

923-255





HS Multi-Clear - 90 Line only or 100 Line only - Rapid Process with 522-20



A brand of BASF –
We create chemistry

- Application:** HS clear for basecoat/clearcoat systems (90 Line and 100 Line only), with speed cure additive.
- Key Features:** High solids content, excellent resistance to weathering, outstanding finish, resistance to yellowing, hardness, fast drying, good polishing behavior and tape resistance.
- Remarks:**
- This version of 923-255 may only be used over 90-Line or 100-Line, as use of this version over 55-Line is not compliant with U.S. National Rule.
 - Choose hardener and reducer according to temperature and size of object to be painted.
 - 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.
 - On vertical surfaces, application in one spraycoat: use 2:1 mixing ratio, no reducer.
 - Potlife at 68°F / 20°C : reduced from 4 hrs, but may vary

VOC ready for use 527 g/l 4.4 lb/gal

	Mixing Ratio	100 parts by volume	923-255
	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: 18-20 s	

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		2-3 min between coats
Film thickness	2-2.5 mil	



Drying at 68°F / 20°C 8 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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