



SYSTEM INFORMATION

Glasurit® 90 Line tri-coat colours

1. Application

Refinishing process for 90 Line tri-coat colours, to improve hiding power and curing properties. The process is based on the filler grey shade concept. The filler in the matching grey shade replaces the first basecoat layer.

2. Properties

The additional basecoat layer in 90 Line tri-coat application processes may lead to (significantly) longer drying times. Consequently, the coating can become more sensitive to stone chipping and in extreme cases, it may cause wrinkling (deformation of the paint film) on pressure marks.

This may be caused by:

- higher basecoat thickness
- insufficient flash-off times

How to avoid that:

- Stick to the recommended flash-off times
- Flash off after each spraycoat until the surface is completely mat.
- Flash-off times can be reduced by additional ventilation with blow equipment (e.g. Dry Jet), brief increase of temperature in combined spraybooths or by intermediate drying at 60°C in the oven.
- An increasing basecoat thickness needs more flash-off time.

Note:

For certain colours it may be necessary to apply more basecoat to achieve the required hiding power. To make up for this limitation as good as possible, we recommend to use a coloured ground coat (step I) for colours that do not have sufficient hiding power. This ground coat colour can be defined directly when the respective basecoat colours are formulated and is assigned to the mixing formula as step I. This step I can either be a 90 Line basecoat mixing formula or a grey shade mixed from Glasurit 285-xxx HS Primer Fillers or from 285-38 and -49 Non-Sanding-Fillers.

We specifically recommend our filler mixtures because of the following advantages:

- Better drying properties
- Lower risk of applying too much basecoat
- Lower materials costs
- Better hiding power

3. Additional information

In order to avoid the application of too much basecoat, you should apply a filler coat in a matching grey shade for certain tri-coat colours that require two colouring basecoat layers.

Please also observe the instructions given in the Technical Data Sheets of the products.

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	Filler (Step I)	
	4 : 1 : 1 mixing stick	Glasurit 285-555 HS Primer Filler black / Glasurit 285-655 HS Primer Filler white Glasurit 929-55, -56 HS Filler Hardener Glasurit 352- Reducer
		HVLP 1.7 – 1.9 mm; 2.0 bar
	2	50 – 70 µm
	60°C	20 min.
	or	9 min.
		P 400
	Clean 1x	Glasurit 700-1 Cleaner
	Wipe dry	
Note: The filler blending concept consists of one white and one black filler that can be mixed with each other in order to achieve many different grey shades.		

Alternative: Glasurit® HS-Tintable Primer 285-95,
 or Glasurit® Primer Filler Pro 285-230, -270, -290
 or Glasurit® Primer Filler 285-700, -730, -790
 or Glasurit® non-sanding filler 285-31, -38, -49

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Alternative: When using solid colours as the first colouring basecoat layer, you may add 93-IC 330 to improve curing. Always check colour accuracy when using 93-IC 330. Please consult the technical data sheets of 93-IC 330 and 90 Line for further details.

	Basecoat (Step I)	
	100 : 5 : 50	Glasurit 90 Line Basecoat
		Glasurit 93-IC 330 Additive
		Glasurit 93-E 3 Adjusting Base, waterborne
		Stir thoroughly after adding each of the components.
		HVLP 1.3 mm; 2.0 bar
	2	10 – 15 µm
		Flash off for about 5 min between spraycoats and about 15 min before basecoat application (step II).
Note: The flash-off time can be reduced by using blow equipment or by briefly increasing the temperature to up to 60°C. Glasurit 93-IC 330 Additive cannot be used in mixing formulas containing Glasurit 11-E 20A, 11-E 30A or 11-E 30B Multi-Effekt. Please note that 93-IC 330 reduces the potlife of 90 Line to 2 hours.		

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	Basecoat (Step II)	
	2 : 1 mixing stick	Glasurit 90 Line Basecoat
		Glasurit 93-E 3 Adjusting Base, waterborne
		HVLP 1.3 mm; 2.0 bar
	1 – 2 ½	10 – 15 µm
		Flash off until mat between spraycoats and before clearcoat application
Note: The flash-off time can be reduced by using blow equipment or by briefly increasing the temperature to up to 60°C.		

	Clear	
	2 : 1 + 10% mixing stick	Glasurit 923-335 HS Multi Clear VOC
		Glasurit 929- VOC Hardener
		Glasurit 352- Reducer
		HVLP 1.3 mm; 2.0 bar
	2	40 – 60 µm
	60°C	30 min
Note: The product can be applied to vertical surfaces in ½ + 1 spraycoats without intermediate flash-off.		

Safety advice:

The products are suitable for professional use only.

It cannot be ruled out that these products contain particles < 0.1 µm.

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