



A brand of BASF –
We create chemistry

100-M 10X

Mixing clear for 100 Line Basecoat

- Application:** Mixing clear for 100 Line.
 100-M 10 is used for mixing effect colors.
 100-M 20 is used for mixing solid colors and effect colors with low effect content.
 100-M 10X is used for mixing effect colors at high temperatures, low humidity or on big surfaces.
 100-M 20X is used for mixing solid colors and effect colors with low effect content at high temperatures, low humidity or on big surfaces.
 100 Line is water-thinnable and applied under Glasurit clear coats.
- Key Features:** Water-thinnable, less than 6% organic solvents (ready for use).
- Remarks:**
- Mixing formulas with 100-M 10 / 100-M 20 / 100-M 10X / 100-M 20X and mixing bases are available to cover the whole range of colours needed in automotive refinishing.
 - For high temperatures, low humidity or big surfaces the mixing clears 100-M 10, 100-M 20 and the reducer 100-E 5 can be exchanged by the products 100-M 10X, 100-M 20X and 100-E 5X.
 - Use 100-M 10 / 100-M 20 only mixed with 100 Line base colors and 100-E 5.
 - Use 100-M 10X / 100-M 20X only mixed with 100 Line base colors and 100-E 5X.
 - Mixtures will keep for up to 3 months when stored in corrosion-resistant (plastic or internally coated) closed cans.
 - Ready for use mixtures will keep for up to 3 weeks when stored in corrosion-resistant (plastic or internally coated) closed cans.
 - Flash-off times can be reduced significantly by using appropriate air blow equipment.
 - Please refer to the Glasurit Know How module "Glasurit 100 Line" for further details and information about application processes.



Paint System

Please see Glasurit Know How module "Glasurit 100 Line".



Mixing Ratio

2:1

100 % by volume

100-M 10, -M 10X, -M 20, -M 20X
Solids or Metallics (acc. to mixing formula)



Reducer

50 % by volume

100-E 5, -E 5X
(acc. to mixing formula)
Stir IMMEDIATELY after adding.

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/IIB(d)(420)249: 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 249 g/litres.



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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Application pressure	bar	2
Nozzle size		1.3-1.4
Number of spray coats		1 full coat + 1 "Finish coat" applied wet-on-wet
Flash off at 20°C	min	Flash off until the surface is completely mat after the "Finish coat".
Film thickness	µm	10-15
Application Remark	Spraying pressure = Inlet pressure The setup depends on the spray gun supplier, please refer to the Glasurit Know How module "BASIC KNOWLEDGE - BODYSHOP EQUIPMENT" for detailed information.	



Infrared (short wave)

Surface temperature 40 - 50°C (max. 60°C) until mat surface and cooling.

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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