












Glasurit® Soft face Additive



- Application:** Plasticising additive used in plastics refinishing procedures
- Properties:** Elastified, good miscibility
- Remarks:**
- Addition of 25% by vol.

	Application	Undercoat materials	Topcoat/clear
	Paint system	S. 3, S. 3a	
	Mixing ratio	4 parts. 285- (100% by vol.) 1 part. 522-111 (25% by vol.)	4 parts 22-,22 VOC 923- 100% by vol.) 1 part 522-111 (25% by vol.)
	Hardener	4 : 1 : 1 100% by vol. 285- : 522-111 25% by vol. 929-55, -56	2 : 1 + 10 % 100% by vol. 22-, 22 VOC /923- : 522-111 50% by vol. 929-91, -93 / 929-31, -33
	Reducer	25% by vol. 352-91, -50	33% by vol. 22 VOC MC600 / 923- : 522-111 33% by vol. 929-61, -63, -64
	Spray viscosity DIN 4 at 20°C	16 - 18 s	22, 22 VOC, 22 VOC MC600 923- 20 - 22 s 17 - 18 s
	Potlife at 20 °C	1 - 2 hours	4 hours
	Gravity cup Spraying pressure	HVLP-gravity-feed spray gun: 1.7 - 1.9 mm2.0 – 3.0 bar 0.7 bar at the nozzle	HVLP-gravity-feed spray gun: 1.3 mm 2.0 – 3.0 bar 0.7 bar at the nozzle
	Number of spraycoats	2	2
	Film thickness	approx. 50 µm	50-60 µm
	Drying at 20 °C	4 hours	16 hours
	Drying at 60 °C	40 min.	45 min
	Infrared (short wave)	8 min.	8 min.
	Infrared (medium wave)	10 - 15 min.	10 - 15 min.

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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