





923-645



HS Clear scratch-resistant VOC



A brand of BASF –
We create chemistry

Application: HS clearcoat for Glasurit waterborne basecoats for repairing scratch-resistant original finishes.
Key Features: Extremely scratch-resistant clearcoat with good polishability and outstanding finish quality.
Remarks: Select hardener and reducer according to ambient temperature and size of object to be painted.

		3:1:1			
	Mixing Ratio	100 % by volume	923-645		
	Hardener	33 % by volume	929-61, -63, -64		
	Reducer	33 % by volume	352-10, -30, -40		
	Spray viscosity at 20°C	DIN 4:	18-21 s	Potlife at 20°C	1 h

Application:		Compliant gravity-feed spray gun		HVLP spray gun
Application pressure	bar	2		
Nozzle pressure	bar		0.7	
Nozzle size		1.3-1.4	1.3	
Number of spray coats		2		
Flash off at 20°C	min	app. 3 min. intermediate flash off between the application of two spraycoats.		
Film thickness	µm	40-60		
Application Remark		Alternatively: ½ + 1 spraycoats, no flash-off between coats required		

Safety advice:

The products are suitable for professional use only.

It cannot be ruled out that this product contains particles < 0.1 µm.

2004/42/IIIB(d)(420)419: The EU limit value for this product (product category: IIB.d) in ready to use form is max 420 g/litre of VOC. The VOC content of this product is 419 g/litres.



The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at www.glasurit.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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	Drying at 20°C	10 h Drying times can be influenced by the selection of hardener, reducer and application.
	Drying at 60°C	30 min Drying times can be influenced by the selection of hardener, reducer and application.
	Infrared (short wave)	8 min
	Infrared (medium wave)	10-15 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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