



SYSTEM INFORMATION

Glasurit® 90 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 90.

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 700-1

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 interface pad for orbital sander

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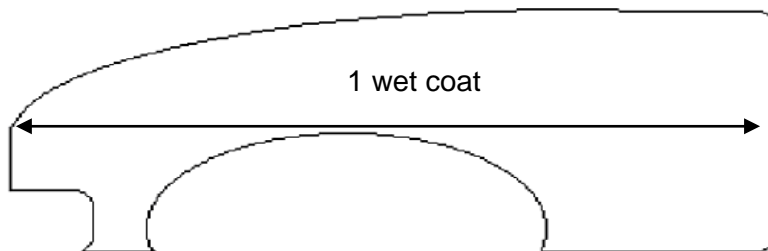
1-3. Application of ground coat

Formulation of ground coat	Volume
285-49	3
929-56	1
352-91	1

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

Note

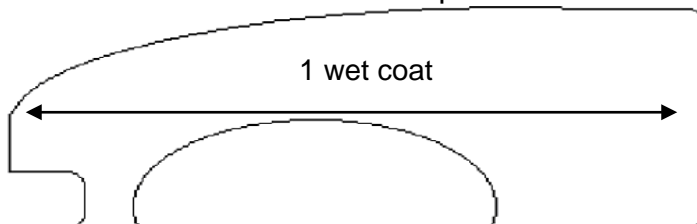
- For ground coat, apply wet coat to avoid generating peel on the surface.
- Allow the total dry time to expire in order to avoid creating a scaly surface.



1-4. Application of blending clear

	Volume
90-M 5	2
93-E 3	1

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



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1-5. Application of KAB colour

Formulation of KAB

KAB colour in 90-Line is only provided as factory package.

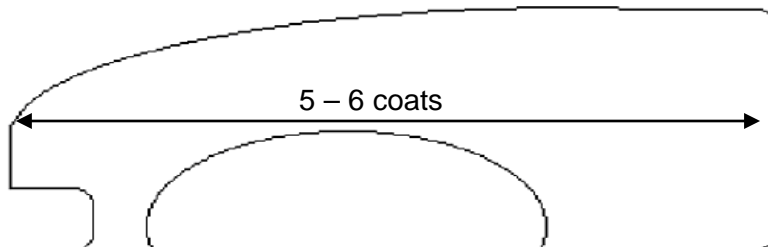
	Volume
KAB Factory pack	100
93-E 3 Adjusting base	50

(Stir immediately after having added adjusting base)

Spray coat:	5 – 6 coats (Flash off until mat)
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.

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2. Spot Repair

2-1. Application of surfacer

Apply 801-72 according to 801-72 technical information

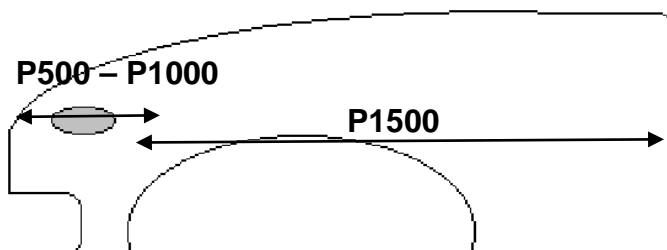
Apply 801-72 for excellent durability performance.

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 700-1

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.



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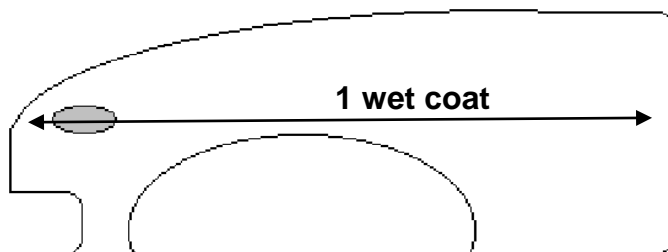
2-3. Application of blending clear (1)

	Volume
90-M 5	2
93-E 3	1

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



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2-4. Application of KAB colour (1)

Formulation of KAB

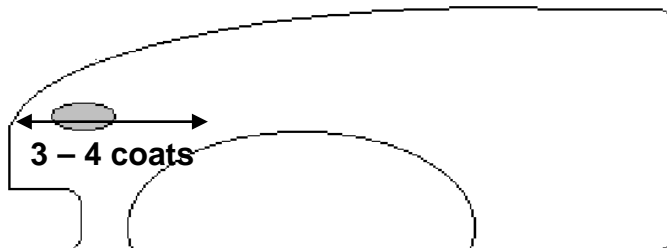
KAB colour in 90-Line is only provided as factory package.

	Volume
KAB Factory pack	2
93-E 3 adjusting base	1
(Stir immediately after having added adjusting base)	

Spray coat: 3 – 4 coats (Flash off until mat)
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.



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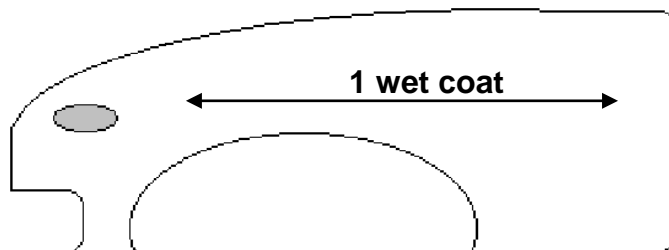
2-5. Application of blending clear (2)

	Volume
90-M 5	2
93-E 3	1

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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2-6. Application of KAB colour (2)

Formulation of KAB

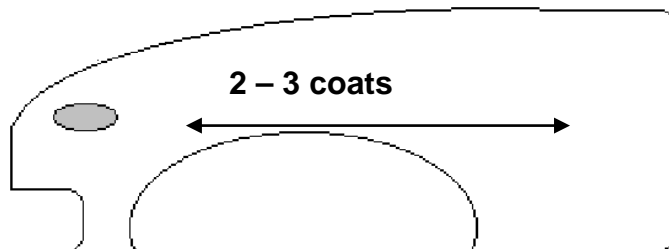
KAB colour in 90-Line is only provided as factory package.

	Volume
KAB Factory pack	2
93-E 3 adjusting base	1
(Stir immediately after having added adjusting base)	

Spray coat: 2 – 3 coats (Flash off until matte)

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 923-45clear

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 this product contains particles < 0.1 µm

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