



SYSTEM INFORMATION

Glasurit® - Fast repair process

1. Application

Process for fast refinishing by adding Glasurit 523-15 Racing Additive to Glasurit products.







2. Properties

By replacing Glasurit 352- Reducer by Glasurit 523-15 Racing Additive, you can significantly shorten the drying time. That leads to

- a reduction of throughput times,
- lower energy costs,
- shorter process times,
- improved tape resistance and
- improved curing performance enabling you to continue working (such as polishing) earlier.

3. Additional information

We recommend this refinishing method especially for vertical surfaces. Please note that the use of 523-15 shortens the potlife.

	Pre-treatment		
		Clean 1x	Glasurit 700-10 Degreasing and cleansing agent
		Wipe dry	
		P80 – P150	Sand damaged areas down to the bare metal
		Clean 1x	Glasurit 700-10 Degreasing and cleansing agent
		Wipe dry	
Please note: Alternatively, you may use 360-4 or 541-5.			

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		Body Filler	
		+ 2 – 3%	Glasurit 839-20/-20K Multi-Purpose Body Filler Glasurit 948-36 Hardener Paste, red
			4 min.
		or 20°C	20 – 30 min.
			P80 / P150 coarse sanding
			P240 / P320 fine sanding
		Clean 1x	Glasurit 700-1 Cleaner
		Wipe dry	
	Please note: Depending on the damaged area, you can also use 839-25.		

		Primer	
		1 : 1	Glasurit 283-150 Etch Primer, light beige Glasurit 352-230 Activator
			HVLP 1.3 – 1.8 mm 2.0 bar
		1 – 2	10 – 15 µm
		20°C	ca. 10 min.

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		HS Primer Filler	
		4 : 1 : 1 mixing stick	Glasurit 285-555 /-655 /-505 HS Primer Filler Glasurit 929-55 HS Filler Hardener Glasurit 523-15 Racing Additive
			HVLP 1.7 – 1.9 mm 2.0 bar
		2	50 – 70 µm
		60°C	10 min.
		or	4 min.
			P400
		Clean 1x	Glasurit 700-1 Cleaner
		Wipe dry	

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		Basecoat	
		2 : 1 mixing stick	Glasurit 90 Line Basecoat
			Glasurit 93-E 3 Adjusting Base
			HVLP 1.3 mm 2.0 bar
		2 + ½	10 – 15 µm
		Flash off until mat between spraycoats and before clearcoat application.	
<p>Please note: The flash-off time can be reduced by using blow equipment or by briefly increasing the temperature to up to 45°C.</p>			

		Clear	
		2 : 1 + 10% mixing stick	Glasurit 923-135 VOC HS Racing Clear
			Glasurit 929-31/-33 VOC Hardener
			Glasurit 523-15 Racing Additive
			HVLP 1.3 mm 2.0 bar
	½ + 1	40 – 50 µm	
	60°C	15 min.	
<p>Please note: Apply clear to vertical surfaces only.</p>			

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Cleaning	Glasurit 700-10 Degreasing and cleansing agent	 1x	 Wipe dry	Sand damaged areas down to the bare metal	 P80 - P150	Glasurit 700-10 Degreasing and cleansing agent	 1x	 Wipe dry		
Body Filler (Coarse + fine)	Glasurit 839-20 / -20K Multi-Purpose Body Filler	Glasurit 948-36 Hardener Paste, red	 +2-3%	 3-5 min	 20°C 20-30 min.	 P80/P150 coarse sanding	 P240/P320 fine sanding	Glasurit 700-1 Cleaner	 1x	 Wipe dry
Primer	Glasurit® 283-150 VOC Etch Primer Filler, light beige	Glasurit® 352-230 Activator	 1 : 1	 HVLP 1.3-1.8 mm 2.0-3.0 bar	 1-2 10-15 µm	 ca. 10 min at 20°C				
Primer Filler	Glasurit 285-505 HS Primer Filler	Glasurit 929-55 HS Filer Hardener	Glasurit 523-15 Racing Additive	 4:1:1 mixing stick	 HVLP 1.7-1.9 mm 2.0 bar	 2	 60°C 10 min.	 4 min.	 P400	 P 800
Alternatively:	Glasurit 285-555 / -655 HS Primer Filler									
Basecoat	Glasurit 90 Line Basecoat	Glasurit 93-E 3 Adjusting Base	 2:1 mixing stick	 HVLP 1.3 mm 2.0 bar	 2 + ½	 Flash off until mat between spraycoats and before clearcoat				
Clear	Glasurit 923-135 Racing Clear	Glasurit 929-31 / -33 VOC Hardener	Glasurit 523-15 Racing Additive	 2:1 + 10% mixing stick	 HVLP 1.3 mm 2.0 bar	 ½ + 1	 60°C 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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