



Technical Service Bulletin

Procedure to De-nib Glasurit 90-Line

Number: GLABUL0189-E

The Glasurit Technical Laboratory has received several calls on how to de-nib Glasurit 90-Line as it tends to remain too soft and tacky for easy de-nibbing. The recommended procedure is as follows:

Without Glasurit 270-2:

- Flash off the 90-Line basecoat color until it has a completely matte finish.
- Let stand for 30 minutes with air flow in the booth or shop, or 20 minutes with driers. As shop conditions will vary, it may take slightly longer for the 90-Line Basecoat to dry to a matte finish.

or

- Heat the finish in a spray booth for 15 minutes @ 140°F/ 60°C, or use a short wave lamp for 5 minutes @ 140°F/ 60°C.
- Lightly wet sand the 90-Line Basecoat with 800 – 1200 grit sandpaper.

When using Glasurit 270-2:

- Flash off the 90-Line basecoat color until it has a completely matte finish.
- Let stand for 30 minutes with air flow in the booth or shop, or 20 minutes with driers. As shop conditions will vary, it may take slightly longer for the 90-Line Basecoat to dry to a matte finish.
- Lightly wet sand the 90-Line Basecoat with 800 – 1200 grit sandpaper.

The Glasurit Technical Laboratory does not recommend baking 90-Line basecoat if 270-2 has been added to the basecoat, as this may result in wrinkling or lifting issues.

DO NOT USE any solvent-based products for wet sanding, as they will disturb the base.

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