

# Technical Information

## 81-30 | Additive Chassis



### 1. Properties

HS – VOC – compliant 1 stage solution for chassis

- Easy application in combination with high efficiency
- Suitable for large areas
- Excellent corrosion protection on shot blasted chassis
- Can be used as tinted primer as part of a 2 – step system or as a **Direct To Metall (DTM)** solution directly on shot blasted chassis

### 2. Application / Tinted Primerfiller

	<b>Pre-mixing ratio</b>	70% by vol. 81-30- 30% by vol. 30CV (stir well)
	<b>Mixing ratio</b>	100% by vol. premix 81-30 / 30CV- 33% by vol. 51-520, -515, -530 10 – 20% by vol. 60-10, -20, -30, -40 (stir well)
	<b>Spray viscosity DIN 4 at 20°C</b>	approx. 25 – 35 s
	<b>Pot life</b>	2 h / 20°C
	<b>HVLG gravity-feed spraygun</b>	1.7 – 1.9 mm 2.0 bar, 0.7 bar at the nozzle
	<b>Compliant gravity-feed spraygun</b>	1.6 – 1.8 mm, 2.2 – 2.5 bar
	<b>Airless / airmix</b>	0,28 – 0,33mm, 120 – 180 bar / + max 2 bar atomization air
	<b>Number of spraycoats</b>	2
	<b>Film thickness</b>	approx. 50 – 70 µm

### 3. Flash off and Drying / Tinted Primerfiller

	<b>Hardener:</b>	<b>Normal 51-520</b>	<b>Fast 51-515</b>	<b>Slow 51-530</b>
	<b>Drying at 20°C</b>	60 min	45 min	60 min
	<b>Drying at 60°C</b>	30 min	25 min	30 min

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 data 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). It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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## 81-30 | Additive Chassis



### 2. Application / DTM

	<b>Pre-mixing ratio</b>	50% by vol. 81-30- 50% by vol. 30CV (stir well)
	<b>Mixing ratio</b>	100% by vol. premix 81-30 / 30CV 33% by vol. 51-520, -515, -530 (stir well)
	<b>Spray viscosity DIN 4 at 20°C</b>	approx. 30 – 40 s
	<b>Pot life</b>	2 h / 20°C
	<b>HVLP gravity-feed spraygun</b>	1.7 – 1.9 mm 2.0 bar, 0.7 bar at the nozzle
	<b>Compliant gravity-feed spraygun</b>	1.6 – 1.8 mm, 2.2 – 2.5 bar
	<b>Airless / airmix</b>	0,28 – 0,33mm, 120 – 180 bar / + max 2 bar atomization air
	<b>Number of spraycoats</b>	2
	<b>Film thickness</b>	approx. 60 – 150 µm

### 3. Flash off and Drying / DTM

	<b>Hardener:</b>	<b>Normal 51-520</b>	<b>Fast 51-515</b>	<b>Slow 51-530</b>
	<b>Drying at 20°C</b>	16 h	16 h	16 h
	<b>Drying at 60°C</b>	40 min	30 min	40 min

#### Safety instructions:

#### 81-30 Additive Chassis (Tinted Primerfiller)

2004/42/IIIB (c II)(540)530: The EU limit value for this product (product category: IIB.c II) in ready to use form is max. 540 g/l. The VOC content of this product is 530 g/l.

#### 81-30 Additive Chassis (DTM)

2004/42/IIIB(d)(420)419: The EU limit value for this product ( product category: IIB.d) in ready to use form is max 420 g/litre of VOC. The VOC content of this product is 419 g/litres.

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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