

DX48

2K HS APPEARANCE CLEAR

Description

2-component, universal high solids clear.

Suitable in various application conditions because of the wide range of activators, from extra fast to slow.

Composition based on a special acrylic polyurethane copolymer.

Products

DX48	2K HS Appearance Clear
DX18	Activator Slow
DX20	Activator Standard
DX24	Activator Extra Fast
DX32	Thinner Fast
DX34	Thinner Standard
DX36	Thinner Slow

Properties

- Has excellent mar, chemical and weather resistance and gives a long lasting high gloss finish.
- Has excellent polishability.
- Gives very fast air drying and allows short flash times between coats and bake depending on the selected activator.
- The wide choice of activators and thinners, allows to adjust this clear to different application conditions, from low/normal temperatures to very high temperatures.
- Can be used for spot, panel and overall repair.

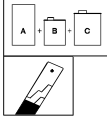
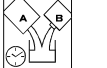
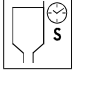


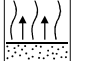
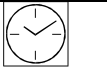

Substrates

- DUXONE® Basecoat.
- All cleaned and sanded OEM finishes (not recommended on thermoplastic acrylic finishes).

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PRODUCT PREPARATION

	Mixing ratio	Fast		Standard		High temperature/ Large surface		
		Volume	Weight	Volume	Weight	Volume	Weight	
	DX48	2	100	2	100	2	100	
	DX18	-	-	-	-	1	50	
	DX20	-	-	1	50	-	-	
	DX24	1	50	-	-	-	-	
	DX32/DX34/ DX36	10 %	15	10 %	15	10 %	15	
	VOC	519 g/l						
	Pot life at 20°C	6-8 hr						
	Spray viscosity at 20°C	DIN 4	17-19 s					
	Spray equipment	Fluid tip (mm)	Distance (cm)		Pressure (bar)			
		Compliant guns						
		Gravity feed	1.2-1.4	10-15		According to supplier's specifications		
		Suction feed	1.5-1.6	10-15				
		Pressure feed	1.0-1.2	10-15				
		Conventional guns						
Gravity feed	1.4-1.6	15-20		3-4				
Suction feed	1.6-1.8	15-20		3-4				
Pressure feed	1.0-1.2	15-20		3-4				
	Number of coats	2						
	Flash time	5 min between coats. 5-10 min before bake.						
	DFT	55-65 µ						
	Drying		DX18		DX20		DX24	
			20°C	40 min x 60°C	20°C	30min x 60°C	20°C	20 min x 60°C
		Dust-free	n.a.	imm.	40 min	imm.	30 min	imm.
		Dry to handle	n.a.	30 min	6 hr	30 min	4 hr	30 min
Tape-free	n.a.	1 hr 30 min	O.N.	1 hr 30 min	5 hr	1 hr 30 min		
	IR drying*	Flash time	5 min		* Guideline for short/medium wave IR equipment.			
	Distance	80 cm						
	Half power	5 min						
	Full power	15-20 min						

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RECOMMENDED USE

Clearcoat application

When the DUXONE® Basecoat is completely flat, apply DX48 in 2 coats with 5 min flash between coats.

Chemical resistance

When fully cured, DX48 is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20 %	battery acid
sulphuric acid	25 %	toluene
hydrochloric acid	20 %	xylene
phosphoric acid	20 %	glycol
ammonia	10 %	brake fluid, petrol

Equipment cleaning

Use a correct solventborne gunwash.

Recoatibility

At any time after tape-free time. After 24 hr, scuff sanding is required.

Remarks

- DX24 is recommended for spot/panel repair only.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Activated material should not be returned to original can of non-activated material.
- Material has to be at room temperature (18-25°C) before use.

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Product data

Package viscosity: 50-60 cp
Theoretical coverage: 6.6-7.1 m²/l at recommended DFT - ready-to-spray

Safety

Consult the Safety Data Sheet prior to use.
Observe the precautionary notices displayed on the container.

All other products referred to in the paint system build-up are from Duxone®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Duxone®, unless explicitly indicated otherwise.

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This Technical Data Sheet supersedes all previous issues.