923-210

Low VOC Ultimate Clear - 3:1 Mixing Ratio, for climate specific conditions

A brand of BASF –
We create chemistry

Application: HS Clear for 2 coat paintwork.

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.
- 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.
- 923-210 can be mixed using one of two possible mix ratios (2:1 or 3:1) as needed depending on your shop or weather conditions.
- 923-210 can be used with the following additives: 522-333 for flexible repairs, 522-422 for altering gloss level, and 522-20 for speed cure. Please see the relevant TDSs for more information.

VOC ready for use	250 g/l 2.1 lb/gal	
	3:1+20 %	
Mixing Ratio	300 parts by volume	923-210
Hardener	100 parts by volume	929-245, -250
Reducer	60 parts by volume	352-720, -740 (up to 60 parts by volume)
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.

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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	2-0 mil	

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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