










## Glasurit® Mat Clear System

- Properties:** Refinishing process for 90 Line basecoat/clearcoat systems with Glasurit 923-55 MS Clear extra mat and Glasurit 923-57 MS Clear mat elastified.
- Substrates:** Please see the Glasurit RATIO System TDS for the refinishing steps up to the application of 90 Line.
- Remarks:**
- Due to the different mixing ratio ratios of the clears to be used, you may achieve a gloss level between 12-65 units (at an angle of 60°). The gloss level may be higher for light and pure silver colours. Additionally, car bodies may show gloss level differences between vertically and horizontally coated panels. Therefore, we recommend to produce a spray-out sample before each refinishing job and to compare it with the area to be repaired.
  - Stir the 923-55 and 923-57 clears well before use!
  - In order to avoid any gloss deviation when refinishing mat clearcoats, it is important
    - to observe the recommended film thicknesses for basecoat and clearcoat
    - to apply staggered overlaps to produce consistent basecoat and clearcoat film thicknesses.
    - to allow the clear to flash off until completely mat after each spraycoat. (Generally, after the first spraycoat 10-15 min and after the second spraycoat 15-20 min. That depends on air speed and spraybooth temperature.) Do not flash off for more than 25 min after each spraycoat.
  - With mat surfaces it is not possible
    - to remove dust inclusions by polishing because polishing changes the gloss level. Therefore, it is very important to work very carefully during cleaning and application.
    - to fade out the clear because the film thickness in the blending area varies, which changes the gloss level. Therefore, always apply the clear to the whole panel!
  - Please also observe the technical product data sheets for Glasurit 923-55 MS Clear extra mat and Glasurit 923-57 MS Clear mat elastified.

<b>Cleaning</b>	 700-1 1x	 wipe dry	 P400 - P500	 700-1 1x	 wipe dry	
<b>90 Line</b>	<b>90 Line Glasurit® Basecoat</b>	<b>93-E3 Glasurit® Adjusting base</b>	 2:1 mixing stick	 HVLV 1.3 mm 2.0-3.0 bar	 2 + 1/2 10 - 15 µm	 Flash off until mat after each spraycoat

### Safety advice:

The products are suitable for professional use only.






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

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 <http://techinfo.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.



## Glasurit® Mat Clear System

### Option 1: Mix Glasurit 929-93 HS Topcoat Hardeners with Glasurit Clears:

<b>Clear</b>	<b>923-55, -57</b> Mixture: Glasurit® MS Clear	<b>929-93</b> Glasurit® HS Topcoat Hardener	<b>352-91</b> Glasurit® Reducer normal	 2:1+10% mixing stick	 HVLP 1.3 mm 2.0 bar	 2 40-50 µm	 Flash off until mat after each spraycoat	 30 min. at 60 °C
	<p><b>Note:</b> Flash off until mat after each spraycoat and before baking. After the first spraycoat, allow to flash off at least 10 min, after the second spraycoat for at least 15 min. Do not flash off for more than 25 minutes after each spraycoat.</p>							

**Note:** Flash off until mat after each spraycoat and before baking.  
After the first spraycoat, allow to flash off at least 10 min, after the second spraycoat for at least 15 min.  
Do not flash off for more than 25 minutes after each spraycoat.

**Mixing ratio:**

Mixing ratio of Glasurit clears to achieve a gloss level of 20-65 units when using Glasurit 929-93 HS Topcoat Hardener			
Gloss level +/- 2 at an angle of 60°	923-55	923-57	923-255
	Mixing ration (% by weight):		
20	100	-	-
25	60	40	-
30	40	60	-
40	20	80	-
53	-	100	-
65	-	75	25

**Further treatment:** Mat surfaces cannot be polished to remove dust inclusions.

**Safety advice:**






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## Glasurit® Mat Clear System

### Option 2: Mix Glasurit 929-33 VOC Hardener with Glasurit Clears:

<b>Clear</b>	<b>923-55, -57</b> Mixture: Glasurit® MS Clear	<b>929-33</b> Glasurit® Hardener VOC	<b>352-91</b> Glasurit® Reducer normal	 100% by weight 33% by weight 17% by weight	 HVLP 1.3 mm 2.0 bar	 2 40-50 µm	 Flash off until mat after each spraycoat	 30 min. at 60 °C

**Note:**

Flash off until mat after each spraycoat and before baking.  
After the first spraycoat, allow to flash off for at least 10 min, after the second spraycoat for at least 15 min.  
Do not flash off for more than 25 minutes after each spraycoat.

**Mixing ratio:**

Mixing ratio of Glasurit clears to achieve a gloss level of 12-65 units when using Glasurit 929-33 VOC Hardener			
Gloss level +/- 2 at an angle of 60°	923-55	923-57	923-335 923-115 923-35
	Mixing ratio (% by weight)		
12	100	-	-
20	50	50	-
25	30	70	-
30	20	80	-
40	-	100	-
53	-	90	10
65	-	75	25

**Further treatment:** Mat surfaces cannot be polished to remove dust inclusions.

**Safety advice:**

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

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