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90-Line

Basecoat - Underhood (Low VOC)

Application: 90-Line Basecoat to be used for underhood coating without clearcoating.
Remarks: New tinting bases must be shaken for 15 minutes on a mechanical paint shaker before placing on a mixing machine. To ensure good color match, agitate tinting bases on a mixing machine for 15 minutes at the beginning of the day, and every 4 hours during the work day.

VOC ready for use 340 g/l 2.8 lb/gal



Mixing Ratio

70 parts by volume 285-02
 30 parts by volume 90-Line Toner(s) (no 90-M4 or 93-E3)
 25 parts by volume 929-100, -105, -115, -120 or -130
 25 parts by volume 352-25 or -45



Spray viscosity at 68°F / 20°C DIN 4: 11-13 s
Potlife at 68°F / 20°C 3 h

Application:



Compliant gravity-feed spray gun



HVLP spray gun

Nozzle pressure	10 psi
Nozzle size	1.3 mm
Number of spraycoats	2
Flash-off at 68°F / 20°C	5 min
Film thickness	1.2-1.6 mil



Drying at 68°F / 20°C 2 h
Drying at 140°F / 60°C 30 min

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

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.