

90-M15

Ground Coat - Low VOC



A brand of BASF –
We create chemistry

Application:

90-M15 is a solution for poor hiding ground coats in 90-Line.

Remarks:

- 90-M15 must be vigorously shaken prior to each use.
- 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.
- 90-M15 is better hiding, better coverage, more durable (because of the use of hardener) and fast drying (not tacky).
- For white colors, additional toner may be needed.

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

Step 1:

91.0 grams 90-M15
9.0 grams 90-Line Toner(s) (no 90-M4 or 93-E3)

Step 2:

100 parts by volume Mixed Color
10 parts by volume 929-100, -105, -115, -120 or -130
10 parts by volume 352-45 (may use up to 20%)

*For directions on adding more toner please see Refinity.



Spray viscosity at 68°F / 20°C

DIN 4: 14-15 s

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 mm
Number of spraycoats	2 - 3 (depending on color used)	
Flash-off at 68°F / 20°C	5-10 min	
Film thickness	1.8-2.8 mil (depending on number of coats)	

	Drying at 68°F / 20°C	20-60 min (depending on color and number of coats)
	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

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