

# DX64G

## 2K SURFACER



### Description

2K high solids chromate-free sanding surfacer:  
Colour: DX64G: grey  
Composition based on functional acrylic copolymer.

### Products

DX64G	2K Surfacers
DX24	Activator Extra Fast
DX20	Activator Standard
DX18	Activator Slow
DX32	Thinner Fast
DX34	Thinner Standard
DX36	Thinner Slow

### Properties

- Easy to apply, smooth flow.
- Excellent vertical stability.
- High filling power and easy to sand.
- Outstanding isolation properties and perfect topcoat hold-out.
- Excellent adhesion.
- Can be overcoated with Solvent Basecoat & 2K Topcoats.

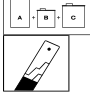







### Substrates

- OEM finishes.
- Cured repair finishes.
- Sanded putties.
- Primed steel, primed zinc galvanised steel and primed aluminium.
- DUXONE® 1K Primer-Surfacer DX61.

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### PRODUCT PREPARATION

	<b>Mixing ratio</b>		<b>Spot &amp; Panel repair (DX24&amp;DX20)</b>		<b>High temperature/ large surface (DX18)</b>	
		DX64G DX24/DX20 DX18 DX32/34/36	Volume 4 1 - 0-10 %	Weight 100 15 - 0-6	Volume 4 - 1 0-10 %	Weight 100 - 15 0-6
	<b>VOC (2004/42/EC)</b>	515 g/l				
	<b>Pot life at 20°C</b>	45 min - 1 hr 30 min. Depending on the activator used.				
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	20-25 s			
	<b>Spray equipment</b>	<b>Sanding surfacer</b>				
			<b>Fluid tip (mm)</b>	<b>Distance (cm)</b>	<b>Pressure (bar)</b>	
		Compliant	1.6-1.8	15-20	2 bar or according to suppliers specifications	
		HVLP	1.6-1.9	15-20	2 bar or according to suppliers specifications	
	<b>Number of coats</b>	1-3				
	<b>Flash time</b>	Between coats till flat. 10 min before bake.				
	<b>DFT</b>	80-200 μ				
	<b>Dry to sand</b>		<b>DX20</b>	<b>DX24</b>	<b>DX18</b>	
		at 15°C	O.N.	6 - 8 hr	O.N.	
		at 20°C	4 hr	3 hr	6 hr	
		at 40°C	40 min	30 min	1 hr	
		at 60°C	30 min	20 min	40min	
	<b>IR drying*</b>	Distance Half power Full power	80 cm 5 min 15-20 min	* Guideline for short/medium wave IR equipment.		

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### RECOMMENDED USE

#### Surface preparation

- Before applying DX64G, clean the surface, sand and degrease properly.
- Treat bare metal spots with 1 coat of wash primer or DUXONE® 1K Primer Filler DX61.

#### Equipment cleaning

Use a correct solventborne gunwash.

#### Remarks

- Do not use activated DX64G beyond the pot life nor reduce it further to get viscosity down again.
- If DX64G is applied over thermoplastic acrylic finishes, complete panel or overall car has to be treated. Spot repairing or sand throughs of the filler can result in spot marking or lifting when applying a basecoat.
- For high film build demand, it is recommended to use 3:1 mixing ratio with DX18 activator.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- 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

Package viscosity:	2500-3000 cp (at 5 rpm)
	900-1200 cp (at 20 rpm)
Theoretical coverage:	9.6 m <sup>2</sup> /l at 50 μ DFT - ready-to-spray

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### Safety

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

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