

TECHNICAL DATA SHEET

DX1068

2K HS PERFORMANCE SURFACER

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS



DESCRIPTION

DX1068 2K HS Performance Surfer is part of the Duxone repair system. It is a VOC compliant high solids, fast-drying, medium grey surfer. It's a robust surfer with exceptional filling power. It offers users versatility and short process times, and is well-suited to spot repairs, thanks to no edge mapping. It should be used with its dedicated activator, DX28, and can be overcoated with Duxone topcoats.

FEATURES

- Simple to apply.
- 2:1 ratio and no thinner required.
- Easy to sand.
- Very good filling properties.
- VOC compliant.

PRODUCT LIST

- DX1068 2K HS Performance Surfer
- DX1020 HS Activator Standard
- DX1024 HS Activator Fast
- DX20 Activator Standard
- DX24 Activator Extra Fast
- DX28 HS Performance Activator
- DX32 Thinner Fast
- DX34 Thinner Standard

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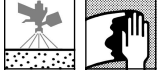
2K HS PERFORMANCE SURFACER

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Product preparation - application STANDARD VOC



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



Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with 1K 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 and cleaned.
Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	Spot & panel repair		Standard		Standard.	
	Volume	Weight	Volume	Weight	Volume	Weight
DX1068	5	100	5	100	2	100
DX1020	-	-	1	14	-	-
DX1024	1	14	-	-	-	-
DX28	-	-	-	-	1	33
DX32 / DX34	20 %	15	20 %	15	-	-



Pot life at 20°C: 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.9	1.6 - 2 bar	inlet pressure
HVLP	1.6 - 1.9	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

with intermediate and final flash-off until flat



	DX28	DX1024	DX1020
20 °C	1 hr 30 min	1 hr	1 hr 30 min - 2 hr
60 - 65 °C	20 min	20 min	30 min



Guideline for short wave IR equipment
Half power: 10 min



P400 - P500



Duxone 2K Topcoat
Duxone Basecoat + Duxone Clearcoat
Duxone Waterborne Basecoat + suitable Duxone VOC Clearcoat

VOC compliant

2004/42/IIB(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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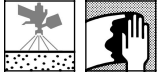
2K HS PERFORMANCE SURFACER

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Product preparation - application STANDARD NON-VOC



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



Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with 1K 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 and cleaned.
Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	Spot & panel repair		Standard	
	Volume	Weight	Volume	Weight
DX1068	4	100	4	100
DX20	-	-	1	17
DX24	1	17	-	-
DX32	-	-	10 %	8
DX32 / DX34	10 %	8	-	-



Pot life at 20°C: 30 min - 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.9	1.6 - 2 bar	inlet pressure
HVLP	1.6 - 1.9	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

with intermediate and final flash-off until flat



	DX24	DX20
20 °C	1 hr	1 hr 30 min - 2 hr
60 - 65 °C	20 min	30 min



Guideline for short wave IR equipment
Half power: 10 min



P400 - P500



Duxone 2K Topcoat
Duxone Basecoat + Duxone Clearcoat
Duxone Waterborne Basecoat + suitable Duxone VOC Clearcoat

VOC compliant

This product mix is not VOC compliant.

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Products

DX1068 2K HS Performance Surfacers

DX1020 HS Activator Standard

DX1024 HS Activator Fast

DX20 Activator Standard

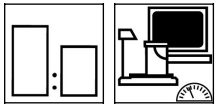
DX24 Activator Extra Fast

DX28 HS Performance Activator

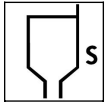
DX32 Thinner Fast

DX34 Thinner Standard

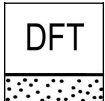
Product mix



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



DIN 4: 28 - 32 s at 20°C



50 - 70 µm per coat

Theoretical coverage

380 - 400 m²/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.



Clean after use with a suitable solventbased guncleaner.

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Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- 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.
- Allow additional time for preheating up to panel temperature.
- 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.
- Surfacers has to be applied over the complete panel or overall car if the OEM paintwork is not well cured. Spot repairing or sand throughs of the surfacer can result in spot marking or lifting when applying a basecoat.

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.