






# 923-450

Multi-Temp Baking Clear - for spot and medium panel repairs - Semi-Gloss with 522-322



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 flexible gloss reducer 522-322 for a semi-gloss finish.
- Key Features:** Excellent resistance to weathering. Very good 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.
  - Stir well after adding 522-322.
  - May be used on plastic parts without the addition of Elastifier Additive 522-111 or Low VOC Elastifier Additive 522-333.

<b>VOC ready for use</b>	500 g/l	4.1 lb/gal
 <b>Mixing Ratio Pre-Mix</b>	100 % by weight	923-450
	25 % by weight	522-322
<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.

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522-322



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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
<b>Application pressure</b>	20-29 psi	
<b>Nozzle pressure</b>		10 psi
<b>Nozzle size</b>		1.2-1.4 mm
<b>Number of spraycoats</b>	2 medium wet coats	
<b>Flash-off at 68°F / 20°C</b>	5-15 min between coats	
<b>Film thickness</b>	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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