923-210

Low VOC Ultimate Clear - 2:1 Mixing Ratio - Gloss Reducing with 522-422

A brand of BASF –
We create chemistry

Application: HS Clear for 2 coat paintwork, with gloss reducing additive for matte finish.

Key Features: Excellent resistance to weathering and yellowing. Very good 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.
- Prepare only the quantity of clear that will be used the same day because the gloss level may change when the mixture is stored for more than 30 days.
- Stir well after adding 522-422.
- The gloss reduction will not be sufficient if used with Elastifiers.
- Filter with a fine strainer after mixing.
- Use of 522-422 will reduce the useable potlife of 923-210.

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

Mixing Ratio

Step 1:

100 parts by volume	923-210
50 parts by volume	929-100, -105, -115, -120, -130
10 parts by volume	352-25, -45, -720, -740

Step 2:

100 parts by volume	Activated 923-210
100 parts by volume	522-422

(Stir well after adding 522-422. Filter with a fine strainer after mixing.)

Spray viscosity at 68°F / 20°C	DIN 4:	15-18 s
Potlife at 68°F / 20°C	1 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.

08/2022

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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 medium wet coats	
Flash-off at 68°F / 20°C	10 min between coats	
Film thickness	2-2.5	
Application remark	In order to avoid any gloss deviation when refinishing matte coatings, it is important: • to observe the recommended film thickness • to apply staggered overlaps to produce consistent clear coat film thickness • to allow the low gloss coating to flash off until completely matte after each spray coat. (Generally, after the first spray coat 10-15 min and after the second spray coat 15-20 min. This depends on air speed and spraybooth temperature.) Do not flash off for more than 25 min after each spray coat.	

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

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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