

DX1048

2K VOC CLEAR

Description

2-component, VOC compliant clear. Suitable in various application conditions.
Composition based on acrylic polyurethane copolymer.

Products

DX1048	2K VOC Clear
DX1020	HS Activator Standard
DX1024	HS Activator Fast

Properties

- Has excellent mar, chemical and weather resistance and gives a long lasting high gloss finish.
- Has excellent polishability.
- Can be used for spot, panel and overall repair.
- VOC compliant, conform with directive 2004/42/EC.









Substrates

- DUXONE® Basecoat.
- All cleaned and sanded OEM finishes (not recommended on thermoplastic acrylic finishes).

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PRODUCT PREPARATION

 	Mixing ratio		Fast		Standard		
			Volume	Weight	Volume	Weight	
		DX1048	2	100	2	100	
		DX1020	-	-	1	50	
		DX1024	1	50	-	-	
	VOC (2004/42/EC)	DX1020 DX1024	420 g/l				
	Pot life at 20°C	DX1020 DX1024	55 min				
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	21-23 s 22-24 s 24-27 s				
	Spray equipment		Fluid tip (mm)	Distance (cm)	Pressure (bar)		
		Compliant guns					
		Gravity feed	1.2-1.4	10-15	According to supplier's specifications		
		Suction feed	1.5-1.6	10-15			
		Pressure feed	1.0-1.2	10-15			
		Conventional guns					
Gravity feed	1.4-1.6	15-20	3-4				
Suction feed	1.6-1.8	15-20	3-4				
Pressure feed	1.0-1.2	15-20	3-4				
	Number of coats	2					
	Flash time	5 min between coats 5 -10 min before bake					
	DFT	60-70 micron					
	Drying		DX1024		DX1020		
			20°C	20 min x 60°C	20°C	25 min x 60°C	
		Dust-free	1 hr	imm.	2hr	imm.	
		Dry to handle	6 hr	30 min	8 hr	30 min	
Tape-free	O.N.	1hr 30 min	O.N.	1 hr 30 min			
	IR drying *	Flash time Distance Half power Full power	5 min 80 cm 5 min 15-20 min		* Guideline for short/medium wave IR equipment.		

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RECOMMENDED USE

Clearcoat application

When the DUXONE® Basecoat is completely flat, apply DX1048 in 2 coats with 5 min flash between coats.

Chemical resistance

When fully cured, DX1048 is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20%	battery acid
sulphuric acid	25%	toluene
hydrochloric acid	20%	xylene
phosphoric acid	20%	glycol
ammonia	10%	brake fluid, petrol

Equipment cleaning

Use a correct solventborne gunwash.

Recoatability

At any time after tape-free time. After 24 hr, scuff sanding is required.

Remarks

- DX1024 is recommended for spot/panel repair only.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Activated material should not be returned to original can of non-activated material.
- Material has to be at room temperature (18-25°C) before use.

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Product data

Package viscosity:	250 cp
Theoretical coverage:	7.8 m ² /l at recommended DFT - ready-to-spray
Directive 2004/42/EC:	The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Safety

Consult the Safety Data Sheet prior to use.
Observe the precautionary notices displayed on the container.

All other products referred to in the paint system build-up are from Duxone®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Duxone®, unless explicitly indicated otherwise.

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This Technical Data Sheet supersedes all previous issues.