

923-450

Multi-Temp Baking Clear - for large panel applications







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.
- 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, sanded and compounded when cooled.
 - 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.
 - This RFU formulation of 923-450 can be used with the following additives: 522-111 or 522-333 for flexible parts, and 522-322 for altering gloss level. Please see the relevant TDSs for more information.

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

2:1+10 %

	Mixing Ratio	100 parts by volume	923-450
	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, -319, -720, -740 (352-740 for temps above 85°F / 29°C)
	Spray viscosity at 68°F / 20°C	DIN 4:	12-15 s
	Potlife at 68°F / 20°C	3 h	

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.



923-450

Multi-Temp Baking Clear - for large panel applications



A brand of BASF –
We create chemistry

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	

	Drying	929-93	929-94
	Drying at 122°F / 50°C	30-40 min	
	Drying at 140°F / 60°C	30-35 min	30 min
	Drying at 158°F / 70°C	15 min	15 min
	Drying at 176°F / 80°C	10 min	10 min
	Infrared (short wave)	10-12 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

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.