

DUXONE® 2K TOPCOAT

2K ACRYLIC TOPCOAT

Description

2-component topcoat system for solid colours for use on cars, buses and trucks.
Composition based on acrylic copolymer.

Products

DX9...	DUXONE® 2K Topcoat Tints
DX0...	DUXONE® Tints
DX18	Activator Slow
DX20	Standard Activator
DX22	HS Activator Fast
DX24	Activator Extra Fast
DX25	Activator
DX32	Thinner Fast
DX34	Standard Thinner

Properties

- DUXONE® 2K Topcoat is a very fast drying 2K acrylic topcoat with superior polishability, perfect gloss retention, high weather and chemical resistance.
- Gives excellent appearance, very good hiding and low consumption.
- Can be used for spot, panel and overall repair.










Substrates

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

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PRODUCT PREPARATION

	DUXONE® colour tools	See colour formula on DUXONE® colour CD.					
	Mixing ratio		Slow	Standard (DX25)	Standard (DX20)	Fast	Very fast
	DUXONE® 2K Topcoat		2	2	2	4	2
	DX18		1	-	-	-	-
	DX25		-	1	-	-	-
	DX20		-	-	1	-	-
	DX22		-	-	-	1	-
	DX24		-	-	-	-	1
	DX32		-	-	0.3	1	0.3
	DX34		0.3	-	-	-	-
	VOC	DX18	556-576 g/l	-	-	-	-
		DX25	-	567-590 g/l	-	-	-
		DX20	-	-	549-562 g/l	-	-
		DX22	-	-	-	545-567 g/l	-
		DX24	-	-	-	-	544-562 g/l
	Pot life at 20°C	DX18	5-6 hr				
		DX25	4 hr				
		DX20	5 hr				
		DX22	2 hr				
		DX24	30 min				
	Spray viscosity at 20°C	DIN 4	17-19 s				
		FORD 4	17-19 s				
		AFNOR 4	19-21 s				
	Spray equipment	Conventional guns	Fluid tip	Distance	Pressure		
		Gravity feed	1.4-1.6 mm	15-20 cm	3-4 bar		
		Suction feed	1.6-1.8 mm	15-20 cm	3-4 bar		
		Pressure feed	1.0-1.2 mm	15-20 cm	3-4 bar		
		Compliant guns (HVLP/HTE)					
		Gravity feed	1.3-1.5 mm	10-15 cm	According to supplier's specifications		
		Suction feed	1.5-1.8 mm	10-15 cm			
		Pressure feed	1.0-1.2 mm	10-15 cm			
	Number of coats	2					
	Flash time	5-15 min between coats or wet-in-wet. 10 min before bake.					
	DFT	40-50 µ					
	Drying		15°C	20°C	30°C	30 min x 60°C	
	Dust-free		18 min	15 min	12 min	imm.	
	Dry to handle		5 hr	4 hr	2 hr 30 min	imm.	
	Tape-free		10 hr	8 hr	6 hr	imm.	
	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					
<p>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.</p>							

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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.

Topcoat application

On well prepared surface, apply 2 full coats wet-in-wet or with 5-15 min flash between coats.

Chemical resistance

When fully cured, DUXONE[®] 2K Topcoat is resistant to short exposures of the chemicals as listed:

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

Equipment cleaning

Use a correct solventborne gunwash.

Recoatability

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

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RECOMMENDED USE (con'd)

Remarks

- DUXONE® 2K Topcoat tints have to be thoroughly mixed before use.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

Product data

Theoretical coverage: 6-8 m²/l at recommended DFT - ready-to-spray

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
DX9111	3.5	2	-
DX9131	3.5	2	-
DX9...	1	2	-
DX0...	1	2	-
DX18	0.5 - 1	2	0.972
DX20	0.25 - 0.5 - 1	2	0.959
DX22	0.25 - 0.5 - 1	2	0.986
DX24	0.5 - 1	2	0.962
DX25	0.5	2	0.949
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.