

Glasurit® Racing Additive



- Application:** Drying accelerator for Glasurit standard clears (VOC-compliant and non-VOC-compliant), 22 Line, 22 Line VOC, 22 VOC MC600, and 285- HS-Primerfiller / Filler
- Properties:**
- Reduction of drying times
 - Improves surface drying and curing performance as well as tape resistance
- Remarks:** No add of 523-15 Racing Additive in 285- Primerfiller / Filler at temperatures > 25°C possible, due to too short potlife

	Paint system	Clear coat			
	Mixing ratio	2 : 1 + 10 % 100% by vol.	VOC-compliant clear 923-35 923-115 923-135 923-335	2 : 1 + 10 % 100% by vol.	Clear 923-144 923-155 923-255 923-525 923-530
	Hardener	50% by vol.	929-31, -33		929-91, -93
	Reducer	10% by vol.	523-15	10% by vol.	523-15
	Spray viscosity DIN 4 at 20°C	16 – 22 s, depending on product used		Potlife at 20°C:	45 - 120 min., depending on product used
	Gravity cup Spraying pressure	HVLP gun: 1.3 mm 2.0 – 3.0 bar / 0.7 bar at the nozzle	Compliant gravity-feed gun 1.3 – 1.4 mm, 2.0 bar		
	Number of spraycoats	½ + 1		½ + 1 2	923-255 923-144, - 155, -525, -530
		Film thickness:	40 - 60 µm	Film thickness:	40 - 60 µm
	Drying at 20 °C	923-135 923-35, -115, -335	1 h 4 h	923-144 923-155, -255, -525, -530	1 h 3 h
	Drying at 60 °C	923-135 923-35, -115, -335	15 min. 20 min.	923-144 923-155, -255, -525, -530	10 min. 20 min.
	Infrared (short wave) Infrared (medium wave)	6 min. 8 - 12 min.			

Safety advice:

The products are suitable for professional use only.
It cannot be ruled out that this product contains particles < 0.1 µm.

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	Paint system	Clear coat		
	Mixing ratio	3 : 1 : 1	VOC-compliant clear	
	Hardener	100% by vol.	923-610	
			923-625	
			923-630	
	Reducer	33% by vol.	929-61, -63	
	Spray viscosity DIN 4 at 20°C	33% by vol.	523-15	
	Spray viscosity DIN 4 at 20°C	18 - 21 s, depending on product used	Potlife at 20°C:	30 - 120 min., depending on product used
	Gravity cup Spraying pressure	Compliant gravity-feed gun 1.3 – 1.4 mm, 2.0 bar	HVLP gun: 1.3 mm 2.0 – 3.0 bar / 0.7 bar at the nozzle	
	Number of spraycoats	½ + 1 2	Film thickness:	40 - 60 µm
	Flash-off at 20°C	approx. 3 min intermediate flashoff when two spraycoats are applied		
	Drying at 60 °C Drying at 40 °C Drying at 20 °C	923-610 10-15 min, improved polishability 30 min 3 - 4 h	923-625 15 - 20 min 30 - 45 min 4 h	923-630 20 min - 4 h

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	Paint system	22 Line VOC and 22 Line			
	Mixing ratio	2 : 1 + 10 % 100% by vol.	22 Line VOC 22 Line VOC	2 : 1 + 10 % 100% by vol.	22 Line 22 Line
	Hardener	50% by vol.	929-31, -33	50% by vol.	929-91, -93
	Reducer	10% by vol.	523-15	10% by vol.	523-15
	Spray viscosity DIN 4 at 20°C	20 – 24 s, depending on product used		Potlife at 20°C:	30 min.
	Gravity cup Spraying pressure	HVLP gun: 1.3 mm 2.0 – 3.0 bar / 0.7 bar at the nozzle		Compliant gravity-feed gun 1.3 – 1.4 mm, 2.0 bar	
	Number of spraycoats	2 intermediate flash-off app. 5 min. Film thickness: 50 - 70 µm		2 intermediate flash-off app. 5 min. Film thickness: 50 - 70 µm	
		½ + 1 can be applied to vertical surfaces (no flash-off between coats required) Film thickness: app. 50 µm		½ + 1 can be applied to vertical surfaces (no flash-off between coats required) Film thickness: app. 50 µm	
	Drying at 20 °C	4 h		4 h	
	Drying at 60 °C	20 min.		15 min.	
	Infrared (short wave)	6 min.		6 min.	
	Infrared (medium wave)	8 - 12 min.		8 - 12 min.	

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	Paint system	22 VOC MC600	
	Mixing ratio	3 : 1 : 1	22 VOC MC600
	Hardener	100% by vol.	22 VOC MC600
	Reducer	33% by vol.	929-61, -63
	Spray viscosity DIN 4 at 20°C	33% by vol.	523-15
	Gravity cup Spraying pressure	20 – 24 s, depending on product used	Potlife at 20°C: 30 min.
	Number of spraycoats	HVLP gun: 1.3 mm 2.0 – 3.0 bar / 0.7 bar at the nozzle	Compliant gravity-feed gun 1.3 – 1.4 mm, 2.0 bar
	Drying at 20 °C	2 intermediate flash-off app. 5 min. Film thickness: 50 - 70 µm	
	Drying at 60 °C	½ + 1 can be applied to vertical surfaces (no flash-off between coats required) Film thickness: app. 50 µm	
	Drying at 20 °C	4 h	4 h
	Drying at 60 °C	20 min.	15 min.
	Infrared (short wave)	6 min.	6 min.
	Infrared (medium wave)	8 - 12 min.	8 - 12 min.

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	Paint system	HS-Primerfiller / Filler			
	Mixing ratio	4 : 1 : 1 100% by vol.	HS-Primerfiller 285-505 285-555 285-655	3 : 1 : 1 100% by vol.	Non-Sanding-Filler 285-31 285-38 285-49 285-95 285-0
	Hardener	25% by vol.	929-55, -56	33% by vol.	929-56 / -55
	Reducer	25% by vol.	523-15	33% by vol.	523-15
	Spray viscosity DIN 4 at 20°C	14 – 22 s, depending on product used		Potlife at 20°C:	30 – 60 min., depending on product used
	Gravity cup Spraying pressure	HVLP gun: 1.7-1.9 mm 2.0 - 3.0 bar / 0.7 bar at the nozzle Compliant gravity-feed gun 1.6 – 1.8 mm, 2.0 bar		HVLP gun: 1.3 mm 2.0 – 3.0 bar / 0.7 bar at the nozzle Compliant gravity-feed gun 1.3 – 1.4 mm, 2.0 bar	
	Number of spraycoats	2 Film thickness: 50 – 70 µm		½ + 1 Film thickness: 20 – 35 µm	
	Drying at 20 °C	1,5 h		10 min. (*)	
	Drying at 60 °C	10 min.		-	
	Infrared (short wave)	4 min.		-	
	Sanding: manual	P400 - P600		(*) If the recommended drying time is exceeded by more than 20 min, the panel has to be lightly scuff-sanded.	
	Sanding: orbital sander	P400 - P500		-	

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	Paint system	Primerfiller	
	Mixing ratio	4 : 1 : 1 100% by vol.	285-700 285-730 285-790
	Hardener	25% by vol.	929-55, -56
	Reducer	25% by vol.	523-15
	Spray viscosity DIN 4 at 20°C		Potlife at 20°C: 20 min.
	Gravity cup Spraying pressure	HVLP gun: 1.7 – 1.9 mm 2.0 – 3.0 bar / 0.7 bar at the nozzle	Compliant gravity-feed gun 1.6 – 1.8 mm, 2.0 bar
	Number of spraycoats	2 Film thickness: 50 - 70 µm	
	Drying at 20 °C	1,5 h	
	Drying at 60 °C	15 min.	
	Infrared (short wave)	6 min.	
	Sanding: manual	P800	
	Sanding: orbital sander	P400 - P500	

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