sanding manual, wet 320-500



Sanding manual, dry 320-500



Orbital sanding, dry 400-500

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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