

### 1. Preparation of Surface

The surfaces to be painted must be dry, clean, free of rust, oil and dust. For cleaning and grease removal, standard, commercially available cleaning agents are recommended.

Sealing surfaces, fitting surfaces and threads must be covered before being painted.

### 2. Priming

Application Method:	High Pressure Spray	Rollers		
Coating Thickness	40 + 15 µm (measured when dry)			
Coating Material	EP-Base coat beige P.580-2100/RAL 1001, BLOA-part no. 03 965 068			
Hardener	P.210-0833 BLOA-part no. 03 965 062			
Mixture ratio (weight)	10:1			
Paint thinner	P.850-3091, max. 15% BLOA-part no. 03 965 069			
Supplier	NEXA Autocolor, PPG Industries Lacke GmbH Düsseldorfer Str. 80, 40721 Hilden Phone: 02103/791-0 Fax: 02103-791-601			
Pot life	6-8 hours			
Viscosity	25-30 sec, DIN-flow cup DIN 53211-4			
Application Tools	pressure bucket pistol	roller		
Spray Pressure	4-5 bar	-		
Spray Nozzle	1,2-1,5 $\emptyset$ mm	-		
Spray Application	2 coats, crosswise	-		
Spray Distance	20 - 30 cm	-		
Drying Time:				
- dry	30 min			
- air-dry (20°C)	overnight			
- oven dry (80°C)	30 min			
Top coating possible ...	without polishing: after 30 minutes with KH, acrylic and finishing paints			
Polishing possible ...	after air drying overnight or oven drying at 80°C after 30 min.			
<b>Standardisation</b>	Edited: Roese		Edition	
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### 3. Top Coating (finish)

Application Method:	High Pressure Spray	Rollers
Coating Thickness	40 +15 µm (measured when dry)	
Coating Material	2K. Acrylpaint Turbo Plus P 488 - BLOA-part no. 102061114	
Hardener	Turbo Plus 2 K. MS Hardner normal P.210-822 BLOA-part-No. 102061116	
Mixture ratio (weight)	3:1	
Paint thinner	Turbo Plus Thinner normal P.850-1391, max. 25% BLOA-part no. 102061117	
Supplier	NEXA Autocolor, PPG Industries Lacke GmbH Düsseldorfer Str. 80, 40721 Hilden Phone: 02103/791-0 Fax: 02103-791-601	
Viscosity	16-18 sec. DIN-flow cup DIN 53211-4	
Application Tools	pressure bucket pistol	roller
Spray Pressure	3-5 bar	-
Spray Nozzle	1,2-1,5Ømm	-
Spray Application	2 coats, crosswise	-
Spray Distance	20 - 30 cm	-
Drying Time:		
- dry		30 min
- air dry (20°C)		8 hours
- oven dry (80°C)		30 min
Gloss		80-100%

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