









Glasurit® 90 Interior Color System Metallics/Solids/Pearl Effects



Application:

Remarks:

- Mixing formulas with 90-IC 440 mixing clear and mixing bases are available to cover the whole range of colours needed in automotive refinishing.
- Substrates/Pre-treatment:
Solvent-resistant old paintwork, e-coated substrates,
Glasurit 285- or 801- primer fillers/surfacers
Clean surfaces with 700-1 / sand with P400 - P500 / clean again with 700-1.
For e-coated substrates that are difficult to reach, cleaning with 700-1 is sufficient.
- Prime bare metal areas with Glasurit 183-70.
- Mixing formulas that contain 90-M5, 93-E3, 11-E waterborne mixing bases or mixing base concentrates 80-M cannot be used with 90-IC 440.

	Paint system		
		Spreading rate: 130 m ² /l at 1 µm	
	Mixing ratio	2 : 1 + 5 % 100% by vol. 90- Metallics/Solids (Replace 90-M4 by 90-IC 440 in the mixing formula.)	
	Reducer	50% by vol. 352-91, -50, -216, 352-10, -30, -40 5% by vol. 93-IC 330	
	Spray viscosity DIN 4 at 20°C	approx. 15 – 18 s	Potlife at 20°C: 4 h
	Gravity cup Spraying pressure	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
	Number of spraycoats	2	Film thickness: 10 – 15 µm
	Flash-off at 20°C	Approx. 5 min. after each spraycoat.	
	Drying at 20°C	15 min.	dust-free and ready for masking
		3 h	ready for assembly
	Drying at 60°C	20 min.	ready for assembly

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(e)(840)839: The EU limit value for this product (product category: IIB.e) in ready to use form is max 840 g/litre of VOC. The VOC content of this product is 839 g/litres.

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