

# Technical Information

## 30-S01



### 30-S01 variant 81-30 DTM

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

## Application

	<b>Mixing Ratio PreMix</b>	50 % by volume	81-30
		50 % by volume mixed color of 30CV (stir well)	30-S01
	<b>Mixing Ratio</b>	100 % by volume	PreMix
		33 % by volume (stir well)	51-515, -520
	<b>Spray viscosity at 20°C</b>	DIN 4: 30-40 s	
	<b>Potlife at 20°C</b>	2 h	
	<b>HVLP spray gun</b>		
	Nozzle size	1.7-1.9 mm	
	Application pressure	2 bar	
	Nozzle pressure	0.7 bar	
	<b>Compliant gravity-feed spray gun</b>		
	Nozzle Size	1.6-1.8 mm	
Application Pressure	2.2-2.5 bar		
	<b>Number of spray coats</b>	2	
	<b>Film thickness</b>	60-150 µm	

### Safety advice:

#### 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.

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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**Flash off at 20°C**

approx. 5 minutes after each spray coat

**Application Remark**

Airless/ airmix: 0,23 – 0,28mm, 120-180 bar / + max 2 bar atomization air

## Drying



	51-520	51-515
<b>Drying at 20°C</b>	16 h	16 h
<b>Drying at 60°C</b>	40 min	30 min

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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