

# Technical Information

## 45-W00







45-W00 variant 50-45

Activator for waterborne basecoats

- For special applications recommended by car manufactures, the usage of 2K Activator could be necessary in Line 45- basecoats
- Additive for solid-color Line 45- and for use in solid-color basecoats applied as a ground coat in Line 45- 3-layer systems to improve tape resistance and hardness.
- Mixing formulas that contain 45-W1012 cannot be used with 50-45.

The drying time depends on climatic conditions and equipment used.

## Application

	<b>Mixing Ratio</b>	100 % by volume 5 % by volume 70 % by volume	50-45 45-R45
		<ol style="list-style-type: none"> <li>1. Mix the Line 45- basecoat formula and stir carefully.</li> <li>2. Add 2K Activator and thoroughly stir</li> <li>3. Add 45-R45 and thoroughly stir again</li> <li>4. Strain before application.</li> </ol> 50-45 cannot be added in formulas which contains already 45-R45.	
	<b>Spray viscosity at 20°C</b>	DIN 4: 18-25 s	
	<b>Potlife at 20°C</b>	2 h	
	<b>HVLP spray gun</b>		
	Nozzle size	1.4 mm	
	Application pressure	2 bar	
	Nozzle pressure	0.7 bar	
	<b>Number of spray coats</b>	2 -3	
	<b>Film thickness</b>	20-25 µm	
	<b>Application Remark</b>	Solid color or ground coat	

### Safety advice:

#### Safety instructions:

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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### Drying

	<b>Drying at 20°C</b>	15 min
	<b>Drying at 60°C</b>	10 min + cooling
	<b>Infrared (medium wave)</b>	10-15 min (1st spraycoat: Flash off until mat 10 – 15 min.; 2nd spraycoat: 40 – 50°C (max 70°C) surface temperature to mat surface + cooling )

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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