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
Glasurit® 90 Line procedure

Refinish paint system for the Nissan GT-R

1-3. Application of ground coat

<table>
<thead>
<tr>
<th>Formulation of ground coat</th>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>285-49</td>
<td>3</td>
</tr>
<tr>
<td>929-56</td>
<td>1</td>
</tr>
<tr>
<td>352-91</td>
<td>1</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>90-M 5</td>
</tr>
<tr>
<td>93-E 3</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
Glasurit® 90 Line procedure

Refinish paint system for the Nissan GT-R

1-5. Application of KAB colour

Formulation of KAB

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

Vol.

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.
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.
Glasurit® 90 Line procedure
Refinish paint system for the Nissan GT-R

2-3. Application of blending clear (1)

<table>
<thead>
<tr>
<th></th>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>90-M</td>
<td>5</td>
</tr>
<tr>
<td>93-E</td>
<td>3</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
Glasurit® 90 Line procedure

Refinish paint system for the Nissan GT-R

2-4. Application of KAB colour (1)

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

<table>
<thead>
<tr>
<th>Volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>KAB Factory pack</td>
</tr>
<tr>
<td>93-E 3 adjusting base</td>
</tr>
<tr>
<td>(Stir immediately after having added adjusting base)</td>
</tr>
</tbody>
</table>

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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BASF Coatings GmbH, Automotive Refinish Coatings Solutions Europe, Glasuritstrasse1, 48165 Münster, Germany  01/2013

**SYSTEM INFORMATION**

**Glasurit® 90 Line procedure**

**Refinish paint system for the Nissan GT-R**

**2-5. Application of blending clear (2)**

<table>
<thead>
<tr>
<th>Volume</th>
<th>90-M 5</th>
<th>2</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>93-E 3</td>
<td>1</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.
Glasurit® 90 Line procedure
Refinish paint system for the Nissan GT-R

2-6. Application of KAB colour (2)

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

Volume

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>KAB Factory pack</td>
<td>2</td>
</tr>
<tr>
<td>93-E 3 adjusting base</td>
<td>1</td>
</tr>
</tbody>
</table>

(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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