Technical Information

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 m²/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.

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)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
Application pressure	2 bar	2-3 bar
Nozzle pressure		0.7 bar
Nozzle size	1.3-1.4 mm	1.3
Number of spray coats	2 (spray to cover) + ½ to match the effect	
Flash off at 20°C	Approx. 5 min. after each spraycoat.	
Film thickness	10-15 µm	

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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