

# 923-631

Variant 522-345



A brand of BASF –  
We create chemistry



### Mixing Ratio PreMix

100 % by volume 923-631  
50 % by volume 522-345

#### Example mix:

522-345 should be mixed as per published formula or can be added manually to 923-631, up to a maximum of 50% by volume concentration, to achieve the desired finish. Do not strain after mixing.



### Mixing Ratio

**3:1:1**  
100 % by volume PreMix



### Hardener

33 % by volume 929-68, -61, -63, -64



### Reducer

33 % by volume 352-30



### Spray viscosity at 20°C

DIN 4: 16-18 s **Potlife at 20°C** 6 h

### Application:



**Application pressure** bar

2

**Nozzle pressure** bar

0.7

**Nozzle size**

1.3-1.4

1.3

**Number of spray coats**

2

**Flash off at 20°C** min

Flash off until mat after each spraycoat and before baking.

**Film thickness** µm

approx. 50 µm

### 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/IIIB(e)(840)839:** The EU limit value for this product ( product category: IIB.d ) in ready to use form is max 840 g/litre of VOC. The VOC content of this product is 839 g/litres.

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Variant 522-345



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**Drying at 20°C** 10 h

**Drying at 60°C** 30 min



**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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