

# TECHNICAL DATA SHEET

## DX48

### 2K HS APPEARANCE CLEAR

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



#### DESCRIPTION

DX48 2K HS Appearance Clear is part of the Duxone repair system. This high solids universal clear delivers an outstanding, long-lasting, high gloss, final appearance. Thanks to a range of activators – from extra slow to fast – it is suitable for a wide variety of application conditions.

#### FEATURES

- Easy to apply.
- Extremely versatile thanks to a range of activators.
- Very fast air drying.
- Excellent polishability.
- Excellent mar, chemical and weather resistance.
- Suitable for spot, panel and overall repairs.

#### PRODUCT LIST

- DX48 2K HS Appearance Clear
- DX18 Activator Slow
- DX20 Activator Standard
- DX24 Activator Extra Fast
- DX32 Thinner Fast
- DX34 Thinner Standard
- DX36 Thinner Slow

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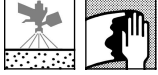
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### Product preparation - application STANDARD



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



	Spot & panel repair		Standard		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight
<b>DX48</b>	2	100	2	100	2	100
<b>DX18</b>	-	-	-	-	1	49
<b>DX20</b>	-	-	1	48	-	-
<b>DX24</b>	1	49	-	-	-	-
<b>DX32 / DX34</b>	10 %	13	-	-	-	-
<b>DX32 / DX34 / DX36</b>	-	-	10 %	14	-	-
<b>DX34 / DX36</b>	-	-	-	-	10 %	14



Pot life at 20°C: 6 hr - 8 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.2 - 1.4	1.8 - 2.2 bar	inlet pressure
<b>HVLP</b>	1.2 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



2 coats

intermediate and final flash-off: 5 min



	DX24	DX20	DX18
<b>20 °C</b>	4 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: 15 - 20 min

VOC compliant

This product mix is not VOC compliant.

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### Products

DX48 2K HS Appearance Clear

DX18 Activator Slow

DX20 Activator Standard

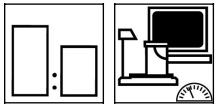
DX24 Activator Extra Fast

DX32 Thinner Fast

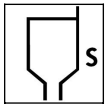
DX34 Thinner Standard

DX36 Thinner Slow

### Product mix



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



DIN 4: 17 - 19 s at 20°C



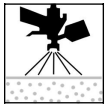
55 - 65 µm (2 coats)

#### Theoretical coverage

330 - 335 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.



DX48 2K HS Appearance 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.
- 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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