











Glasurit® Racing Additive



- Application:** Drying accelerator for Glasurit standard clears (VOC-compliant and non-VOC-compliant), 22 Line, 22 Line VOC, 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.

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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

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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.	

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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		-	

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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	

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