

DUXONE® 2K TOPCOAT

2K ACRYLIC TOPCOAT



Description

2-component topcoat system for solid colours for use on cars, buses and trucks.
Composition based on acrylic copolymer.

Products

DX9...	DUXONE® 2K Topcoat Tints
DX0...	DUXONE® Tints
DX18	Activator Slow
DX20	Activator Standard
DX24	Activator Extra Fast
DX32	Thinner Fast
DX34	Standard Thinner
DX36	Thinner Slow

Properties

- DUXONE® 2K Topcoat is a very fast drying 2K acrylic topcoat with superior polishability, perfect gloss retention, high weather and chemical resistance.
- Gives excellent appearance, very good hiding and low consumption.
- Can be used for spot, panel and overall repair.


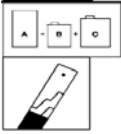
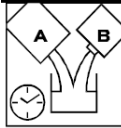
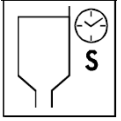





Substrates

- All OEM finishes, DUXONE® Primer-Surfacers and DUXONE® Surfacers.
- All cleaned and sanded old finishes.

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PRODUCT PREPARATION

	DUXONE® Colour Tools	See colour formula on DUXONE® colour CD					
	Mixing ratio		Very Slow	Slow	Standard	Very Fast	
		2K Topcoat DX18 DX20 DX24 DX32 DX34 DX36	2 1 - - - - 0.3	2 1 - - - 0.3 -	2 - 1 - 0.3 - -	2 - - 1 0.3 - -	
	Pot life at 20°C	DX18 DX20 DX24	5-6 hr 5 hr 30 min				
	Spray DIN 4 viscosity FORD 4 at 20°C	DIN 4 FORD 4 AFNOR 4	17-19 s 17-19 s 19-21 s				
	Spray equipment		Fluid tip (mm)	Distance (cm)	Pressure (bar)		
		Compliant guns					
		Gravity feed	1.3-1.5	10-15	According to supplier's specifications		
		Suction feed	1.5-1.8	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	5-15 min between coats or wet-in-wet. 10 min before bake.					
	DFT	40-60 µ					
	Drying		15°C	20°C	30°C	30 min x 60°C	
		Dust-free	1 hr	40 min	20 min	imm.	
		Dry to handle	6 hr	4 hr	2 hr 30 min	imm.	
	Tape-free	O.N.	O.N.	6 hr	imm.		
	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

Surface preparation

1. Clean surface with water and soap. Rinse and dry.
2. Degrease. Wipe dry with a clean cloth.
3. Repair according to damage.
4. Sand surface:
 - a. mechanical P320 - P400 (finally with P500 will give best results);
 - b. wet P800 - P1000.
5. Remove all traces of sanding dust, blowing oil-free compressed air.
6. Degrease. Wipe dry with a clean cloth.
7. Tack rag.

Topcoat application

On well prepared surface, apply 2 full coats with 5-15 min flash between coats.

Chemical resistance

When fully cured, DUXONE® 2K Topcoat is resistant to short exposures of the chemicals as listed:

sodium hydroxide	10 %	battery acid
sulphuric acid	20 %	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.

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Remarks

- DUXONE® 2K Topcoat tints have to be thoroughly mixed before use.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

Product data

Theoretical coverage: 6-8 m²/l at recommended DFT - ready-to-spray

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.