

923-345





Anti-Scratch 2.1 VOC HS Clear - Rapid Process with 522-20



A brand of BASF –
We create chemistry

- Application:** A scratch-resistant HS clear 55-, 90-Line basecoat/clearcoat systems, with speed cure additive.
- Key Features:** High solids content; scratch-resistant; outstanding weathering and yellowing resistance; excellent finish quality.
- Remarks:**
- The addition of the elastifier additive (Glasurit Elastifier Additive 522-111 or Low VOC Elastifier Additive 522-333) will change the scratch resistance characteristics of this clearcoat. As such, Glasurit 923-345 is not recommended for use over flexible parts.
 - Suitable for repairing scratch-resistant original finishes.
 - Choose reducer according to temperature and size of object to be painted
 - Potlife at 68°F / 20°C : reduced from 2 hrs, but may vary

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

	Mixing Ratio	100 parts by volume	923-345
	Hardener	100 parts by volume	929-346
	Reducer	10 parts by volume	352-25, -45
	Additive	2 parts by volume	522-20
	Spray viscosity at 68°F / 20°C	DIN 4: 16-17 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 medium coats	
Flash-off at 68°F / 20°C	5 min between coats	
Film thickness	2-2.4 mil	

	Drying at 68°F / 20°C	10 h
	Drying at 140°F / 60°C	45 min
	Infrared (short wave)	10 min
	Infrared (medium wave)	20-30 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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