923-255



A brand of BASF – We create chemistry

HS Multi-Clear - Flexible with 522-111 at 2:1

Applicatio	on:	HS clear for basecoat/cle	arcoat systems (55-, 90-, 100-).		
Key Features:		High solids content, excellent resistance to weathering, outstanding finish, resistance to yellowing, hardness, fast drying, good polishing behavior and tape resistance.			
Remarks:		 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. 			
VOC ready	VOC ready for use 497 g/l 4.1 lb/gal				
	Mixing Ratio Pre-Mix	100 parts by volume 923-255 50 parts by volume 522-111			
		2:1+10 %			
	Mixing Ratio	100 parts by volume	Pre-Mix		
Ð	Hardener	50 parts by volume	929-91, -93, -94		
	Reducer	10 parts by volume	352-25, -45		
₽ _s	Reducer Spray viscosity at 68°F / 20°C	10 parts by volume DIN 4: 18-20 s	352-25, -45		

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-fee	Compliant gravity-feed spray	
Applicati	on pressure	20-29 psi		
Nozzle p	ressure			10 psi
Nozzle si	ize			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	
\bigcirc	Drying at 68°F / 20°C	12 h		
	Drying at 140°F / 60°C	45 min		
R	Infrared (short wave)	12 min		
	Infrared (medium wave)	15-23 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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