

# 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.



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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
<b>Application pressure</b>	<b>bar</b>	2
<b>Nozzle pressure</b>	<b>bar</b>	0.7
<b>Nozzle size</b>		1.3-1.4
<b>Number of spray coats</b>		2
<b>Flash off at 20°C</b>	<b>min</b>	Flash off until mat after each spraycoat and before baking.
<b>Film thickness</b>	<b>µm</b>	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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