SYSTEM INFORMATION

Glasurit® 55 Line procedure

Refinish paint system for the Nissan GT-R

1. Edge to edge repair

1-0 Process description

Paint system with improved surface hardness for Nissan GT-R with Line 55.

1-1.Application of surfacer

Apply 801-72 according to 801-72 technical information.
Apply 801-72 for excellent durability performance.

1-2.Pretreatment

1) Sand primer filler with a dual action sander P500.
2) Sand with dual action sander P600 to cover the sanding mark of P500.
3) Sand with dual action sander P800 to cover the sanding mark of P600.
4) Sand with dual action sander P1000 to cover the sanding mark of P800.
5) Degrease with 541-5

Note

- If the rough surface of primer filler remains, it will result in a scaly appearance
- If the sand-scratch marks of P500, P600 or P800 remains, it will affect the surface quality by mottling or telegraphing the sand-scratches
- Use guide coat prior to sanding to avoid over sanding.
- Use guide coat prior to sanding, then sand until it disappears in order to confirm that the sanding mark of the prior process does not remain.
- Use soft inter face pad for orbital sander.
SYSTEM INFORMATION

Glasurit® 55 Line procedure

Refinish paint system for the Nissan GT-R

1-3. Application of ground coat

Formulation of ground coat

<table>
<thead>
<tr>
<th>Volume</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>352-91</td>
<td>17,4 g</td>
</tr>
<tr>
<td>55-A 929</td>
<td>9,0 g</td>
</tr>
<tr>
<td>55-M 25</td>
<td>82,1 g</td>
</tr>
<tr>
<td>929-91</td>
<td>5</td>
</tr>
<tr>
<td>352-91</td>
<td>100</td>
</tr>
</tbody>
</table>

Spray coats: 1 wet coat
Flash Off: 15 min. at 20°C
Spray gun setting: HVLP 1.3 mm
Intake pressure 2.0 bar

Note

- For ground coat, apply wet coat to avoid generating peel on the surface.
- Allow the total dry time to expire in order to avoid creating a scaly surface.
SYSTEM INFORMATION

Glasurit® 55 Line procedure

Refinish paint system for the Nissan GT-R

1-4. Application of blending clear

<table>
<thead>
<tr>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>55-M 0</td>
</tr>
<tr>
<td>929-91</td>
</tr>
<tr>
<td>352-91</td>
</tr>
</tbody>
</table>

Spray coats: 1 coat
Dry time: 15 min at 60°C
Spray gun setting: HVLP 1.3 mm
Intake pressure 2.0 bar

Note
- For blending clear, apply wet coat to avoid generating peel on the surface.
- After dry time has expired allow part to cool to room temperature before applying KAB base coat.
SYSTEM INFORMATION

Glasurit® 55 Line procedure

Refinish paint system for the Nissan GT-R

1-5. Application of KAB colour

Formulation of KAB

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>KAB colour</td>
<td>100</td>
</tr>
<tr>
<td>929-91</td>
<td>5</td>
</tr>
<tr>
<td>352-91</td>
<td>110</td>
</tr>
</tbody>
</table>

Spray coat: 5 – 6 coats (Flash off until mat after each coat)
Dry time: 15 min. at 60°C
Spray gun setting: HVLP 1.3 mm
Intake pressure 2.0 bar

Note
- For KAB base coat, apply medium coat.
- Apply 2-3 mist coats after hiding has been achieved.
- Allow the total dry time to expire in order to avoid creating a scaly surface.

1-6. Application of 923-45 clear

Apply 923-45 clear according to technical information of 923-45 clear

Spray coats: 1.5 – 2 coats
Dry time: 30 min. at 60°C

Note
- On a vertical surface, apply 1 mist coat followed by a wet coat
- On a horizontal surface, apply 2 coats to ensure a smooth surface.
- The drying time is 60°C (surface temperature) 30 min.
SYSTEM INFORMATION
Glasurit® 55 Line procedure
Refinish paint system for the Nissan GT-R

2. Spot Repair

2-1.Application of surfacer

Apply 801-72 according to 801-72 technical information
Apply 801-72 for excellent durability performance.

2-2.Pretreatment

1) Sand primer filler with a dual action sander P500.
2) Sand with dual action sander P600 to cover the sanding mark of P500.
3) Sand with dual action sander P800 to cover the sanding mark of P600.
4) Sand with dual action sander P1000 to cover the sanding mark of P800.
5) Sand with dual action sander P1500 on the fade out zone.
6) Degrease with 541-5

Note

- If the rough surface of primer filler remains, it will result in a scaly appearance.
- If the sand-scratch marks of P500, P600 or P800 remains; it will affect the surface quality by mottling or telegraphing the sand-scratches.
- Use guide coat prior to sanding to avoid over sanding.
- Use guide coat prior to sanding, then sand until it disappears in order to confirm that the sanding mark of the prior process does not remain.
- Use soft inter face pad for orbital sander.
SYSTEM INFORMATION

Glasurit® 55 Line procedure

Refinish paint system for the Nissan GT-R

2-3. Application of blending clear (1)

<table>
<thead>
<tr>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>55-M 0</td>
</tr>
<tr>
<td>929-91</td>
</tr>
<tr>
<td>352-91</td>
</tr>
</tbody>
</table>

Spray coats: 1 wet coat
Dry time: 15 min at 60°C
Spray gun setting: HVLP 1.3 mm
Intake pressure 2.0 bar

Note
- For blending clear, apply wet coat.
- After dry time has expired allow part to cool to room temperature before applying KAB base coat

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.

BASF Coatings GmbH, Automotive Refinish Coatings Solutions Europe, Glasuritstrasse1, 48165 Münster, Germany 02/2013
2-4. Application of KAB colour (1)

Formulation of KAB

<table>
<thead>
<tr>
<th>KAB colour</th>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>929-91</td>
<td>5</td>
</tr>
<tr>
<td>352-91</td>
<td>110</td>
</tr>
<tr>
<td>KAB colour</td>
<td>100</td>
</tr>
</tbody>
</table>

Spray coat: 3 – 4 coats (Flash off until mat after each coat)
Spray gun setting: HVLP 1.3 mm
Intake pressure 1.0 – 1.5 bar

Note

- For KAB base coat, apply medium coat.
- Apply 2-3 mist coats after hiding has been achieved.
- Allow the total dry time to expire in order to avoid creating a scaly surface.
Refinish paint system for the Nissan GT-R

2-5. Application of blending clear (2)

<table>
<thead>
<tr>
<th>Volume</th>
<th>55-M 0</th>
<th>929-91</th>
<th>352-91</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>100</td>
<td>5</td>
<td>150</td>
</tr>
</tbody>
</table>

Spray coats: 1 wet coat
Flash off: no flash off
Spray gun setting: HVLP 1.3 mm
Intake pressure 2.0 bar

Note
- Before the mist coat of KAB base coat, apply a wet coat of blending clear on the blending area to avoid overspray mist.

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SYSTEM INFORMATION

Glasurit® 55 Line procedure

Refinish paint system for the Nissan GT-R

2-6. Application of KAB colour (2)

Formulation of KAB

<table>
<thead>
<tr>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>KAB colour</td>
</tr>
<tr>
<td>929-91</td>
</tr>
<tr>
<td>352-91</td>
</tr>
</tbody>
</table>

Spray coat: 2 – 3 coats (Flash off until mat after each coat)
Spray gun setting: HVLP 1.3 mm
Intake pressure 0.8 – 1.5 bar
Dry time: 15 min. at 60°C

2-7. Application of 923-45 clear

Apply 923-45 clear according to technical information of 923-45 clear

Spray coats: 1.5 – 2 coats
Dry time: 30 min. at 60°C

Note

- On a vertical surface, apply 1 mist coat followed by a wet coat
- On a horizontal surface, apply 2 coats to ensure a smooth surface.
- The drying time is 60°C (surface temperature) 30 min.

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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