



TECHNICAL BULLETIN

Applying 285-16 Wet-on-Wet over E-Coat and OEM Finishes

Number: GLABUL0100-E

In response to numerous requests from the field, the Glasurit Technical Services Lab has reissued its recommendation for applying 285-16 as a wet-on-wet sealer over OEM finishes and e-coat. While using a scuff pad will improve mechanical adhesion of 285-16 to OEM substrates, this step can be skipped if the part is cleaned with 360-4 within 15 minutes prior to sealer application. For production shops where reduced cycle-times are vital, 285-16 may be the perfect solution! Observing the following steps will result in the quality, lasting finish that you expect from Glasurit.

Glasurit 285-16 W/O/W. Application

1. Clean the panel with 360-4 Metal Cleaner to remove any oil or grease contamination that may be present.
2. Use a grey scuff pad to scratch the surface. This step is optional.
3. Apply 1-2 coats of 285-16 (mixed 4:1:1 with 929-51 and 352-50 or 352-91). If not scuffing, apply 285-16 **within 15 minutes of cleaning**.
4. Flash off for 30 minutes.
5. Apply 22-Line or 55-Line/923- Clear according to recommended procedures.
6. Bake the entire system for 30 minutes @ 140°F. *

*Glasurit 923-450 and 923-550 clears require a higher baking temperature. When using these clears, bake the entire system for 20 minutes @ 160°F or 15 minutes @ 180°F.

Note that 285-16 may still be used as a primer-filler and a corrosion primer over bare metal parts. Refer to the Glasurit Technical Manual for more detailed information on 285-16 and other products mentioned in this bulletin.

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