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Application:

- For special applications recommended by car manufacturers or for use under P-C-15 clear coat, the usage of 93-IC 330 would be necessary in 90 Line basecoat.
- Additive for 90 Line and for use in solid-colour basecoats applied as a ground coat in 90 Line 3-layer systems to improve tape resistance and hardness.
- If clear coat is to be applied after the base coat application, please ensure this is done within 4 hours.

Remarks:

- Substrates: Solvent-resistant old paintwork, sanding filler, Glasurit primer fillers

Handling



Pre-treatment:

Clean surfaces with Glasurit waterborne cleaner (base-/topcoat) / sand with P400 - P500 / clean again with Glasurit waterborne cleaner (base-/topcoat).

Alternative: apply to Glasurit wet-on-wet filler.



Mixing Ratio

100 % by volume

90 Line basecoat*

Mix the 90 Line basecoat to the formula and stir it carefully.

* 93-IC 330 is unsuitable for use in mixing formulas which contain the mixing base concentrates 80-M.



Hardener

5 % by volume

93-IC 330

Add 93-IC 330 and stir again carefully.



Reducer

50-70 % by volume

93-E 3

Stir IMMEDIATELY after having added adjusting base.

When using 90-M 4 slow in the mixing formula, 93-E 3 slow must also be used.

Potlife at 20°C

30 min

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/IIB(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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90 Line Variant 93-IC 330



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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Application pressure	2 bar	2-3 bar
Nozzle pressure		0.7 bar
Nozzle size	1.3-1.4	1.3
Number of spray coats	2 (spray to cover) plus ½ to match effect. For some colours, one further spraycoat may be necessary.	
Flash off at 20°C	Flash off until mat after each spraycoat.	
Film thickness	10-15 µm	



Drying at 20°C	approx. 15 min.
Drying at 60°C	approx. 10 min. + cooling down
Drying Remark	Infrared 1st spraycoat: flash off at room temperature until mat. 2nd spraycoat: at 40 – 50°C (max 70°C) surface temperature to mat surface + 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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