








### Glasurit® 90 Line Additive for basecoat



- Application:**
- For special applications recommended by car manufactures, the usage of 93-IC 330 could be necessary in 90 Line basecoats.
  - Additive for solid-colour 90 Line and for use in solid-colour basecoats applied as a ground coat in 90 Line 3-layer systems to improve tape resistance and hardness.
- Remarks:**
- Substrates: Solvent-resistant old paintwork, sanding filler, Glasurit 285- primer fillers
  - Pre-treatment: Clean surfaces with 700-1 / sand with P400 - P500 / clean again with 700-1.  
Alternative: apply to Glasurit wet-on-wet filler

	<b>Mixing ratio</b>	100 % by vol.      90 Line basecoat* 5 % by vol.        93-IC 330 50 - 70 % by vol.    93-E3	
		Mix the 90 Line basecoat to the formula and stir it carefully. Add 93-IC 330 and stir again carefully. Add 93-E3 and stir carefully.	
		* 93-IC 330 is unsuitable for use in mixing formulas which contain the waterborne dispersions 11-E20A, 11-E30A or 11-E30B or mixing base concentrates 80-M.	
	<b>Spray viscosity DIN 4 at 20°C</b>	approx. 19 - 24 s	<b>Potlife at 20°C:</b> 2 h
	<b>Gravity cup Spraying pressure</b>	HVLP gun: 1.3 mm 2.0 – 3.0 bar /0.7 bar at the nozzle	Compliant gravity-feed gun: 1.3 – 1.4 mm, 2.0 bar
	<b>Number of spraycoats</b>	2 - 3 For some colours, one further spraycoat may be necessary.	<b>Film thickness:</b> 10 – 25 µm
	<b>Flash-off at 20°C</b>	Flash off until mat after each spraycoat.	
	<b>Drying at 20 °C Drying at 60 °C</b>	approx. 15 min. approx. 10 min. + cooling down	
	<b>Infrared</b>	1st spraycoat: 2nd spraycoat:	flash off at room temperature until mat. at 40 – 50°C (max 70°C) surface temperature to mat surface + cooling.

**Safety advice:**

The products are suitable for professional use only.  
It cannot be ruled out that this product contains particles < 0.1 µm.

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