





# 923-610



HS clear coat fast drying



A brand of BASF –  
We create chemistry

- Application:** HS Clear for Glasurit waterborne basecoats.  
For universal application in quick repair jobs on single panels up to a complete car side.
- Key Features:** Fast drying, excellent polishing behavior and universal application.
- Remarks:**
- Select hardener, reducer and reducer percentage according to ambient temperature and size of object to be painted.
  - Use reducer 352-70 only in combination with 929-63, -64 and with very high ambient temperatures or infrared drying systems.

		<b>3:1:1</b>			
	<b>Mixing Ratio</b>	100 % by volume	923-610		
	<b>Hardener</b>	33 % by volume	929-61, -62, -63, -64		
	<b>Reducer</b>	33 % by volume	352-10, -30, -40, -70		
	<b>Spray viscosity at 20°C</b>	DIN 4:	18-21 s	<b>Potlife at 20°C</b>	45 min

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

**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/IIB(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](http://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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	<b>Drying at 20°C</b>	2-3 h with 523-65 Glasurit Air-Drying Additive
	<b>Drying at 40°C</b>	30-45 min at panel temperature ** Drying times can be influenced by the selection of hardener, reducer and application. 523-15 Glasurit Racing Additive can reduce drying times.
	<b>Drying at 60°C</b>	10-15 min at panel temperature ** Drying times can be influenced by the selection of hardener, reducer and application. 523-15 Glasurit Racing Additive can reduce drying times.
	<b>Infrared (short wave)</b>	10 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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