

# 923-210

Low VOC Ultimate Clear - 2:1 Mixing Ratio - Flexible with 522-333



A brand of BASF –  
We create chemistry

- Application:** HS Clear for 2 coat paintwork, elastified for use on flexible parts.
- Key Features:** Excellent resistance to weathering and yellowing. Very good gloss, hardness and hold out. Does not require reactive reducers.
- Remarks:**
- Choose hardener according to temperature and size of object to be painted. Drying time will vary accordingly.
  - When using 923-210 over 55-Line, the use of 355-55 in the basecoat (10:1:4) is optional.
  - 923-210 can be mixed using one of two possible mix ratios as needed depending on your shop or weather conditions.
  - 352-720 is recommended for use in normal to high temps and normal to lower humidities. 352-740 is recommended for use in normal to high temps and normal to high humidities.
  - 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.
  - Elastifier must be added to use 923-210 over flexible parts.

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**VOC ready for use**                      250 g/l                      2.1 lb/gal

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**Mixing Ratio Pre-Mix**

100 parts by volume 923-210  
25 parts by volume 522-333

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**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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**2:1+10 %**



**Mixing Ratio**

100 parts by volume      Pre-Mix



**Hardener**

50 parts by volume      929-100, -105, -115, -120, -130



**Reducer**

0-10 parts by volume      352-25, -45, -720, -740



**Spray viscosity at 68°F / 20°C**

DIN 4:      15-18 s

**Potlife at 68°F / 20°C**

1 h

**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  
medium wet coats

**Flash-off at 68°F / 20°C**

10 min  
between coats

**Film thickness**

2-2.5



**Drying at 68°F / 20°C**

2 h

**Drying at 140°F / 60°C**

30 min



**Infrared (short wave)**

7 min

**Infrared (medium wave)**

10 min

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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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