

TECHNICAL DATA SHEET

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS

DUXONE[®] BASECOAT



DESCRIPTION

Duxone Basecoat is part of the Duxone repair system. The balanced tints of the Duxone Basecoat are easy to apply. They provide coverage at low film thickness and deliver very good colour performance and accurate colour matching. Available in solid, aluminium, pearl and xirallic tints, Duxone Basecoat is suitable for cars, trucks and buses. For superior film properties, the use of DX20 is recommended.

FEATURES

- Easy to apply.
- Accurate colour matching.
- Suitable for spot, panel and overall repairs.

PRODUCT LIST

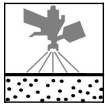
- Duxone Basecoat
- Duxone Low Strength Tints
- DX11 Pearl Additive
- DX20 Activator Standard
- DX32 Thinner Fast
- DX34 Thinner Standard
- DX36 Thinner Slow

DUXONE[®] BASECOAT

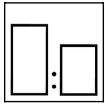
Product preparation - application STANDARD / 2-STAGE



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



Old or original paintwork well sanded and cleaned.
Primer-Surfacer or Surfacer, sanded and cleaned.
Primer-Surfacer or Surfacer, unsanded in a wet-on-wet process.
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



	Spot & panel repair	Standard	Large surface
DUXONE[®] BASECOAT	1	1	1
DX34	-	0.5 - 0.8	-
DX32	0.5 - 0.8	-	-
DX36	-	-	0.5 - 0.8

* 0.5 parts thinner for poor hidere.

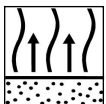


Not applicable



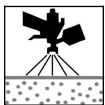
	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

with intermediate and final flash-off until flat



Clearcoat

VOC compliant

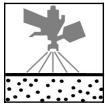
This product mix is not VOC compliant.

DUXONE[®] BASECOAT

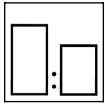
Product preparation - application STANDARD / 3-STAGE



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Old or original paintwork well sanded and cleaned.
Primer-Surfacer or Surfacer, sanded and cleaned.
Primer-Surfacer or Surfacer, unsanded in a wet-on-wet process.
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



	Standard
DUXONE[®] BASECOAT	0.9
DX20	0.1
DX32 / DX34 / DX36	0.5 - 0.8

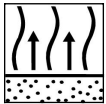


Pot life at 20°C: 8 hr



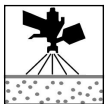
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see manufacturer's instructions



2 - 3 coats

with intermediate and final flash-off until flat



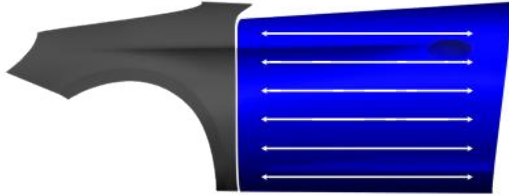
Clearcoat

VOC compliant

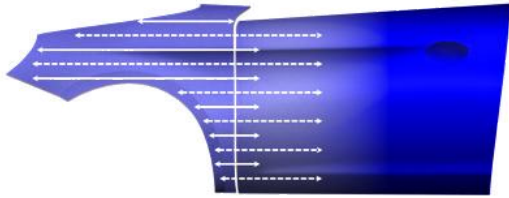
This product mix is not VOC compliant.

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Blend-in method

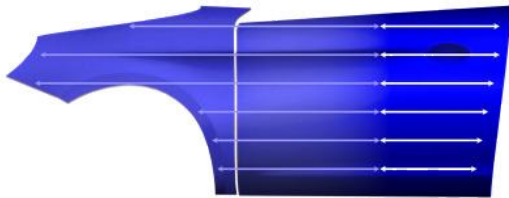


Adjacent panel: sand panel with suitable abrasive e.g. Trizact – P1000.
New part / repair: sand filler (minimum P500).

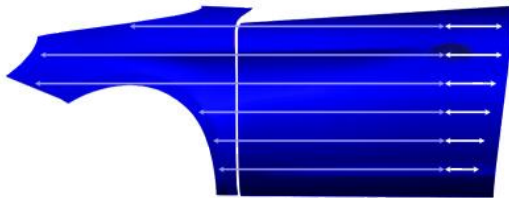


Apply the DX5136/DX34 (blender) in a 1/1 ratio and let dry.
Remarks: In hot & dry conditions the blender can be applied to the whole panel. Wet-on-wet is also possible. Use of blender is optional, it is applied to avoid:

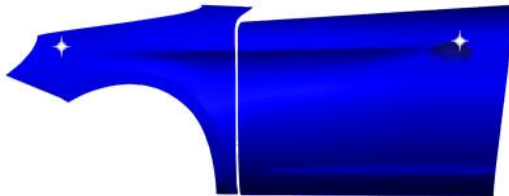
- Overspray particles in both solid and metallic and pearl colours.
- Dark halo in fade-out area of metallics and pearls.



Apply the BC to the widest area flash till flat.



Apply the 2nd coat inside 1st coat and extend further onto fender.
DO NOT extend beyond the 1st coat. – flash till flat



Apply Duxone Clearcoat to finish the repair.

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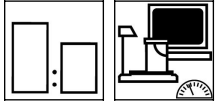
Products

Duxone Basecoat
Duxone Low Strength Tints

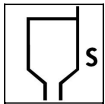
DX11 Pearl Additive
DX20 Activator Standard

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Product mix



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



DIN 4: 15 - 17 s at 20°C



10 - 20 µm



Clean after use with a suitable solventbased cleaning thinner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Duxone tints have to be thoroughly mixed before weigh-out and the Duxone colour has to be mixed immediately after weigh-out.
- For superior film properties, the addition of 10% DX20 Activator Standard is recommended.
- For Tri-stage colours we advise to activate the Ground coat with 10% DX20 Activator Standard.

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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.

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.