

100 Line

Basecoat Metallics / Solids - with hardener



A brand of BASF –
We create chemistry

- Application:** Metallic and solid color basecoat/clearcoat finishing. Wet-on-wet process with Glasurit Clears 923-.
- Key Features:** Exhibits excellent hiding power and fast flash off time. Very low solvent content.
- Remarks:**
- Mixing formulas to cover the whole range of colors needed in automotive refinishing.
 - For high temperatures, low humidity or large surfaces the mixing clears 100-M 10, 100-M 20, and reducer 100-E 5 can be exchanged for the following products: mixing clears 100-M 10X, 100-M 20X and reducer 100-E 5X.
 - Use 100-M 10 / 100-M 20 only mixed with 100 Line base colors and 100-E5.
 - Use 100-M 10X / 100-M 20X only mixed with 100 Line base colors and 100-E 5X.
 - Mixing is not required prior to addition of 100-E 5, 100-E 5X Reducers - then stir or shake until uniform.
 - Apply first coat until hiding is achieved.
 - Second coat must be applied prior to flash off of first coat at a greater distance.
 - Flash-off times can be reduced significantly by accelerating air circulation.
 - 5% 100-IC 550 may be added to the color formula.
 - Please refer to the Glasurit Know How module "100 Line" (knowhow.glasurit.com) for more complete information on product details and application processes.



Paint System

Please see Glasurit Know How module "100 Line" (<https://knowhow.glasurit.com/us>)

VOC ready for use 250 g/l 2.1 lb/gal

100:5:50



Mixing Ratio

100 parts by volume

100 Line
(according to mixing formula)
(Stir before reducing to incorporate toners well)



Hardener

5 parts by volume

100-IC 550
(Stir before adding reducer to incorporate hardener well)



Reducer

50 parts by volume

100-E 5, -E 5X
(Stir IMMEDIATELY after having added reducer)
*When using 100-M 10X/100-M 20X, 100-E 5X must also be used.

Potlife at 68°F / 20°C 2 h

Safety advice:



Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Safety Data Sheet (SDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.

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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Nozzle pressure	10 psi	
Nozzle size	1.3-1.4 mm	
Number of spraycoats	1 full coat + 1 "finish coat" applied wet-on-wet	
Flash-off at 68°F / 20°C	Flash off until the surface is completely matte after the "finish coat".	
Film thickness	0.4-0.6 mil	
Application remark	The setup depends on the spray gun supplier, please refer to the Glasurit Know How module "100 Line" for detailed information.	



Infrared (short wave)

Adjust to achieve a surface temperature of 104°F - 122°F (140°F max) [40°C - 50°C (max. 60°C)] . Dry until matte surface and allow to cool.

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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