

# 923-255

923-255 Variant 522-345



A brand of BASF –  
We create chemistry

**Application:** 522-345 should be mixed as per published formula or can be added manually to 923-255, up to a maximum of 50% by volume concentration, to achieve the desired finish. Do not strain after mixing.



**Mixing Ratio PreMix**

50 % by volume 522-345  
100 % by volume 923-255  
Or as per published formula.



**Mixing Ratio**

**2:1+10 %**  
100 % by volume PreMix



**Hardener**

50 % by volume 929-91, -93



**Reducer**

10 % by volume 352-50, -91



**Spray viscosity at 20°C**

DIN 4: 16-18 s **Potlife at 20°C** 4 h

Application:	Compliant gravity-feed spray gun	HVLP spray gun
Application pressure	bar 2	
Nozzle pressure	bar	0.7
Nozzle size	1.3-1.4	1.3
Number of spray coats		2
Film thickness	µm 50-70	

**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 [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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**Drying at 20°C**      6 h (929-91)  
10 h (929-93)



**Drying at 60°C**      20 min. (929-91)  
30 min. (929-93)

**Infrared (short wave)**      8 min

**Infrared (medium wave)**      10-15 min

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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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