

# TECHNICAL DATA SHEET

## DX1044

### 2K PRODUCTIVE VOC CLEAR

**DUXONE**<sup>®</sup>  
AUTOMOTIVE PAINT SYSTEMS



#### DESCRIPTION

DX1044 2K Productive VOC Clear is part of the Duxone repair system and is suitable for use in a clear-over-base system. This VOC compliant, fast-drying clear delivers consistent, durable high-build finishes and offers short flash-off times between coats and bake cycles. It also has fast dust-free times, which helps to prevent defects caused by air contamination.

#### FEATURES

- Fast drying.
- Excellent polishability.
- Suitable for spot, panel and overall repairs.
- VOC compliant.

#### PRODUCT LIST

- DX1044 2K Productive VOC Clear
- DX1020 HS Activator Standard
- DX1024 HS Activator Fast

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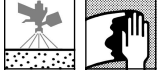
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#### Product preparation - application STANDARD



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Duxone Basecoat: Surfaces must be dried / flashed-off in accordance with TDS before application  
Duxone Waterborne Basecoat: Surfaces must be dried / flashed-off in accordance with TDS before application  
Existing finishes: Surfaces must be sanded and degreased before application



	Spot & panel repair		Standard	
	Volume	Weight	Volume	Weight
<b>DX1044</b>	2	100	2	100
<b>DX1020</b>	-	-	1	51
<b>DX1024</b>	1	51	-	-



Pot life at 20°C: 1 hr 15 min



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.3 - 1.5	1.8 - 2.2 bar	inlet pressure
<b>HVLP</b>	1.3 - 1.5	0.7 bar	atomisation pressure

see manufacturer's instructions



2 coats

intermediate and final flash-off: 5 min



	DX1024	DX1020
<b>20 °C</b>	3 hr	5 hr 30 min
<b>60 - 65 °C</b>	20 min	25 min



Guideline for short wave IR equipment  
Half power: 5 min  
Full power: 15 - 20 min

VOC compliant

2004/42/IB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

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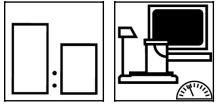
## Products

DX1044 2K Productive VOC Clear

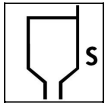
DX1020 HS Activator Standard

DX1024 HS Activator Fast

## Product mix



Mixing ratios with special agents are available in the productmix table on Colour Room and in the specific TDS.



DIN 4: 20 - 22 s at 20°C



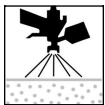
60 - 70 µm (2 coats)

### Theoretical coverage

475 - 480 m<sup>2</sup>/l at 1 micron dry film thickness

Due to different activator characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.

Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



DX1044 2K Productive VOC Clear can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

## Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Close can of clear and activator tightly immediately after use, as both products will react with humid air and water and lose their hardening effect.

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

All other products referred to in the refinish build up are from our Duxone product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Duxone product range, unless explicitly indicated otherwise.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.