

90-Line

Basecoat Metallic / Solid / Pearl / Multi-effect



A brand of BASF –
We create chemistry

Application:

Metallic and solid color basecoat/clearcoat finish. Wet-on-wet process with Glasurit Clears 923-.

Remarks:

- Use water to clean tools. Paint residue dried to the tools can be removed with 700-1.
- Collect and dispose all paint-related waste, including water used to clean tools, in accordance with local, state and federal regulations. Refer to 700-7 technical data sheet for more information.
- Use of an air jet will significantly reduce the flash-off time of 90-Line.
- 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.
- The following 90-Line materials have reduced shelf lives and must be protected from freezing: 90-M4, 90-M4EDT, 90-M4S, 93-E3, 93-E3S and 90-M5 (12 months from the date of manufacture).
- For ease of blending, the over reduction of up to 80% is recommended.
- It is important to prepare the 90-Line as follows: Mix Color as per formula, mix well until uniform, add 93-E3, mix well until uniform, finally strain before application
- Potlife at 68°F / 20°C: 6 months when mixed according to formula stored in plastic or lined cans.

VOC ready for use 420 g/l 3.5 lb/gal

2:1



Mixing Ratio

100 parts by volume

90-Line
(Mix intermix formula well prior to addition of any 93-E3 or 93-E3S)



Reducer

50-80 parts by volume

93-E 3, -E3S
(Mix well IMMEDIATELY after addition)
When using 90-M4S in the mixing formula, 90-E3S must also be used



Spray viscosity at 68°F / 20°C

DIN 4: 18-24 s

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		1.2-1.5 mm
Number of spraycoats	2 plus 1/2 to harmonize the effect (appearance)	
Flash-off at 68°F / 20°C	Until matte after each coat 2 - 3 mins. or until matte before next step	
Film thickness	0.4-1 mil	
Application remark	Dirt nibs can be removed with a fine sanding pad, then blend in the area	

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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