

# 90-M 4

90 Line Basecoat



A brand of BASF –  
We create chemistry

- Application:** Metallic and solid-colour basecoat/clearcoat finishing. Wet-on-wet process with Glasurit 923- Clear.
- Key Features:** Very good hiding power, high efficiency.  
Water-thinnable, less than 10% organic solvents.
- Remarks:**
- Mixing formulas with 90-M4 / 90-M4 slow and mixing bases are available to cover the whole range of colours needed in automotive refinishing.
  - At rather high temperatures or when refinishing large surfaces, it is possible to replace 90-M4 by 90-M4 slow, while replacing 93-E3 Adjusting base by 93-E3 slow at the same time.
  - Mixtures will keep for up to 6 months when stored in closed plastic containers or cans coated inside.
  - Use of 93-IC 330 if recommended by car manufacturers (see Technical Information).
  - Flash-off times can be reduced significantly by using appropriate air blow equipment.
  - Flash-off time before application of 923- Clear: 2-3 min. (until surface is mat).
  - When using white colors with high spray viscosity the mixing ratio can be changed up to 100 : 80.



**Spreading rate** 130 m<sup>2</sup>/l at 1 µm

**2:1**



**Mixing Ratio** 100 % by volume 90 Line Metallics/Solids (acc. to mixing formula)



**Reducer** 50 % by volume 93-E 3, -E 3 slow  
**(stir IMMEDIATELY after having added adjusting base)**  
When using 90-M4 slow in the mixing formula, 93-E3 slow must also be used.



**Spray viscosity at 20°C** DIN 4: 18-24 s **Potlife at 20°C**

**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)419:** 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 419 g/litres.



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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
<b>Application pressure</b>	<b>bar</b>	2
<b>Nozzle pressure</b>	<b>bar</b>	0.7
<b>Nozzle size</b>		1.3-1.4
<b>Number of spray coats</b>	2 (spray to cover) + ½ to match the effect	
<b>Flash off at 20°C</b>	<b>min</b>	Approx. 5 min. after each spraycoat.
<b>Film thickness</b>	<b>µm</b>	10-15



**Drying at 20°C**

Flash off until mat after each spraycoat.



**Sanding manual, dry**

Remove dust nibs by dry sanding; gently fade out applying mist coat afterwards.

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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