

# TECHNICAL DATA SHEET

## DX46

### 2K HS STANDARD CLEAR

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



#### DESCRIPTION

DX46 2K HS Standard Clear is part of the Duxone repair system and is suitable for use in a clear-over-base system. This high solids universal clear has very good flow in application and delivers a good, long-lasting high-gloss finish. It can be air dried, dried on low bake or using IR, which can help improve a bodyshop's efficiency.

#### FEATURES

- Very good flow.
- Superb polishability.
- Excellent mar, chemical and weather resistance.
- Suitable for spot, panel and overall repairs.

#### PRODUCT LIST

- DX46 2K HS Standard Clear
- DX18 Activator Slow
- DX20 Activator Standard
- DX24 Activator Extra Fast

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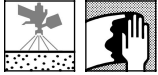
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### Product preparation - application STANDARD



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  
Existing finishes: Surfaces must be sanded and degreased before application



	Large surface		Spot & panel repair		Standard	
	Volume	Weight	Volume	Weight	Volume	Weight
<b>DX46</b>	2	100	2	100	2	100
<b>DX18</b>	1	50	-	-	-	-
<b>DX20</b>	-	-	-	-	1	49
<b>DX24</b>	-	-	1	50	-	-



Pot life at 20°C: 3 hr 30 min



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.3 - 1.4	1.8 - 2.2 bar	inlet pressure
<b>HVLP</b>	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



2 coats

intermediate and final flash-off: 5 min - 10 min



	DX24	DX20	DX18
<b>20 °C</b>	4 hr	5 hr	6 hr
<b>60 - 65 °C</b>	20 min	30 min	40 min



Guideline for short wave IR equipment  
Half power: 5 min  
Full power: 8 - 12 min

VOC compliant

This product mix is not VOC compliant.

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### Products

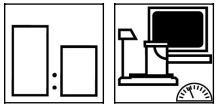
DX46 2K HS Standard Clear

DX18 Activator Slow

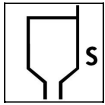
DX20 Activator Standard

DX24 Activator Extra Fast

### Product mix



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



ISO 4: 28 - 37 s at 20°C  
DIN 4: 14 - 16 s at 20°C



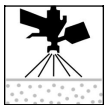
50 - 60 µm

#### Theoretical coverage

360 - 370 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.



DX46 2K HS Standard 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 Activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- If necessary for minor viscosity adjustments, use Duxone basecoat Thinner (maximum 5%).
- 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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