

TECHNICAL DATA SHEET

DX61

1K PRIMER-SURFACER

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS



DESCRIPTION

DX61 1K Primer-Surfacer is part of the Duxone repair system. It is a grey, chromate-free acid wash primer-surfacer that is formulated for use directly on steel, galvanised steel and aluminium. Its good flow delivers smooth application, and it's applied wet-on-wet. It provides excellent corrosion protection.

FEATURES

- Simple to apply
- Dries quickly
- Suitable for dry sanding after 1 hour or 1.5 hours air drying
- Can be used as a primer, or as a primer-surfacer

PRODUCT LIST

- DX61 1K Primer-Surfacer
- DX32 Thinner Fast
- DX34 Thinner Standard
- DX36 Thinner Slow

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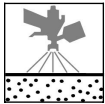
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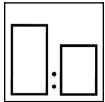
Product preparation - application STANDARD



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



Bare steel sanded and cleaned
Galvanised steel or soft aluminium sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned
Old or original paintwork well sanded and cleaned
OEM Primer (e-coat), sanded and cleaned

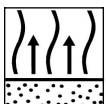
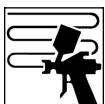


	Spot & panel repair		Standard		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight
DX61	2	100	2	100	2	100
DX32	1	40	-	-	-	-
DX34	-	-	1	41	-	-
DX36	-	-	-	-	1	41

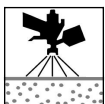


	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5 mm	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.5 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



Primer		Primer-surfacer	
1 coat	final flash-off: 10 min - 15 min	1 - 2 coats	with intermediate flash-off: 5 min final flash-off: 15 min - 8 hr



Primer	Primer-surfacer
2K Surfacer	Duxone 2K Topcoat Duxone Basecoat + Clearcoat

VOC compliant

This product mix is not VOC compliant.

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Products

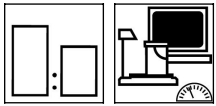
DX61 1K Primer-Surfacer

DX32 Thinner Fast

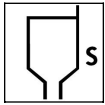
DX34 Thinner Standard

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: 18 - 20 s at 20°C



15 µm per coat



Clean after use with a suitable solventbased guncleaner.

Remarks

- Only use plastic or inner coated metal cans.
- Dry sanding only allowed for lightly denibbing.
- Do not recoat with polyester-, epoxy- or waterborne products.
- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Not suitable for application on thermoplastic paintwork.
- Maximum time before overcoating is 8 hours.
- Can be used as Primer-Surfacer for small sand throughs and immediately topcoated with Duxone Basecoat + Clearcoat and 2K Topcoat.

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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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