





923-209

Low VOC HS Klarlack Clear - Rapid Process with 522-20



A brand of BASF –
We create chemistry

- Application:** HS clear for basecoat/clearcoat systems (55-, 90-) with speed cure additive for blending.
- Key Features:** High solids content, low VOC, excellent resistance to weathering, outstanding finish, resistance to yellowing, very good gloss and holdout.
- Remarks:**
- No flex additive needed for flexible parts.
 - To polish or remove dust particles: after 24 hrs. air dry, or when cool after force drying, wet sand with 1200 grit or finer sandpaper and then polish with fine polishing compound and/or liquid polish. Two mils of clearcoat (dry film) must remain over basecoat. If extensive color sanding is anticipated, apply an additional coat of clear.
 - Measure amount of 522-20 carefully!
 - Use 2% max 522-20 in 923-209.

VOC ready for use	242 g/l	2 lb/gal
 Mixing Ratio	100 parts by volume	923-209
 Hardener	50 parts by volume	929-91
 Reducer	10 parts by volume	352-91, -216
Additive	2 parts by volume	522-20
 Spray viscosity at 68°F / 20°C	DIN 4:	14-16 s
Potlife at 68°F / 20°C	2 h	

Safety advice:



Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Safety Data Sheet (SDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.



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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Application pressure	20-29 psi	
Nozzle pressure		10 psi
Nozzle size		1.2-1.4 mm
Number of spraycoats	2	
Flash-off at 68°F / 20°C	5 min between coats	
Film thickness	2-2.5 mil	

	Drying at 68°F / 20°C	2-2.5 h
	Drying at 140°F / 60°C	30 min
	Infrared (short wave)	8 min
	Infrared (medium wave)	10-15 min

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document

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