
















02/2007

Glasureit® Restoration of classic cars

Pre-treatment:

Old paintwork	Do a solvent resistance test on a sand-through	Glasureit® 352-91 Reducer	 1x	Finish swells, becomes sticky, softens?	no = solvent-resistant	yes = solvent-sensitive		
solvent-sensitive	Refer to information concerning repair of solvent-sensitive finishes							
solvent-resistant	Glasureit® 541-5 Wax and Silicone Remover	 1X	 Wipe dry	Sand damaged areas down to the bare metal	 P16-P150 or blasting	Glasureit® 541-5 Wax and Silicone Remover	 1X	 Wipe dry
Steel	Glasureit® 541-5 Wax and Silicone Remover	 1X	 Wipe dry	Sand damaged areas down to the bare metal	 P16-P150 or blasting	Glasureit® 541-5 Wax and Silicone Remover	 1X	 Wipe dry

If extensive, time-consuming welding is necessary:





Primer	Glasureit® 183-153 Shop Primer chromate-free	Glasureit® 352-50 Reducer	 4:1 mixing stick	 HVLP 1.9 mm 2.0-3.5 bar	 2 20-25 µm	 10 min. at 20°C
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Alternative procedure:

Primer	Glasureit® 183-30 1K Anti-corrosive Primer redbrown	 Shake for 2 min.	 1-2 15-20 µm	 10 min. at 20°C
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Use only primers with welding certificate. Apply primer after welding operations and remove it again before body-filling.

To achieve long-lasting corrosion protection especially on large bare metal areas and on vehicles that will stand in the shop for a longer time before being refinished:

Primer filler	Glasureit® 285-16 HS VOC Thermo Primer Filler	Glasureit® 929-51 HS Filler Hardener fast	Glasureit® 352-Reducer	 4:1:1 mixing stick	 HVLP 1.9 mm 2.0-3.5 bar	 2	 30 min. at 60°C
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Galvanised steel	Glasureit® 541-5 Wax and Silicone Remover			Sand damaged areas down to the bare metal		Glasureit® 541-5 Wax and Silicone Remover		
		1X	Wipe dry		P16-P150		1X	Wipe dry

If extensive, time-consuming welding is necessary:

Primer	Glasureit® 183-153 Shop Primer chromate-free	Glasureit® 352-50 Reducer				
			4:1 mixing stick	HVLP 1.9 mm 2.0-3.5 bar	2 thin coats 20-25 µm	10 min. at 20°C

Alternative procedure:

Primer	Glasureit® 1K Anti-corrosive Primer redbrown			
		Shake for 2 min.	1-2 15-20 µm	10 min. at 20°C

Use only primers with welding certificate. Apply primer after welding operations and remove it again before body-filling.

To achieve long-lasting corrosion protection especially on large bare metal areas and on vehicles that will stand in the shop for a longer time before being refinished:

Primer	Glasureit® 283-150 VOC Etch Primer Filler	Glasureit® 352-228 Activator	Glasureit® 352-Reducer				
				1:1+30% mixing stick	HVLP 1.9 mm 2.0-3.5 bar	1 thin coat 10-15 µm	10 min. at 20°C

Primer filler	Glasureit® 285-16 HS VOC Thermo Primer Filler	Glasureit® 929-51 HS Filler Hardener fast	Glasureit® 352-Reducer				
				4:1:1 mixing stick	HVLP 1.9 mm 2.0-3.5 bar	2	30 min. at 60°C

Aluminium	Glasureit® 541-5 Wax and Silicone Remover			Sand damaged areas down to the bare metal		Glasureit® 541-5 Wax and Silicone Remover		
		1X	Wipe dry		P150-P180		1X	Wipe dry

Body filling work and undercoat materials:

Body Filler (coarse & fine)	Glasureit® Multi Purpose Body Filler 839-20/20K	Glasureit® Hardener Paste, red 948-36					Glasureit® 581-40 Guide Coat			
			+ 2-3%	20-30 min. at 20°C	3-5 min.	P80/P150 coarse sanding		P240/P320 fine sanding	541-5 1X	Wipe dry

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


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
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






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or, as fine body filler:






Polyester spray filler	Glasurit® 1006-23 HS Polyester Spray Filler	Glasurit® 948-22 Hardener	 1500:50	 2.5-3,0 mm 2.0-3,0 bar	 4-8 200 – 300 µm	 3 h at 20°C 30 min at 60°C	 10-15 min.	 P150 coarse sanding P240-P320 fine sanding	Caution: Prime sand-through areas on galvanised or aluminium substrates with 283-150
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Primer (bare metal areas)	Glasurit® 283-150 VOC Etch Primer Filler	Glasurit® 352-228 Activator	Glasurit® 352- Reducer	 1:1+30% mixing stick	 HVLP 1.9 mm 2.0-3.5 bar	 1 thin spray coat 10-15 µm	 10 min. at 20°C
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Primer filler	Glasurit® 285-60 Universal HS VOC Primer Filler	Glasurit® 929-51, -53 HS Filler Hardener	Glasurit® 352 Reducer	 4:1:1 mixing stick	 HVLP 1.9 mm 2.0-3.5 bar	 2	 25 min. at 60°C	 5-10 min.	 P800	 P400
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
or alternatively: Glasurit® 285-51 / -55 HS VOC Primer Filler, Glasurit® 285-65 Universal HS VOC Primer Filler, Glasurit® 285-16 HS Thermo Primer Filler






To ensure good finish quality we recommend the application of a 2K topcoat for a visual check.

Visual check	Glasurit® 22 Line HS 2C Topcoat VOC 3.5	Glasurit® 929-31 / -33 Hardener VOC 3.5	Glasurit® 352- Reducer	 2:1+10% mixing stick	 HVLP 1.3 mm 2.0-3.5 bar	 2	 30 min. at 60°C	 7-10 min.
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Check the surface quality, e.g. under neon light	If surface is okay =>	 P800	 P400
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Basecoat/ clearcoat system

Basecoat	Glasurit® 90 Line Basecoat	Glasurit® 93-E3 Adjusting Base	 2:1 mixing stick	 HVLP 1.3 mm 2.0-3.5 bar	 2 + ½	 approx. 10 min.
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Clearcoat	Glasurit® 923-335 HS Multi Clear	Glasurit® 929-31 / -33 Hardener VOC 3.5	Glasurit® 352- Reducer	 2:1+10% mixing stick	 HVLP 1.3 mm 2.0-3.5 bar	 2	 30 min. at 60°C	 7-10 min.
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

Direct-gloss topcoat

Topcoat	Glasurit® 22 Line HS 2K Topcoat VOC 3.5	Glasurit® 929-31 / -33 Hardener VOC 3.5	Glasurit® 352- Reducer	 2:1+10% mixing stick	 HVLP 1.3 mm 2.0-3.5 bar	 2	 30 min. at 60°C	 7-10 min.
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High-end finishing:

We recommend the application of an additional layer of clear on top of 22 Line VOC topcoats and on top of our basecoat/ clearcoat systems.

Cleaning	Glasurit® 541-5 Wax and Silicone Remover	 1X	 Wipe dry	 P1200	Glasurit® 541-5 Wax and Silicone Remover	 1X	 Wipe dry
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Clearcoat	Glasurit® 923-335 HS Multi Clear	Glasurit® 929-31 / -33 Hardener VOC 3.5	Glasurit® 352- Reducer	 2:1+10% mixing stick	 HVLP 1.3 mm 2.0-3.5 bar	 2	 30 min. at 60°C	 7-10 min.
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Black mat finishes:

Topcoat	Glasurit® 22 Line HS-2K-Topcoat rallye black mat 1250/M	Glasurit® 929-31 / -33 Hardener VOC 3.5	Glasurit® 352- Reducer	 2:1+10% mixing stick	 HVLP 1.3 mm 2.0-3.5 bar	 2	 30 min. at 60°C	 7-10 min.
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