



SYSTEM INFORMATION

Glasurit® Repair System for Citroen Cactus Airbump

Process description Glasurit® Repair System for the repair of Citroen Cactus Airbump panels produced out of TPU thermoplastic polyurethane

1. Substrate without defects

Cleaning	Glasurit® 700-10 Degreasing and cleansing agent	Entire part with sanding pad grey	Wipe dry	Glasurit® 700-10 Degreasing and cleansing agent	1x	Wipe dry				
	Adhesion Primer	934-10 Glasurit® 1K Plastic Adhesion Primer	2min	1-2 5 - 10 µm	15 min at 20°C					
Primer Filler		Glasurit® Primer Filler grey 285-505	Glasurit® Softface Additive 522-111	4:1 mixing stick						
	Alternatively:	Mixture Glasurit® Primer Filler grey / Softface Additive	Glasurit® HS Filler Hardener	Glasurit® 352-Reducer	4:1:1 mixing stick	HVLP 1.7-1.9 mm 2.0-3.0 bar	2 40 - 60 µm	30 min at 60°C	P 800	700-1 1x
Basecoat		Glasurit® 90 Line Basecoat	Glasurit® 93-E 3 Basecoat Reducer	2:1 mixing stick	HVLP 1.3 mm 2.0-3.0 bar	2 + 1/2	Flash off until mat between spraycoats and before clearcoat			
	Clear	Glasurit® 923-335 HS Multi Clear VOC	Glasurit® 929-Hardener VOC	Glasurit® 352-Reducer	2:1 + 10% mixing stick	HVLP 1.3 mm 2.0-3.0 bar	2	30 min at 60°C		

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these statements do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at www.glasurit.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.








SYSTEM INFORMATION

Glasurit® Repair System for Citroen Cactus Airbump








2. Substrate with slight defects

Cleaning	Glasurit® 700-10 Degreasing and cleansing agent	 1x	 Wipe dry	Damaged area P150, entire part sanding pad		Glasurit® 700-10 Degreasing and cleansing agent	 1x	 Wipe dry
-----------------	--	---	---	--	---	--	---	---





Body Filler (fine)	Glasurit® 839-90 Plastic Body- Filler	Glasurit® 948-36 Hardener Paste, red	 +3%	 25-35 min at 20°C	 P150/P240/ P320 / P400	Glasurit® 700-1 Cleaner	 1x	 Wipe dry
-------------------------------	--	---	--	---	--	-------------------------------	---	---





Adhesion Primer	934-10 Glasurit® 1K Plastic Adhesion Primer	 2min	 1-2 5 - 10 µm	 15 min at 20°C
----------------------------	--	---	---	--

Primer Filler	Glasurit® Primer Filler grey 285-505	Glasurit® Softface Additive 522-111	 4:1: mixing stick
----------------------	--	---	---

Mixture Glasurit® Primer Filler grey / Softface Additive	Glasurit® HS Filler Hardener	Glasurit® 352- Reducer	 4:1:1 mixing stick	 HVLP 1.7-1.9 mm 2.0-3.0 bar	 2 40 - 60 µm	 30 min at 60°C	 P 800	 700-1 1x	 Wipe dry
---	------------------------------------	------------------------------	--	--	--	--	--	--	---

Alternatively: Glasurit® 285-555, 285-655 HS Primer Filler

Basecoat	Glasurit® 90 Line Basecoat	Glasurit® 93-E 3 Basecoat Reducer	 2: 1 mixing stick	 HVLP 1.3 mm 2.0-3.0 bar	 2 + ½	 Flash off until mat between spraycoats and before clearcoat
-----------------	----------------------------------	--	---	--	--	---

Clear	Glasurit® 923-335 HS Multi Clear VOC	Glasurit® 929- Hardener VOC	Glasurit® 352- Reducer	 2: 1 + 10% mixing stick	 HVLP 1.3 mm 2.0-3.0 bar	 2	 30 min at 60°C
--------------	---	-----------------------------------	------------------------------	---	--	--	--

Safety advice:

The products are suitable for professional use only.
It cannot be ruled out that this product contains particles < 0.1 µm.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these statements do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at www.glasurit.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.