

TECHNICAL DATA SHEET

DX40

2K CLEAR

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS



DESCRIPTION

DX40 2K Clear is part of the Duxone repair system and is suitable for use in a clear-over-base system. It only requires short flash-off times during application and is very fast when air dried. It also has fast dust-free times, which helps to prevent defects caused by air contamination. Formulated for use with its dedicated activator, DX25.

FEATURES

- Easy mixing ratio 2:1 with DX25, dedicated activator.
- No thinner required.
- Simple to apply.
- Can be air dried, low baked or dried using IR.
- Suitable for spot, panel and overall repairs.

PRODUCT LIST

- DX40 2K Clear
- DX25 Activator

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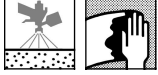
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Product preparation - application STANDARD



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
Existing finishes: Surfaces must be sanded and degreased before application



	Standard	
	Volume	Weight
DX40	2	100
DX25	1	49



Pot life at 20°C: 4 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.8 - 2.2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure

see manufacturer's instructions



2 coats

intermediate and final flash-off: 5 min



	DX25
20 °C	5 hr
60 - 65 °C	20 min



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

VOC compliant

This product mix is not VOC compliant.

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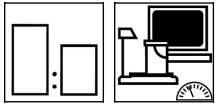
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Products

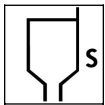
DX40 2K Clear

DX25 Activator

Product mix



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



DIN 4: 14 - 16 s at 20°C



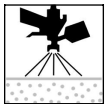
55 - 65 µm (2 coats)

Theoretical coverage

295 - 300 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.



DX40 2K 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.
- If necessary for minor viscosity adjustments, use Duxone basecoat Thinner (maximum 5%).
- 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.
- Not to be used with Duxone Waterborne 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.

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