






# 923-450

Multi-Temp Baking Clear - for spot and medium panel repairs - 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 spot and medium panel repairs with flex additive.
- Key Features:** Excellent resistance to weathering. Very good gloss, hardness and hold out. Fast drying and taping.
- Remarks:**
- Choose reducer according to temperature and size of object to be painted. Drying time will vary accordingly.
  - Do NOT force dry when using hardener 929-91.
  - 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.

<b>VOC ready for use</b>	500 g/l	4.1 lb/gal
 <b>Mixing Ratio Pre-Mix</b>	100 parts by volume	923-450
	25 parts by volume	522-111
	<b>2:1+10 %</b>	
 <b>Mixing Ratio</b>	100 parts by volume	Pre-Mix
 <b>Hardener</b>	50 parts by volume	929-91
 <b>Reducer</b>	10 parts by volume	352-50, -91, -216
 <b>Spray viscosity at 68°F / 20°C</b>	DIN 4:	12-15 s
<b>Potlife at 68°F / 20°C</b>	2 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 spot and medium panel repairs - Flexible with 522-111



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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 wet coats	
Flash-off at 68°F / 20°C	5-15 min between coats	
Film thickness	2-2.5 mil	



**Drying at 68°F / 20°C**

3.75 h  
Do NOT force dry when using  
929-91 hardener.

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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