

TECHNICAL DATA SHEET

DX86

SPRAY PUTTY

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS



DESCRIPTION

DX86 Spray Putty is part of the Duxone repair system. It is a 2K VOC compliant finishing spray putty designed for use on glass fibre reinforced polyester and to rectify 2K putties' imperfections. It provides excellent sagging resistance and a high film build.

FEATURES

- Simple to apply.
- Easy to sand.
- Good homogenous structure.
- Delivers smooth, uniform surface.
- Suitable for IR drying.
- VOC compliant.

PRODUCT LIST

- DX86 Spray Putty
- AXT560 Hardener for 2K Spray Putty
- DX861 Spray Putty Activator

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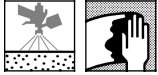
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Product preparation - application STANDARD



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



Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.
Old or original paintwork well sanded and cleaned.
Fully cured 2K Surfacer or 2K Epoxy Primer-surfacer sanded and cleaned
OEM Primer (e-coat), sanded and cleaned.
Steel, galvanised steel and light aluminium, sanded and cleaned, coated with primer and overcoated with 2K Surfacer



	Standard	
	Volume	Weight
DX86	100	100
AXT560 / DX861	5 %	4



Pot life at 20°C: 20 min



	Spray nozzle	Spray pressure	
Compliant	2 - 2.5	2 - 3 bar	inlet pressure

see manufacturer's instructions



1 - 5 coats

without intermediate flash-off
before bake: 5 min - 10 min



	DX861 / AXT560
20 °C	2 hr
60 - 65 °C	30 min - 35 min



Guideline for short wave IR equipment
Half power: 10 - 12 min



Coarse sand: P120 - P220
Final sand: P240 - P360



Primer
Primer-Surfacer
Surfacer

VOC compliant

2004/42/IIB(b)(250) 250: The EU limit value for this product (product category: IIB(b)) in ready to use form is maximum 250 g/l of VOC. The VOC content of this product in ready to use form is maximum 250 g/l.

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Products

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DFT



500 - 600 µm film thicknesses up to 1000µm are possible



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Do not apply over 1K primer, etch primer or thermoplastic acrylic finishes.
- Do not wet sand.
- Polyester materials have a limited shelf life. Store in a cool place, and use within 12 months for best results.

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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