



90-Line Basecoat Metallics / Solids

Solids/Metallic/Pearl/Multi-effect

Application: Metallic and solid color basecoat/clearcoat finish. Wet-on-wet process with Glasurit Clears 923-.

- Remarks:**
- Use water to clean tools. Paint residue dried to the tools can be removed with 700-1.
 - Collect and dispose all paint-related waste, including water used to clean tools, in accordance with local, state and federal regulations. Refer to 700-7 technical data sheet for more information.
 - Use of an air jet will significantly reduce the flash-off time of 90-Line.
 - Tinting bases must be shaken for 10 - 15 mins. on shaker before using or placing on a mixing rack. To ensure good color match, agitate tinting bases on a mixing rack 15 minutes before use and every 4 hours during the work day.
 - The following 90-Line materials have reduced shelf lives and must be protected from freezing: 90-M4, 90-M4EDT and 90-M4S (12 months from date of manufacture); 93-E3 and 93-E3S (12 months from date of manufacture); 90-M5 (12 months from the date of manufacture).
 - For ease of blending, the over reduction of up to 80% is recommended.
 - It is important to prepare the 90-Line as follows: Mix Color as per formula, stir well until uniform, add 590-100, stir well until uniform, add 93-E3, stir well until uniform, finally strain before application.

	Application	Basecoat	Basecoat with hardener
	Paint System	B7, B10, C1, C1a, D.S1, D.S3, D.S3a, D.S9, D.S9.1, D.S9.2	B7, B9, B10, C1, C1a, D.S1, D.S3, D.S3a, D.S9, D.S9.1, D.S9.2
	VOC ready for use	3.5 lbs/gal; 420 gms/liter or less	3.3 lbs/gal; 371 gms/liter or less
	Mixing ratio	2:1 100 parts by volume 90-Line (Stir intermix formula well prior to addition of any 93-E3 or 93-E3S)	10:0.5:4 100 parts by volume 90-Line (Stir intermix formula well prior to addition of any 93-E3 or 93-E3S)
	Hardener	—	5 parts by volume 590-100
	Reducer	50 - 80 parts by volume 93-E3 or 93-E3S (Stir well IMMEDIATELY after addition)	40 - 80 parts by volume 93-E3 or 93-E3S (Stir well IMMEDIATELY after addition)
	Spray viscosity DIN 4 at 68°F / 20°C	18 - 24 s	23 - 31 s
	Potlife at 68°F / 20°C	Mixed according to formula stored in plastic or lined cans - 6 month	24 hrs.
	Gravity cup / Spraying pressure	HVLP: 1.2-1.3 mm/10 psi at air cap (max.)	HVLP: 1.2-1.3 mm/10 psi at air cap (max.)
	Number of spray coats	2 plus 1/2 to harmonize the effect (appearance)	2 plus 1/2 to harmonize the effect (appearance)
	Film thickness	0.4 - 1.0 mil	0.4 - 1.0 mil
	Flash-off at 68°F / 20°C	Until matte after each coat 2 - 3 mins. or until matte before next step	Until matte after each coat 2 - 3 mins. or until matte before next step
	Sanding	Dirt nibs can be removed with a fine sanding pad, then blend in the area.	Dirt nibs can be removed with a fine sanding pad, then blend in the area.

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Material Safety Data Sheet (MSDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.