

# 100 Line

## Glasurit 100 Line Basecoat



A brand of BASF –  
We create chemistry

- Application:** Metallic and solid-color basecoat/clearcoat finishing. Wet-on-wet process with Glasurit clear coats. 100 Line is water-thinnable and applied under Glasurit clear coats.
- Key Features:** Very good hiding power, high efficiency.  
Water-thinnable, less than 6% organic solvents (ready for use).
- Remarks:**
- Mixing formulas with 100-M 10 / 100-M 20 / 100-M 10X / 100-M 20X and mixing bases are available to cover the whole range of colours needed in automotive refinishing.
  - For high temperatures, low humidity or big surfaces the mixing clears 100-M 10, 100-M 20 and the reducer 100-E 5 can be exchanged by the products 100-M 10X, 100-M 20X and 100-E 5X.
  - Use 100-M 10 / 100-M 20 only mixed with 100 Line base colors and 100-E 5.
  - Use 100-M 10X / 100-M 20X only mixed with 100 Line base colors and 100-E 5X.
  - Mixtures will keep for up to 3 months when stored in plastic containers.
  - Ready for use mixtures will keep for up to 3 weeks when stored in plastic containers.
  - Flash-off times can be reduced significantly by using appropriate air blow equipment.
  - Please refer to the Glasurit Know How module "Glasurit 100 Line" for further details and information about application processes.



### Paint System

Please see Glasurit Know How module "Glasurit 100 Line".

2:1



### Mixing Ratio

100 % by volume

100 Line  
Solids or Metallics (acc. to mixing formula)



### Reducer

50 % by volume

100-E 5, -E 5X  
(acc. to mixing formula)  
Stir IMMEDIATELY after adding.

### 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/IIIB(d)(420)249:** 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 249 g/litres.



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<b>Application:</b>	 <b>Compliant gravity-feed spray gun</b>	 <b>HVLP spray gun</b>
<b>Application pressure</b>	2 bar	
<b>Nozzle size</b>	1.3-1.4	
<b>Number of spray coats</b>	1 full coat + 1 "Finish coat" applied wet-on-wet	
<b>Flash off at 20°C</b>	Flash off until the surface is completely mat after the "Finish coat".	
<b>Film thickness</b>	10-15 µm	
<b>Application Remark</b>	Spraying pressure = Inlet pressure The setup depends on the spray gun supplier, please refer to the Glasurit Know How module "BASIC KNOWLEDGE - BODYSHOP EQUIPMENT" for detailed information.	



**Infrared (short wave)**

Surface temperature 40 - 50°C (max. 60°C) until mat surface and cooling.

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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