

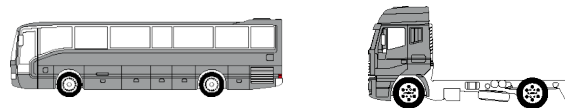


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We create chemistry

# 90-M 4 CV PLUS

Basecoat metallics/solids

**Application:**



busses, cabs (color change), boxes, bulk loading vehicles, busses (repair)

**Key Features:**

- good leveling
- suitable for large areas / surfaces
- excellent UV resistance
- good hiding power
- outstanding application characteristics

**Remarks:**

The complete color range for CV-application is covered.  
The substrate should be clean, free of dust, rust, oil and grease.  
Use P-P-31 to clean substrates after sanding.  
Mixing Base 90-M 4 CV PLUS + 90-M Tinting Base + Adjusting Base 93- E 3 CV PLUS = 90 CV PLUS

**Substrates**

- = Very well suited
- = well suited
- = suited in some cases

Steel	Galvanized steel	Stainless steel	Aluminium	Anodized Aluminium	GRP / SMC	PP-EPDM	Glasurit CV - Primer	Glasurit CV - Primer Filler / Filler	Powder coating	Coil-coating	Plywood	Wood	OEM-Paintwork	Old paint work
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<b>Spreading rate</b>	130 m <sup>2</sup> /l at 1 µm
<b>Solid Content</b>	~ 15 %

**Safety advice:**

It cannot be ruled out that this product contains particles < 0.1 µm.

The products are suitable for professional use only.

**2004/42/IIIB (d)(420)419:** The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/l. The VOC content of this product is 419 g/l.

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**Mixing Ratio** 2 : 1 by volume



**Reducer** 93-E 3 CV PLUS



**Spray viscosity at 20°C** DIN 4: 20-30 s

**Potlife at 20°C** 8 h

**Application:** **Compliant - gravity feed cup** **HVL spray gun** **Suction cup** **Airless/ Airmix** **Pressure pot dbl.-pump**

<b>Application pressure</b>	2 bar	2.5 bar
<b>Nozzle pressure</b>		0.8-1.5 bar
<b>Nozzle size</b>	1.5	1-1.1
<b>Number of coats</b>	2 + ½	2 + ½
<b>Flash off at 20°C</b>	until mat	until mat
<b>Film thickness</b>	10-15 µm	



<b>Drying</b>	<b>Overcoatable</b>	<b>Tack-free</b>	<b>Ready for masking</b>	<b>Ready to assemble</b>	<b>Sandable</b>
	Min. Max.				
<b>Object Temp. 20°C</b>	30 min 8 h				
<b>Object Temp. 60°C</b>	15 min				

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## Remark

Prespray one light spray coat, leave to flash off until mat. Then finish with one wet coat, leave to flash off until mat.

Apply ½ spray coat (minimum distance to the panel: 50 cm) to match the effect.

If required to reduce the viscosity afterwards use Glasurit 93-E 3 CV PLUS.

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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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