








Glasurit® 90 Line Additive for basecoat



- Application:**
- For special applications recommended by car manufactures, the usage of 93-IC 330 could be necessary in 90 Line basecoats.
 - Additive for solid-colour 90 Line and for use in solid-colour basecoats applied as a ground coat in 90 Line 3-layer systems to improve tape resistance and hardness.
- Remarks:**
- Substrates: Solvent-resistant old paintwork, sanding filler, Glasurit 285- primer fillers
 - Pre-treatment: Clean surfaces with 700-1 / sand with P400 - P500 / clean again with 700-1.
Alternative: apply to Glasurit wet-on-wet filler

	Mixing ratio	100 % by vol. 90 Line basecoat* 5 % by vol. 93-IC 330 50 - 70 % by vol. 93-E3	
		Mix the 90 Line basecoat to the formula and stir it carefully. Add 93-IC 330 and stir again carefully. Add 93-E3 and stir carefully.	
		* 93-IC 330 is unsuitable for use in mixing formulas which contain the waterborne dispersions 11-E20A, 11-E30A or 11-E30B or mixing base concentrates 80-M.	
	Spray viscosity DIN 4 at 20°C	approx. 19 - 24 s	Potlife at 20°C: 2 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 - 3 For some colours, one further spraycoat may be necessary.	Film thickness: 10 – 25 µm
	Flash-off at 20°C	Flash off until mat after each spraycoat.	
	Drying at 20 °C Drying at 60 °C	approx. 15 min. approx. 10 min. + cooling down	
	Infrared	1st spraycoat: 2nd spraycoat:	flash off at room temperature until mat. at 40 – 50°C (max 70°C) surface temperature to mat surface + cooling.

Safety advice:

The products are suitable for professional use only.
It cannot be ruled out that this product contains particles < 0.1 µm.

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