

TECHNICAL DATA SHEET

DX1064

2K VOC SURFACER

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS



DESCRIPTION

DX1064 2K VOC Surfacers is part of the Duxone repair system. This robust VOC compliant, high solids universal surfacer in grey has a wide application window and delivers excellent vertical stability as well as outstanding filling power and adhesion. It provides great topcoat holdout of Duxone topcoats.

FEATURES

- Simple to apply
- Excellent vertical stability
- Easy to sand
- Very good adhesion
- VOC compliant

PRODUCT LIST

- DX1064 2K VOC Surfacers
- DX1020 HS Activator Standard
- DX1024 HS Activator Fast
- DX32 Thinner Fast
- DX34 Thinner Standard

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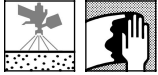
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Product preparation - application STANDARD



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



Wash Primer or epoxy primer
Old or original paintwork well sanded and cleaned
OEM Primer (e-coat), sanded and cleaned
Surfaces pretreated with 2K polyester products and then finely sanded
Glass fibre reinforced polyester substrates, free of release agents sanded.



	Spot & panel repair		Standard	
	Volume	Weight	Volume	Weight
DX1064	4	100	4	100
DX1020	-	-	1	16
DX1024	1	16	-	-
DX32 / DX34	0 - 5 %	0 - 4	0 - 5 %	0 - 4



Pot life at 20°C: 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.7 mm	1.8 - 2.2 bar	inlet pressure
HVLP	1.4 - 1.7 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 3 coats

with intermediate and final flash-off until flat



	DX1024	DX1020
20 °C	3 hr	3 hr - 4 hr
60 - 65 °C	25 min	25 min - 30 min



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



P360 - P500
P800 - P1000



Duxone 2K Topcoat
Basecoat + Clearcoat

VOC compliant

2004/42/IIIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

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Products

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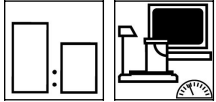
DX1020 HS Activator Standard

DX1024 HS Activator Fast

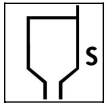
DX32 Thinner Fast

DX34 Thinner Standard

Product mix



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



DIN 4: 20 - 25 s at 20°C



80 - 100 µm per coat



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Mix thoroughly and put can on mixing machine.
- Allow additional time for preheating up to panel temperature.
- When isolating certain spots - even on problem substrates - the best results are achieved with a medium film thickness of 80-120µm in 2 coats, after either air drying overnight or force drying/IR drying. With problem substrates, careful pretreatment is necessary and the Surfacers must be applied to the entire area.
- For dry film thicknesses of more than 150 micron air dry overnight at 20°C or 40 minutes at 60-65°C.
- Surplus ready for use material should not be returned to original can.
- If applied over thermoplastic acrylic finishes, complete panel or overall car has to be treated. Spot repairing or sand throughs of the primer can result in spot marking or lifting when applying basecoat.

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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.