

DUXONE® BASECOAT

ACRYLIC BASECOAT

Description

A basecoat system for solid, metallic and pearl colours. Suitable for use on cars, trucks and buses.

Composition based on acrylic copolymer.

Products

DX5...	DUXONE® Basecoat Tints
DX0...	DUXONE® Tints
DX11	DUXONE® Pearl Additive
DX32	Thinner Fast
DX34	Standard Thinner

Properties

- DUXONE® Basecoat combines ease of application, fast drying and accurate colour matching.
- Can be used for spot, panel and overall repair.


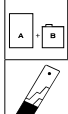





Substrates

- All cleaned and sanded sound old finishes.
- All OEM finishes, DUXONE® primers and DUXONE® fillers.

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PRODUCT PREPARATION

	DUXONE® colour tools	See colour formula on DUXONE® colour CD.			
	Mixing ratio	DUXONE® Basecoat DX32/DX34	1 0.5-0.8		
	VOC	720-750 g/l			
	Pot life at 20°C	Not applicable.			
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	1:0.5	1:0.8	
			21-23 s	15-17 s	
			21-23 s	15-17 s	
			22-24 s	16-19 s	
	Spray equipment	Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip	Distance	Pressure
			1.2-1.4 mm	15-20 cm	3-4 bar
			1.4-1.6 mm	15-20 cm	3-4 bar
		1.0-1.2 mm	15-20 cm	3-4 bar	
		Compliant guns (HVLPHTE) Gravity feed Suction feed Pressure feed	1.2-1.4 mm	10-15 cm	According to supplier's specifications
			1.4-1.6 mm	10-15 cm	
0.8-1.1 mm	10-15 cm				
	Number of coats	2-3			
	Flash time	Till flat between coats and before clearcoating. Tack rag-free after 20 min.			
	DFT	10-20 µ depending on colour.			
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.					

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RECOMMENDED USE

Surface preparation

1. Clean surface with water and soap. Rinse and dry.
2. Degrease. Wipe dry with a clean cloth.
3. Repair according to damage.
4. Sand surface:
 - a. mechanical P320 - P400 (finally with P500 will give best results);
 - b. wet P800 - P1000.
5. Remove all traces of sanding dust, blowing oil-free compressed air.
6. Degrease. Wipe dry with a clean cloth.
7. Tack rag.

Clearcoat application

DUXONE® clear must be applied when DUXONE® Basecoat is completely flat.
Maximum time before clearcoating is 24 hours.

Equipment cleaning

Use a correct solventborne gunwash.

Remarks

- Excessive coats of colour will slow up drying, avoid heavy coats.
- Material has to be at room temperature (18-25°C) before use.

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RECOMMENDED USE (con'd)

Product data

Theoretical coverage: 5-7 m²/l at recommended DFT - ready-to-spray

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
DX5111	3.5	2	-
DX5136	3.5	2	-
DX5213	3.5	2	-
DX5223	3.5	2	-
DX5...	1	2	-
DX0...	1	2	-
DX11	1	2	0.920
DX32	1 - 5	2	0.874
DX34	1 - 5	2	0.903

Safety

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

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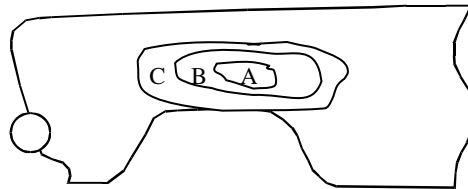
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REPAIR SYSTEMS

Spot and panel repair - surface preparation

1. Repair with recommended undercoats according to damage.
2. Sand treated spots as recommended.
3. Prepare complete fade-out area with fine rubbing compound.
4. Clean carefully afterwards.

Spot and panel repair - system



- Apply 1 coat DUXONE® Basecoat over the treated spot (A). Flash 5-10 min. Wipe off spray dust with tack rag in zone B-C (if needed).
- Apply 2 to 3 coats. Extend each coat slightly beyond the previous one and allow each coat to flash (5-10 min) before applying the next coat. If needed, tack wipe after each coat to eliminate spray dust around the colour coat.