

923-645

Variant 522-345



A brand of BASF –
We create chemistry

Key Features:



Mixing Ratio PreMix

100 % by volume 923-645
50 % by volume 522-345

Example mix:

522-345 should be mixed as per published formula or can be added manually to 923-645, 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 929-63



Reducer

33 % by volume 352-30



Spray viscosity at 20°C

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

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.



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 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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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Application pressure	bar	2
Nozzle pressure	bar	0.7
Nozzle size		1.3-1.4
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



Drying at 20°C 10 h

Drying at 60°C 30 min



Infrared (short wave) 8 min

Infrared (medium wave) 10-15 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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