


923-450

Multi-Temp Baking Clear - for large panel applications - Flexible with 522-111



A brand of BASF –
We create chemistry

- Application:** Clear for 2 coat paintwork (wet-on-wet procedure). This procedure is for large panel and complete applications with flex additive.
- Key Features:** Excellent resistance to weathering. Very good gloss, hardness and hold out. Fast drying and taping. Recommended for baking conditions ranging in temperature from 100°F / 38°C to 180°F / 82°C.
- Remarks:**
- Choose hardener and reducer according to temperature and size of object to be painted. Drying time will vary accordingly.
 - Must be activated with 929-93 for temperatures less than 85°F/29°C and 929-94 for temperatures greater than 85°F/29°C.
 - For best results, flash five minutes prior to baking.
 - Vehicle can be immediately recoated without sanding within 15 minutes of application. If longer, clearcoat may be recoated after it has been completely cured, cooled, and sanded.
 - To polish or remove dust particles: 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.

VOC ready for use	500 g/l	4.1 lb/gal
 Mixing Ratio Pre-Mix	100 parts by volume	923-450
	25 parts by volume	522-111

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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2:1+10 %



Mixing Ratio

100 parts by volume Pre-Mix



Hardener

50 parts by volume 929-93, -94
Must be activated with 929-93 for temperatures less than 85°F/29°C and 929-94 for temperatures greater than 85°F/29°C.



Reducer

10 parts by volume 352-50, -91, -216



Spray viscosity at 68°F / 20°C

DIN 4: 12-15 s

Potlife at 68°F / 20°C 3 h

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

5-15 min
between coats

Film thickness

2-2.5 mil

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	Drying	929-93	929-94
	Drying at 122°F / 50°C	38-50 min	
	Drying at 140°F / 60°C	38-44 min	38 min
	Drying at 158°F / 70°C	19 min	19 min
	Drying at 176°F / 80°C	13 min	13 min
	Infrared (short wave)	13-15 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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