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# 100-M 10X

Mixing clear for 100 Line Basecoat

- Application:** Mixing clear for 100 Line. 100-M 10X is used for mixing effect colors at high temperatures, low humidity or on big surfaces. 100 Line is water-thinnable and is applied under Glasurit clear coats.
- Key Features:** Water-thinnable, less than 6% organic solvents (ready for use).
- Remarks:**
- Mixing formulas with mixing clears and mixing bases are available to cover the whole range of colours needed in automotive refinishing.
  - Use 100-M 10X only mixed with 100 Line base colors and 100-E 5X.
  - Mixtures will keep for up to 3 months when stored in plastic containers.
  - Ready for use mixtures will keep for up to 3 weeks when stored in plastic containers.
  - 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".

## 2:1



## Mixing Ratio

100 % by volume

100 Line Metallics (incl. 100-M 10X acc. to mixing formula)



## Reducer

50 % by volume

100-E 5X  
(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/IIIB(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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Mixing clear for 100 Line Basecoat



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<b>Application:</b>	 <b>Compliant gravity-feed spray gun</b>	 <b>HVLP spray gun</b>
<b>Application pressure</b>	<b>bar</b>	2
<b>Nozzle size</b>		1.3-1.4
<b>Number of spraycoats</b>		1 full coat + 1 "Finish coat" applied wet-on-wet
<b>Flash-off at 20°C</b>	<b>min</b>	Flash off until the surface is completely mat after the "Finish coat".
<b>Film thickness</b>	<b>µm</b>	10-15
<b>Application Remark</b>	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)**

1st spraycoat and "Finish coat" applied wet-on-wet, surface temperature 40 - 50°C (max. 60°C) until mat surface and cooling.

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