

100-M 20X

Mixing clear for 100 Line Basecoat



A brand of BASF –
We create chemistry

- Application:** Mixing clear for 100 Line. 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 is applied under Glasurit clear coats.
- Key Features:** Water-thinnable, less than 6% organic solvents (ready for use).
- Remarks:**
- Mixing formulas with mixing clears 100-M 10X / 100-M 20X and mixing bases are available to cover the whole range of colours needed in automotive refinishing.
 - Use 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 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".



Mixing Ratio

2:1

100 % by volume

100 Line Solids or Metallics with low effect content (incl. 100-M 20X acc. to mixing formula)



Reducer

50 % by volume

100-E 5X
(stir IMMEDIATELY after having added adjusting base)

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 spraycoats		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)

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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