

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

Properties: 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
	Hardener	50% by vol.	929-31, -33
	Reducer	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 Film thickness:	40 - 60 µm
	Drying at 20 °C	923-135 923-35, -115, -335	1 h 4 h
	Drying at 60 °C	923-135 923-35, -115, -335	15 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.

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® Racing Additive

G / Z

		Clear coat		
	Mixing ratio	3 : 1 : 1 100% by vol.	VOC-compliant clear 923-610 923-625 923-630	
	Hardener	33% by vol.	929-61, -63	
	Reducer	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: 1.3mm 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. 2 min between spray coats		
	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

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® Racing Additive

G / Z

	Paint system	22 Line VOC	
	Mixing ratio	2 : 1 + 10 %	100% by vol. 22 Line VOC
	Hardener	50% by vol.	929-31, -33
	Reducer	10% by vol.	523-15
	Spray viscosity DIN 4 at 20°C	app. 20 - 24 s	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
		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	
	Drying at 60 °C	20 min.	
	Infrared (short wave)	6 min.	
	Infrared (medium wave)	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.

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® Racing Additive

G / Z

	Paint system	22 VOC MC600	
	Mixing ratio	3 : 1 : 1	
	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	app. 20 - 24 s	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
		2 intermediate flash off app. 5 min.	Film thickness: 50 - 70 µm
	Drying at 20 °C	½ + 1 can be applied to vertical surfaces (no flash-off between coats required)	
	Drying at 60 °C	Film thickness: app. 50 µm	
	Infrared (short wave) Infrared (medium wave)	4 h	
		20 min.	
		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.

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® Racing Additive

G / Z

	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	HVLG 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		HVLG 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		-	

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® Racing Additive

G / Z

	Paint system	Primerfiller	
	Mixing ratio	4 : 1 : 1	
	Hardener	100% by vol.	285-700 285-730 285-790
	Reducer	25% by vol.	929-55, -56
	Spray viscosity DIN 4 at 20°C	20 – 24 s, depending on product used	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	
	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	

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.

