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.
## SYSTEM INFORMATION

### Glasurit® 90 Line tri-coat colors

<table>
<thead>
<tr>
<th><strong>Filler (Step I)</strong></th>
<th>Glasurit 285-555 HS Primer Filler black / Glasurit 285-655 HS Primer Filler white</th>
</tr>
</thead>
<tbody>
<tr>
<td>4 : 1 : 1 mixing stick</td>
<td>Glasurit 929-55, -56 HS Filler Hardener</td>
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<tr>
<td></td>
<td>Glasurit 352- Reducer</td>
</tr>
<tr>
<td></td>
<td>HVLP 1.7 – 1.9 mm; 2.0 bar</td>
</tr>
<tr>
<td>2</td>
<td>50 – 70 µm</td>
</tr>
<tr>
<td>60°C</td>
<td>20 min.</td>
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<tr>
<td>or</td>
<td>9 min.</td>
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<td></td>
<td>P 400</td>
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<tr>
<td></td>
<td>Clean 1x Glasurit 700-1 Cleaner</td>
</tr>
<tr>
<td></td>
<td>Wipe dry</td>
</tr>
</tbody>
</table>

**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

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these statements do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at www.glasurit.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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**SYSTEM INFORMATION**

### Glasurit® 90 Line tri-coat colors

**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.

<table>
<thead>
<tr>
<th>Basecoat (Step I)</th>
</tr>
</thead>
<tbody>
<tr>
<td>100 : 5 : 50</td>
</tr>
<tr>
<td>Glasurit 90 Line Basecoat</td>
</tr>
<tr>
<td>Glasurit 93-IC 330 Additive</td>
</tr>
<tr>
<td>Glasurit 93-E 3 Adjusting Base, waterborne</td>
</tr>
<tr>
<td>Stir thoroughly after adding each of the components.</td>
</tr>
<tr>
<td>HVLP 1.3 mm; 2.0 bar</td>
</tr>
<tr>
<td>2</td>
</tr>
<tr>
<td>10 – 15 µm</td>
</tr>
<tr>
<td>Flash off for about 5 min between spraycoats and about 15 min before basecoat application (step II).</td>
</tr>
</tbody>
</table>

**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 Mixing Base Concentrates 80-M. Please note that 93-IC 330 reduces the potlife of 90 Line to 2 hours.
### 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- Clear VOC (pls. see respective technical information sheet)  
| 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.

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**Safety advice:**  
The products are suitable for professional use only.  
It cannot be ruled out that these products contain particles < 0.1 µm.