

# 923-365

Glamour Production Clear - National Rule - Rapid Process with 522-20



A brand of BASF –  
We create chemistry

- Application:** 923-365 Glamour Production Clear is a 2 component clearcoat that is compliant in both Low VOC and National Rule markets for topcoat of Glasurit basecoats. 923-365 is designed to meet high throughput demands of shops. The application described here is for the use of 923-365 with the 522-20 speed cure additive.
- Key Features:** This clear exhibits the appearance of a glamour clear while reducing “bake cycle time” of the shop. It is ideal for 1-4 panel repairs, very easy application, with a recommended baking condition of at least 15 minutes at 140°F/60°C. Fast drying when baked with excellent hold-out under all environmental conditions.
- Remarks:**
- Choose hardener and reducer according to temperature and size of object to be painted. Drying time will vary accordingly.
  - Vehicle can be immediately recoated, sanded and compounded 2 hours after recommended bake or air-dry times.
  - To polish or remove dust particles: when cool after force drying, wet/dry sand with 1500 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.
  - Potlife at 68°F / 20°C : reduced from 1 hr, but may vary

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**VOC ready for use**                      500 g/l                      4.1 lb/gal

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**Mixing Ratio**

100 parts by volume                      923-365



**Hardener**

50 parts by volume                      929-93, -94



**Reducer**

20 parts by volume                      352-50, -91, -216, -319, -720, -740

**Additive**

2 parts by volume                      522-20



**Spray viscosity at 68°F / 20°C**

DIN 4:                      12-14 s

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**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	2-2.5 mil DFT / Coverage @ 1mil = 590-620 (mils*ft2 / gal)	



**Drying at 68°F / 20°C** 1.5-2 h

**Drying at 140°F / 60°C** 15-20 min



**Infrared (short wave)** REVO RAPID MC2 program: Flash Off at 140°F / 60°C - 3 mins Drying at 180°F / 82°C - 6 mins.



**Polishing**

After 2.5 hrs. air dry or after cool down after bake cycle.

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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