

Technical Information

Spot Repair on the panel being repaired with Glasurit Basecoats – water-based – 90-Line Metallic/Solid Colors , Pearl Metallics, Multi-effect

B
26b

General Information:

The method of blending-in is used to overcome color differences. It involves the use of 90-M5 Blending Clear which allows the effect particles to align and lie down in the fade-out area and ensures at the same time that the edge of the overspray area is smooth and homogeneous. 90-M5 Blending Clear guarantees that the fade-out area does not show any dark marks.

1. Pre-treatment:

Prepare the substrate for topcoat application as usual.

Clean with:

Glasurit Cleaner **700-1** or
Glasurit Clean Fix **541-92**

Sand surrounding area with

Sanding pad (e.g. white from 3M) and
Glasurit Sand Fix **563-808**

Clean again with

Glasurit Cleaner **700-1** or
Glasurit Clean Fix **541-92**

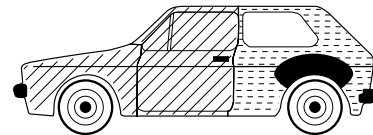
2. Spot repair on the panel being repaired

2.1 90-M5 Blending Clear

Mixing Ratio: 2:1
90-M5:93-E3
Spray viscosity: 18 - 22 sec DIN 4mm
Spray gun: HVLP, 1.3 mm
Spraying pressure: 2 - 3 bar/30 - 45 p.s.i.
intake pressure

Spray 1 wet coat on the panel being repaired.

No flash-off!

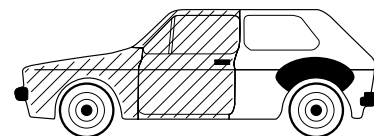


2.2 Basecoat 90-Line

Spray viscosity: 18 - 24 sec DIN 4mm
Spray gun: HVLP, 1.3 mm
Spraying pressure: 1 - 2 bar/15 - 30 p.s.i.
intake pressure

Spray 1 coat to cover on repaired area.

Flash-off until matte.*



* Use of the SATA DryJet (or equivalent) will significantly reduce the dry times.

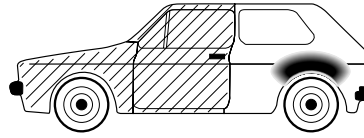


2.3 Basecoat 90-Line

Spray viscosity: 18 - 24 sec DIN 4mm
Spray gun: HVLP, 1.3 mm
Spraying pressure: 1 - 2 bar/15 - 30 p.s.i.
intake pressure

Blend in the fade-out zone (generously over rather a large area).

Flash-off before application of clear: 2 - 3 mins.



3. 923-Clear

