

90 Line Glasurit® Basecoat

G / T

- Application:** Metallic and solid-colour basecoat/clearcoat finishing. Wet-on-wet process with Glasurit 923- Clear.
- Properties:** Very good hiding power, high efficiency.
Water-thinnable, less than 10% organic solvents.
- Remarks:**
- Mixing formulas with 90-M4 and mixing bases are available to cover the whole range of colours needed in automotive refinishing.
 - At rather high temperatures or when refinishing large surfaces, it is possible to replace 90-M4 by 90-M4 slow, while replacing 93-E3 Adjusting base by 93-E3 slow at the same time.
 - Mixtures will keep for up to 6 months when stored in plastic containers or cans coated inside.
 - Use of 93-IC 330 if recommended by car manufacturers (see Technical Information).
 - Flash-off times can be reduced significantly by using appropriate air blow equipment.
 - Flash-off time before application of 923- Clear: 2-3 min. (until surface is mat).
 - When using white colors with high spray viscosity the mixing ratio can be changed to 100 : 80.

Safety advice:

The products are suitable for professional use only.

It cannot be ruled out that this product contains particles < 0.1 µm.

2004/42/II B(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.

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	Paint system	RATIO Aqua	
		Spreading rate:	130 m ² /l at 1 µm
	Mixing ratio	2 : 1 100% by vol. 90 Line Metallics/Solids (acc. to mixing formula)	
	Reducer	50% by vol. 93-E3 Adjusting Base * (stir IMMEDIATELY after having added adjusting base)	
		*When using 90-M4 slow in the mixing formula, 93-E3 slow must also be used.	
	Spray viscosity DIN 4 at 20°C	approx. 18-24 s	
	Gravity cup Spraying pressure	HVLP gun: 1.3 mm 2.0-3.0 bar / 0.7 bar at the nozzle	Compliant gravity-feed gun 1.3-1.4 mm, 2.0 bar
	Number of spraycoats	2 (spray to cover) + ½ to match the effect	Film thickness: 10-15 µm
	Flash-off at 20°C	Approx. 5 min. after each spraycoat.	
	Intermediate drying Drying at 20°C Blow dry with Dry Jet	Flash off until mat after each spraycoat.	
	Sanding	Remove dust nibs by dry sanding; gently fade out applying mist coat afterwards.	

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