

# 90-M 4

90 Line Basecoat



A brand of BASF –  
We create chemistry

- Application:** Metallic and solid-colour basecoat/clearcoat finishing. Wet-on-wet process with Glasurit 923- Clear.
- Key Features:** Very good hiding power, high efficiency.  
Water-thinnable, less than 10% organic solvents.
- Remarks:**
- Mixing formulas with 90-M4 / 90-M4 slow and mixing bases are available to cover the whole range of colours needed in automotive refinishing.
  - At rather high temperatures or when refinishing large surfaces, it is possible to replace 90-M4 by 90-M4 slow, while replacing 93-E3 Adjusting base by 93-E3 slow at the same time.
  - Mixtures will keep for up to 6 months when stored in closed plastic containers or cans coated inside.
  - Use of 93-IC 330 if recommended by car manufacturers (see Technical Information).
  - Flash-off times can be reduced significantly by using appropriate air blow equipment.
  - Flash-off time before application of 923- Clear: 2-3 min. (until surface is mat).
  - When using white colors with high spray viscosity the mixing ratio can be changed up to 100 : 80.



**Spreading rate** 130 m<sup>2</sup>/l at 1 µm

**2:1**



**Mixing Ratio** 100 % by volume 90 Line Metallics/Solids (acc. to mixing formula)



**Reducer** 50 % by volume 93-E 3, -E 3 slow  
**(stir IMMEDIATELY after having added adjusting base)**  
When using 90-M4 slow in the mixing formula, 93-E3 slow must also be used.

**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/IIIB(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.



The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at [www.glasurit.com](http://www.glasurit.com) or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

# 90-M 4

90 Line Basecoat



A brand of BASF –  
We create chemistry

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 mm	1.3
Number of spray coats	2 (spray to cover) + ½ to match the effect	
Flash off at 20°C	Approx. 5 min. after each spraycoat.	
Film thickness	10-15 µm	



### Drying at 20°C

Flash off until mat after each spraycoat.



### Sanding manual, dry

Remove dust nibs by dry sanding; gently fade out applying mist coat afterwards.

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:

The products are suitable for professional use only.

It cannot be ruled out that this product contains particles < 0.1 µm.

**2004/42/IIIB(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.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at [www.glasurit.com](http://www.glasurit.com) or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.