

TECHNICAL DATA SHEET

DX64W / DX64G / DX64B

2K SURFACER

WHITE / GREY / BLACK

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS



DESCRIPTION

DX64G (grey) / DX64W (white) / DX64B (black) are part of the Duxone repair system. These robust, high solids universal surfacers can be used for both sanding and non-sanding applications. They have very wide application windows and deliver excellent vertical stability as well as outstanding filling power and adhesion. The colours can be used on their own or can be mixed together to deliver the optimal undercoat colour for the subsequent topcoat colour. They provide great topcoat holdout of Duxone topcoats.

FEATURES

- Simple to apply.
- Excellent vertical stability.
- Easy to sand.
- Very good adhesion.
- Can be converted to non-sanding versions.

PRODUCT LIST

- DX64B 2K Surfacers - Black
- DX64G 2K Surfacers - Grey
- DX64W 2K Surfacers - White
- DX18 Activator Slow
- DX20 Activator Standard
- DX24 Activator Extra Fast
- DX1020 HS Activator Standard
- DX1024 HS Activator Fast
- DX32 Thinner Fast
- DX34 Thinner Standard
- DX36 Thinner Slow
- DX1014 Converting Additive WB
- DX14 Converting Additive

TECHNICAL DATA SHEET

DX64W / DX64G / DX64B

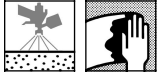
2K SURFACER WHITE / GREY / BLACK

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS

Product preparation - application STANDARD SANDING NON VOC



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



Wash Primer or epoxy primer
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



	Spot & Panel repair		Standard		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight
DX64W / DX64G / DX64B	4	100	4	100	4	100
DX18	-	-	-	-	1	16
DX20	-	-	1	16	-	-
DX24	1	16	-	-	-	-
DX32	0 - 10%	0 - 7	-	-	-	-
DX32 / DX34	-	-	0 - 10%	0 - 7	-	-
DX34 / DX36	-	-	-	-	0 - 10%	0 - 7

RFU viscosity DIN 4: 20 - 25s
For Coverage Booster mixing ratio, see mixing table in Remarks.



Pot life at 20°C: 1 hr - 1 hr 15 min



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.7	1.8 - 2.2 bar	inlet pressure
HVLP	1.4 - 1.7	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 3 coats

with intermediate and final flash-off until flat



	DX24	DX20	DX18
20 °C	3 hr	4 hr	6 hr
40 °C	30 min	40 min	1 hr
65 °C	20 min	30 min	40 min



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



P360 - P500
P800 - P1000



Duxone 2K Topcoat
Duxone Basecoat + Clearcoat

VOC compliant

This product mix is not VOC compliant.

TECHNICAL DATA SHEET

DX64W / DX64G / DX64B

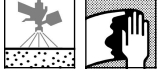
2K SURFACER WHITE / GREY / BLACK

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS

Product preparation - application STANDARD NON-SANDING NON VOC



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



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		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight
DX64W / DX64G / DX64B	2	100	2	100	2	100
DX18	-	-	-	-	1	32
DX20	-	-	1	32		
DX24	1	32	-	-		
DX14	1	30	1	30	1	30

RFU viscosity DIN 4: 14 - 16s
For Coverage Booster mixing ratio, see mixing table in Remarks.



Pot life at 20°C: 1 hr - 1 hr 30 min



	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



1 coat

final flash-off: 15 min - 8 hr with 2K Topcoat
final flash-off: 15 min - 45 min with Duxone Basecoat



Duxone 2K Topcoat
Duxone Basecoat + Clearcoat

VOC compliant

This product mix is not VOC compliant.

TECHNICAL DATA SHEET

DX64W / DX64G / DX64B

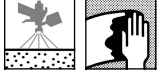
2K SURFACER WHITE / GREY / BLACK

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS

Product preparation - application STANDARD SANDING VOC



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



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 reinforced polyester substrates, free of release agents, sanded and cleaned.



	Spot & Panel repair		Standard	
	Weight	Volume	Weight	Volume
DX64W / DX64G / DX64B	4	100	4	100
DX1024	1	16.9	-	-
DX1020	-	-	1	16.9
DX32	10 - 15%	9 - 11	-	-
DX32 / DX34	-	-	10 - 15%	9 - 11

RFU viscosity DIN 4: 20 - 25s
For Coverage Booster mixing ratio, see mixing table in Remarks.



Pot life at 20°C: 1 hr - 1 hr 15 min



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.7	0.8 - 2.2 bar	inlet pressure
HVLP	1.4 - 1.7	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 3 coats

with intermediate and final flash-off until flat



	DX1024	DX1020
20 °C	3 hr	4 hr
40 °C	30 min	40 min
65 °C	20 min	30 min



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



P360 - P500
P800 - P1000



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.

TECHNICAL DATA SHEET

DX64W / DX64G / DX64B

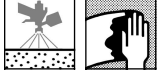
2K SURFACER WHITE / GREY / BLACK

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS

Product preparation - application STANDARD NON-SANDING VOC



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



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
DX64W / DX64G / DX64B	3	100	3	100
DX1020	-	-	1	22
DX1024	1	22	-	-
DX1014	1.5	30	1.5	30

RFU viscosity DIN 4: 14 - 16s
For Coverage Booster mixing ratio, see mixing table in Remarks.



Pot life at 20°C: 1 hr - 1 hr 30 min



	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



1 final flash-off: 30 min - 1 hr with Duxone Waterborne Basecoat



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.

TECHNICAL DATA SHEET

DX64W / DX64G / DX64B

2K SURFACER WHITE / GREY / BLACK

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS

Products

DX64B 2K Surfacers - Black
DX64G 2K Surfacers - Grey
DX64W 2K Surfacers - White

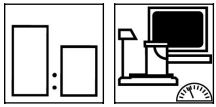
DX18 Activator Slow
DX20 Activator Standard
DX24 Activator Extra Fast

DX1020 HS Activator Standard
DX1024 HS Activator Fast

DX32 Thinner Fast
DX34 Thinner Standard
DX36 Thinner Slow

DX1014 Converting Additive WB
DX14 Converting Additive

Product mix



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



60 - 80 µm per coat

Theoretical coverage

380 - 460 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.

TECHNICAL DATA SHEET

DX64W / DX64G / DX64B

2K SURFACER WHITE / GREY / BLACK

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Mix thoroughly and put can on mixing machine.
- Allow additional time for preheating up to panel temperature.
- 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.
- For dry film thicknesses of more than 150 micron air dry overnight at 20°C or 40 minutes at 60-65°C.
- Surplus ready for use material should not be returned to original can.

	White	Light Grey	Grey	Dark Grey	Black
DX64W	100	72.5	-	-	-
DX64G	-	27.5	100	60	-
DX64B	-	-	-	40	100

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.